

GLOBAL SEAMLESS TUBES & PIPES PVT. LTD (INDIA)

MILL TEST CERTIFICATE

CERTIFICATE ACCORDING TO IS 10204 : 2012

PURCHASER NAME :		PO-43472 (PO-28.894)		TEST CERTIFICATE No.:		GSTP/2291/OSI/2023										
PURCHASER ORDER No. :		GSTPL/NO/EXP/5624		TEST CERTIFICATE Date :		18.02.2023										
WORK ORDER No. :		GSTPL/NO/EXP/5624		INVOICE No.:												
NAME OF PRODUCT :		CARBON STEEL SEAMLESS PIPES		INVOICE Date :												
PROCESS OF PIPE/TUBE MANUFACTURE :		CARBON STEEL COLD DRAWN SEAMLESS PIPES														
STEEL MANUFACTURED BY (MELT & POUR):		RASHTRIYA ISPAT NIGAM LIMITED, INDIA(FOR SL NO 5)														
		BHUSHAN POWER & STEEL LIMITED, INDIA (FOR SL NO 3, 6 & 7)														
STEEL MAKING METHOD :		BOF-LF/TRUT-CCM-ROUND METHOD, Fully Killed		Approved QAP No.:		GSTPL/QC/0157/2020-21 Rev.00 DT-03.01.2023										
SPECIFICATION & GRADE :		ASTM A53 B / ASME SA 53-B / SA 106 B, EDD. - 2019 / 2012, NACE MR-0175 & MR-0103 EDD.- 2015 / 2012														
PO Sr. No.	GSTPL REF. HEAT NO.	SUPPLIER HEAT NO.	SIZE (Inch)				Quantity				General					
			OD	X WT	X LENGTH		Nos.	Mtrs.	FEET	MT.	End Condition	Coating				
3	BG0974	22D4336	1 1/2"	X 0.1470"	X 21.000'	1141	7303.54	23961.00	11.330	Plain End	Black Paint					
5	BG1056	22D04554	3/4"	X 0.1540"	X 21.000'	1706	10920.11	35826.00	23.040	Bevel End						
5	BG1049	22E02367	3/4"	X 0.1540"	X 21.000'	854	5466.45	17834.00	11.530	Bevel End						
6	BG0974	22D4336	1"	X 0.1330"	X 21.000'	1497	9582.30	31477.00	23.030	Bevel End						
7	BG0974	22D4336	1"	X 0.1390"	X 21.000'	1158	7412.36	24318.00	23.030	Bevel End						
CHEMICAL COMPOSITION (%)																
PO Sr. No.	HEAT NO.	REQUIRED	MIN	MAX	%C	%Mn	%S	%P	%SI	%Cr		%Cu	%Mo	%Ni	%V	%CE
											0.30					
3	22D4336	L1/A	0.184	0.720	0.010	0.009	0.130	0.032	0.001	0.002	0.004	0.001	0.001	0.001	0.320	
3	BG0974	P1/A	0.185	0.712	0.008	0.012	0.125	0.033	0.001	0.002	0.004	0.003	0.003	0.003	0.322	
5	22D04554	L2/A	0.168	0.630	0.004	0.018	0.110	0.010	0.001	0.001	0.001	0.001	0.001	0.001	0.274	
5	BG1056	P2/A	0.170	0.639	0.005	0.016	0.131	0.013	0.008	0.001	0.009	0.005	0.005	0.281		
5	22E02367	L3/A	0.185	0.640	0.007	0.019	0.120	0.010	0.001	0.001	0.001	0.001	0.001	0.274		
5	BG1049	P3/A	0.185	0.682	0.006	0.017	0.132	0.012	0.007	0.001	0.009	0.005	0.005	0.283		
6	22D4336	L4/A	0.194	0.720	0.010	0.008	0.130	0.032	0.001	0.002	0.004	0.001	0.001	0.320		
6	BG0974	P4/A	0.198	0.713	0.008	0.013	0.128	0.020	0.001	0.002	0.004	0.003	0.003	0.320		
7	BG0974	P5/A	0.188	0.713	0.008	0.018	0.128	0.028	0.001	0.002	0.005	0.004	0.004	0.324		
MECHANICAL PROPERTIES																
PO Sr. No.	HEAT NO	REQUIRED	TENSILE STRENGTH (MPa)	YIELD STRENGTH (MPa)	ELONGATION (%)	HARDNESS (HRB)	IMPACT TEST	FLATTENING TEST	FLARING TEST	Bend Test at 90°						
											415	240	30.00	88 HRBW (Max)	-	-
3	BG0974		444.95	285.68	53.12	71-72	N/A	N/A	N/A	Satisfactory						
5	BG1056		453.37	280.84	50.65	71-73	N/A	N/A	N/A	Satisfactory						
5	BG1049		455.10	285.68	47.78	73-75	N/A	N/A	N/A	Satisfactory						
6	BG0974		500.36	360.75	42.65	75-77	N/A	N/A	N/A	Satisfactory						
7	BG0974		477.65	317.56	48.15	73-75	N/A	N/A	N/A	Satisfactory						
NON-DESTRUCTIVE TEST																
PO Sr. No.	HEAT NO	HYDRO-STATIC TEST as per SAEJ487 (100%)	E.C.T. as per ASTM E-309 (100%)	U.T. AS PER ASTM E-312 (100%)	SURFACE QUALITY		DIMENSION TOLERANCE as per Specification									
					IN SIDE	OUT SIDE										
3	BG0974	2500 PSI, duration of 5 Sec. Satisfactory	Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory									
5	BG1056		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory									
5	BG1049		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory									
6	BG0974		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory									
7	BG0974		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory									
Heat Treatment : Heat Treated Above 650°C (1200°F)																
MARKING : GSTP/LOGO/CDS/ASTM A53 B/ASME SA53-B/106B/EDD.../H. NO..../HYD. 2500 PSI/NDE/NACE MR0175 MR0103/MADE IN INDIA																
REMARKS : Legend: 1. L1/A= Lade Analysts One, P1/A= Product Analysts One, 2. L2/A= Lade Analysts Two, P2/A= Product Analysts Two, 3. L3/A= Lade Analysts Three, P3/A= Product Analysts Three, 4. L4/A= Lade Analysts Four, P4/A= Product Analysts Four, P5/A= Product Analysts Five, 5. N/A= Not Applicable.																
1. 100% Tubes Visual Surface Finish & Visual Dimensional Inspection Carried Out By "GSTPL" & 10% Qty. Witnessed by "BVIPL" Surveyor - Found Satisfactory.																
2. Mechanical Tests Carried Out By "GSTPL" & Witnessed by "BVIPL" Surveyor - Found Satisfactory.																
3. Chemical Tests Carried Out By "GSTPL" & Report Reviewed by "BVIPL" Surveyor - Found Satisfactory.																
4. 100% Hydrostatic Test Carried Out By "GSTPL" & 10% Qty. Witnessed by "BVIPL" Surveyor - Found Satisfactory.																
5. 100% Eddy Current Test Carried Out By "GSTPL" & Report Reviewed by "BVIPL" Surveyor - Found Satisfactory.																
6. Single Hard Stamp on Each Bundle Metal Tag as 'V' & Double Hard Stamp on 10% Witnessed Qty. Metal Bundle Tag as 'V' & 'J' by "BVIPL" for Identification.																
We hereby certify that the material herein described has been Manufacture Sample tested & Inspected in accordance with above standard & specification & satisfy the requirement.																
For, GLOBAL SEAMLESS TUBES & PIPES PVT. LTD. (INDIA)																
Sr. ENGINEER (QA/QC)		BUREAU VERITAS SURVEYOR (SIGN)				MANAGER (QA/QC)										

DOC. No: GSTP/NO/MTC, Issue Date: 01.04.2019, Issue No. - 01, Rev. No. - 00

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ALL MATERIALS ARE FREE FROM MERCURY

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WE DO NOT ENCOURAGE ANY CHINESE SUBSTRATE