

GLOBAL SEAMLESS TUBES & PIPES PVT. LTD (INDIA)

GLOBAL SEAMLESS														
MILL TEST CERTIFICATE														
CERTIFICATE ACCORDING TO EN 10204 : 3.3														
PURCHASER NAME :			PO-43472 (PO-28.694)				TEST CERTIFICATE No.:			GSTP/2291/OSI/2023				
PURCHASER ORDER No. :			GSTPL/WO/EXP/5624				Date :			08.11.2022				
WORK ORDER No. :			Date :				TEST CERTIFICATE Date :			14.11.2022				
NAME OF PRODUCT :			CARBON STEEL SEAMLESS PIPES				INVOICE NO:							
PROCESS OF PIPE/TUBE MANUFACTURE :			CARBON STEEL COLD DRAWN SEAMLESS PIPES				INVOICE Date :							
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/0187/2020-21 Rev.00 DT-03.03.2021				
SPECIFICATION & GRADE :			ASTM A53 B / ASME SA 53-B / SA 106 B, EDD. - 2019 / 2021, 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		No.	Mtr.	FLIT	WT.	End Condition	Coating				
3	BG0974	22D4336	1 1/2" X 0.1470" X 21.000"		1141	7303.94	22961.00	11.330	Plain End	Black Paint				
5	RG1056	22D04354	3/4" X 0.1540" X 21.000"		1706	10920.11	35826.00	23.040	Bevel End					
5	RG1049	22E02367	3/4" X 0.1540" X 21.000"		854	5466.45	17934.00	11.530						
6	BG0974	22D4336	1" X 0.1330" X 21.000"		1497	9582.30	31437.00	23.020						
7	BG0974	22D4336	1" X 0.1790" X 21.000"		1159	7412.36	24318.00	23.030						
CHEMICAL COMPOSITION (%)														
PO Sr. No.	HEAT NO.	REQUIRED	%C	%Mn	%S	%P	%SI	%Cr			%Cu	%Mo	%Ni	%V
			Max	0.30	1.06	0.035	0.035	-		0.400	0.400	0.150	0.400	0.080
		Min	-	0.29	-	-	-	0.100	-	-	-	-	-	
3	22D4336	L1/A	0.194	0.720	0.010	0.009	0.130	0.032	0.001	0.002	0.004	0.001	0.320	
	BG0974	P1/A	0.185	0.712	0.008	0.012	0.125	0.033	0.001	0.002	0.004	0.003	0.322	
	22D04354	L2/A	0.166	0.630	0.004	0.018	0.110	0.010	0.001	0.001	0.001	0.001	0.274	
5	RG1056	P2/A	0.170	0.638	0.005	0.018	0.131	0.013	0.008	0.001	0.009	0.003	0.281	
	22E02367	L3/A	0.185	0.640	0.007	0.019	0.120	0.010	0.001	0.001	0.001	0.001	0.274	
	RG1049	P3/A	0.188	0.682	0.008	0.017	0.132	0.012	0.007	0.001	0.009	0.003	0.283	
6	22D4336	L4/A	0.194	0.720	0.010	0.009	0.130	0.032	0.001	0.002	0.004	0.001	0.320	
	BG0974	P4/A	0.196	0.713	0.008	0.013	0.128	0.020	0.001	0.002	0.004	0.003	0.320	
	BG0974	P5/A	0.198	0.713	0.008	0.015	0.126	0.028	0.001	0.002	0.005	0.004	0.324	
MECHANICAL PROPERTIES														
PO Sr. No.	HEAT NO	REQUIRED	TENSILE STRENGTH (MPa)	YIELD STRENGTH (MPa)	ELONGATION (%)	HARDNESS (HRBW)	IMPACT TEST	FLATTENING TEST	FLARING TEST	Bend Test at 90°				
			G.L. = 50 mm & Pipe Tested On Full Section											
		Min	-	-	-	-	89 HRBW (Max)	-	-	-				
		Max	415	240	30.00	-	-	-	-	-				
3	BG0974		444.95	298.58	53.12	71 - 72	N/A	N/A	N/A	Satisfactory				
5	RG1056		453.37	280.84	50.65	71 - 73	N/A	N/A	N/A	Satisfactory				
5	RG1049		455.10	285.88	47.75	73 - 75	N/A	N/A	N/A	Satisfactory				
6	BG0974		500.38	360.75	42.58	75 - 77	N/A	N/A	N/A	Satisfactory				
7	BG0974		477.85	317.50	48.18	73 - 75	N/A	N/A	N/A	Satisfactory				
NON-DESTRUCTIVE TEST														
PO Sr. No.	HEAT NO	HYDRO-STATIC TEST as per EN 10204 (100%)	E.C.T. as per ASTM E-309 (100%)		U.T. AS PER ASTM E-813 (100%)		SURFACE QUALITY		DIMENSION TOLERANCE as per Specification					
			2500 PSI, duration of 5 Sec. Satisfactory	Satisfactory	N/A	N/A	Satisfactory	Satisfactory		Satisfactory				
3	BG0974		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory	Satisfactory	Satisfactory					
5	RG1056		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory	Satisfactory	Satisfactory					
5	RG1049		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory	Satisfactory	Satisfactory					
6	BG0974		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory	Satisfactory	Satisfactory					
7	BG0974		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory	Satisfactory	Satisfactory					
Heat Treatment : Heat Treated Above 650°C (1200°F)														
MARKING : GSTP/LOGO/CDS/ASTM A53 B/ASME SA53-B/1068/ST2E..../H. NO..../HYD. 2500 PSI/NDE/NACE MR0175 MR0103/MADE IN INDIA														
REMARKS : Legend: 1. L1/A= Ladle Analysis One, P1/A= Product Analysis One, 2. L2/A= Ladle Analysis Two, P2/A= Product Analysis Two, 3. L3/A= Ladle Analysis Three, P3/A= Product Analysis Three, 4. L4/A= Ladle Analysis Four, P4/A= Product Analysis Four, P5/A= Product Analysis Five, S. 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)							

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CORPORATE OFFICE : Plot-Y9, 3rd Floor, EP Block, Setor-V, Salt Lake City, Bidhannagar, Kolkata - 700 091

REGD. OFF : Plot-Y9, 3rd Floor, EP Block, Setor-V, Salt Lake City, Bidhannagar, Kolkata - 700 091

Mob : +91 9051134600 CIN-U29299WB2019PTC231524

ALL MATERIALS ARE FREE FROM MERCURY

Web : www.globalseamless.com EMAIL : sales@globalseamless.com

WE DO NOT ENCOURAGE ANY CHINESE SUBSTRATE