



MILL TEST CERTIFICATE
(EN 10204:2004 TYPE 3.1)

Format No.: AIS/QC/FR-16
Rev. No.: 01
Effective Date : 01.08.2021

Customer / Client:
Project:
P.O. NO: 25.106
Pipe Manufacturer & Location: AI STEEL TUBES & PIPES INDUSTRIES LLC
Specification & Grade: ASTM A53-2022, Grade, A (SCH40)
Product Type: ERW Welded Carbon Black Painted Plain End Steel Pipes

Certificate No.: AI/TC/24-06-033, Rev.00
Dated: 10.06.2024
Steel Making Process: Basic-Oxygen
Country of Melt and Pour: Sr # 1. Posco Korea/Sr. # 2. Isw India

PRODUCT/HEAT ANALYSIS

Sr.No	Product Dimensions	Type of Pipe	No. of pcs	Heat No.	C%	Mn%	P%	S%	V%	Cr%	Ni%	Co%	Mo%	Co+Ni+Cr+Mo+V%	REMARKS
				Maximum Requirement	0.250	0.95	0.050	0.045	0.080	0.400	0.400	0.400	0.150	1.0	
1	1-1/4" X 0.140" X 21'	BPE	5838	34200814	0.140	0.490	0.014	0.011	0.001	0.020	0.010	0.030	0.007	0.07	P/A
2	1-1/2" X 0.145" X 21'		396	G42967	0.152	0.750	0.016	0.004	0.001	0.012	0.015	0.024	0.002	0.05	P/A

MECHANICAL TESTS

Sr.No	Heat No.	Tensile Test Values			(e) Flattening Test	Bend Test	Eddy Current	Hydro Test Pressure In (psi)	GALVANIZING		(c) Pipe Ends	(f) V.D.I
		Y.S. (Mpa)	U.T.S. (Mpa)	EL%					AVG ZN COATING Gms/m	ADHESION TEST		
	Minimum Requirement	215	310									
1	34200814	350	462	34	Satisfactory	Satisfactory	Satisfactory	1200	-	-	Satisfactory	Satisfactory
2	G42967	375	480	29	Satisfactory	Satisfactory	Satisfactory	1200	-	-	Satisfactory	Satisfactory

Note - 1
(a) Elongation % = As per ASTM A53 Table X4.1 & X4.2, (b) Outside Dia = ± 1% of Specified OD, (c) Pipe Ends = Plain End otherwise specified (d) Wall Thickness = +12.5 % & minimum as per Table X2.4, (e) Flattening Test: No cracks or breaks on the inside or outside surface at weld and unsond material or of incomplete weld that is revealed by the flattening test shall be cause for rejection (f) V.D.I. - Visual & Dimension Inspection, As per ASTM A 53, CL.12.0, (g) Hydrostatic Test pressure = As per ASTM A 53 Table X2.3, Holding Time = 5 Second, (h) Heat Treatment = Heat Treated after welding to a minimum of 540 °C so that no untempered martensite remains, (i) Nondestructive Test = As per ASTM A 53, CL.9.0 (j) Y.S. = Yield Strength, U.T.S = Ultimate Tensile Strength, El = Elongation, P/A = Product Analysis

It is certified that pipes listed in this certificate are manufactured, Examined, Tested and comply according ASTM A53, Grade, A - SCH40 and all test results found acceptable.

