




Vallourec Deutschland GmbH (A01) Werk Rath-Stopfen Rather Kreuzweg 106 40472 Düsseldorf		INSPECTION CERTIFICATE (A02) 3.1 EN 10204:2004
		No. : 49933RS14 (A03) Page: 1 / 4 Date: 14.01.2014

(A01) Vallourec Deutschland GmbH	(A08.1) Vallourec-Order-No. 85208306
(A06.1) Customer SIDERPIGHI S.P.A. CON SOCIO UNICO VIA EMILIA PARMENSE 15 I-29010 PONTENURE (PIACENZA)	(A08.2) Suborder
(A06.2) Orderer SIDERPIGHI S.P.A. / CON SOCIO UNICO	(A07.2) Order-No. 13000157 Date 24.09.2013
(B01, B02, B04) Description of the product	HOT FINISHED SEAMLESS STEEL TUBES TOLERANCES ACC. TO EN 10210-2:2006 ENDS PLAIN, SQUARE CUT, DEBURRED INSIDE AND OUTSIDE WITHOUT RUST PROTECTION TUBES LOOSE PO-NO. ORDERER'S CLIENT VALIT 20130451 EN 10210-1:2006 EN 10297-1:2003 S355J2H/E355+AR
(A14)  0769-CPD-078001-1	

(A13) Vallourec Item	(A09) Cust. Item	(B14) Item text	(B09) Dimensions	(B10) Single length
42			O.D. 394 MM X WTH. 16 MM	IN RANDOM MILL LENGTH 10000 - 12000 MM

(A13) Vallourec Item	(A09) Cust. Item	(B08) Quantity	(B11) Total length m	(B13) Weight kg
42		9	103,35	15.906

HI-TECH METAL DI GABBANELLI MICHELE VOSTRO ORDINE MAIL DEL 20.10.2014
N°. 1 BARRA, 1790 KG, COLATA 245438
NOSTRO DDT N. 173 DEL 22/01/2014

Vallourec Deutschland GmbH (A01) Werk Rath-Stopfen Rather Kreuzweg 106 40472 Düsseldorf		INSPECTION CERTIFICATE (A02) 3.1 EN 10204:2004
		No. : 49933RS14 (A03) Page: 2 / 4 Date: 14.01.2014

Vallourec Item	Delivery Note-No	Packing list-No
42	77792	

(C71)

HEAT CHEMICAL ANALYSIS

(B07.1) Heat	(B15) Process	C %	Si %	Mn %	P %	S %	Al %	Cu %	Cr %	Ni %	Mo %
min	-	-	-	-	-	-	-	-	-	-	-
max	-	0.180	0.550	1.60	0.030	0.0300	0.100	0.400	0.300	0.300	0.080
245438	Oxygen (BOF)	0.130	0.200	1.39	0.019	0.0009	0.037	0.020	0.070	0.030	0.010


(B07.1) Heat	V %	Ti %	Nb/Cb %	N %	B %	CQ 03 %					
min	-	-	-	-	-	-					
max	0.100	0.050	0.060	-	0.0008	.45					
245438	0.090	0.006	0.001	0.0135	0.0004	.40					

CQ 03 $CEV/CE = C + Mn/6 + (Cr+Mo+V)/5 + (Ni+Cu)/15$

Heats fully killed

TENSILE TEST RESULTS

Type (C10.1)	TUBE STRIP TEST SPECIMEN
Test temperature (C03)	ROOM TEMPERATURE
Direction (C02)	longitudinal

Vallourec Deutschland GmbH (A01) Werk Rath-Stopfen Rather Kreuzweg 106 40472 Düsseldorf		INSPECTION CERTIFICATE (A02) 3.1 EN 10204:2004
		No. : 49933RS14 (A03) Page: 3 / 4 Date: 14.01.2014

TENSILE TEST RESULTS

(B07.1) Heat	(C00.1) Test Piece	(C10) Dimension	(C11) YS	(C12) TS	(C13) Elong.	(C14.1) Ratio				
		mm	ReH MPa	R _m MPa	5,65√S ₀ %	R/R _m -				
min		-	355	490	22.0	-				
max		-	-	630	-	-				
245438	3289	25.05X17.14	391	540	27.0	0.72				

IMPACT TEST RESULTS

Type (C40)	Charpy-V
Test temperature (C03)	- 20 DEGREES C
Direction (C02)	longitudinal

(B07.1) Heat	(C00.1) Test Piece	(C41)	(C42.1) Impact1	(C42.1) Impact2	(C42.1) Impact3	(C43.3) Mean				
		qcm	J	J	J	J				
min		-	19.0	19.0	19.0	27.0				
max		-	-	-	-	-				
245438	3289	0.800	130	112	71,0	104				

(D55)

OTHER TESTS ON PIPE

Test	Conditions	Test rate	Result
HEAT TREATMENT	NORMALIZED FINISH-ROLLED >850 DEGREES C/AIR		
TIGHTNESS TEST WITH FLUX LEAKAGE TEST	EN 10246-1: 1996	EACH PIPE/TUBE	SATISFACTORY
APPEARANCE AND DIMENSIONS (D01)		EACH PIPE/ TUBE	SATISFACTORY

(A04, B06)

MARKING, IDENTIFICATION

42	 VALLOUREC	PAINT STENCILED ON ONE SIDE PIPE NO. (TALLY-NR.) CONTINUOUSLY PAINT STENCILED VALLOUREC LOGO MANUFACTURER'S NAME MANUFACTURER'S MARK TERMS OF DELIVERY EN 10210-1/EN 10297-1 S355J2H/E355 394 X 16 HEAT-NO. WA 85208306 V&M ITEM-NO 42
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Warning Notice: The Vallourec Group is currently changing its markings on tubes/pipes and on associated documentation.


For technical reasons, please be informed that the manufacturer's references marked on the products (logo and/or company name) may temporarily diverge from the contractual documents (until June 2014).

(Z01)

Vallourec Deutschland GmbH (A01) Werk Rath-Stopfen Rathar Kreuzweg 106 40472 Düsseldorf		INSPECTION CERTIFICATE (A02) 3.1 EN 10204:2004 No. : 49933RS14 (A03) Page: 4 / 4 Date: 14.01.2014
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The supplied products are in compliance with the requirements of the order

(A05, Z02, Z03)

Date	14.01.2014
Validated by	Inspection Representative
	DOGAN 
☎	+49(0)21 19603852
☎	+49(0)21 19602216
@	CERTIFICATES-RS- PLUG@VALLOUREC.COM
Stamp	

Indication in parentheses correspond to attributes according to EN 10168

This testimonial and certification respectively may neither be modified nor used for other products. Offences are regarded as falsification of documents and will be subject to criminal prosecution.

V&M DEUTSCHLAND GmbH (A1) Werk Rath-Stopfen Rather Kreuzweg 10B 40472 Dusseldorf	 VALLOUREC & MANNESMANN TUBES Vallourec Group	INSPECTION CERTIFICATE (A2) 3.1 EN 10204 2014
		No. 26539RS12 (A3) Page 1 / 3 Date: 03.05.2012

(A01) V&M DEUTSCHLAND GmbH	(A26.1) V&M-Order-No. 85290370
(A06.1) Customer: SICAM S.P.A. VIA MARZIANA, 21 I-27020 PARONA LOMELLINA (PAVIA)	(A06.2) Orderer: SICAM S.P.A. / VIA MARZIANA, 21
(B01, B02, B04) Description of the product	(A27.2) Order-No. 111 Date 15.02.2012
HOT FINISHED SEAMLESS STEEL TUBES ENDS PLAIN, SQUARE CUT, DEBURRED INSIDE AND OUTSIDE WITHOUT RUST PROTECTION TUBES LOOSE PO-NO: ORDERER'S CLIENT VALIT 20120080 EN 10297-1 2003 E470 +AR	

(A13) V&M Item	(A09) Cust. Item	(B14) Item text	(B09) Dimensions	(B10) Single length
8			O.D. 305 MM X WTH. 14.2 MM	IN RANDOM MILL LENGTH: 10000 12000 MM

(A13) V&M Item	(A09) Cust. Item	(B08) Quantity	(B11) Total length m	(B13) Weight kg
8		9	103.45	10.701

V&M Item	Delivery Note-No	Packing list-No
8	37970	

(G71)

HEAT CHEMICAL ANALYSIS



QUESTO DOCUMENTO E' RIPRODOTTO MEDIANTE UN SISTEMA
 COMPUTERIZZATO ED E' CONFORME ALL'ORIGINALE.
 THIS DOCUMENT IS REPRODUCED BY A COMPUTERIZED SYSTEM
 AND IS CONFORM TO THE ORIGINAL.

Spett. HI-TECH METAL
 Certificato emesso il 22/01/2014 Fatt. n° 1195 del 22/01/2014
 Dimensioni : 305 x 14,2 1.186 KG Pezzi: 1 Colata/Entrata: 256926
 Vs.Rif. ord. n. 6

F. ZAMBRUNO Responsabile della Qualità

V&M DEUTSCHLAND GmbH (A01) Werk Rath-Strophen Rrather Kreuzweg 106 40472 Dusseldorf	 VALLOUREC & MANNESMANN TUBES Vallourec Group	INSPECTION CERTIFICATE (D10) 3.1 EN 10204 2.0.34
		No: 26539RS12 (A04) Page 2 / 3 Date: 03.05.2012

(C71)

HEAT CHEMICAL ANALYSIS

(B07.1) Heat	(B15) Process	C %	Si %	Mn %	P %	S %	Al %	V %	Nb/Cb %	N %
min	-	0.160	0.100	1.30	-	-	0.010	0.030	-	-
max	-	0.220	0.500	1.70	0.030	0.0350	-	0.150	0.070	0.0200
256926	Oxygen (BOF)	0.210	0.280	1.53	0.014	0.0250	0.030	0.130	0.035	0.0101

Heats fully killed

TENSILE TEST RESULTS

Type (C10.1)	TUBE STRIP TEST SPECIMEN
Test temperature (C08)	ROOM TEMPERATURE
Direction (C02)	longitudinal

(B07.1) Heat	(C00.1) Test Piece	(C16) Dimension mm	(C17) YS R _{0.2} MPa	(C18) TS R _m MPa	(C19) Elong. 5.65√S ₀ %	(C19.1) Ratio R _m /R _{0.2}
min	-	-	470	650	17.0	-
max	-	-	-	-	-	-
256926	6248	25.10X14.62	487	706	21.0	0.69


(D55)

OTHER TESTS ON PIPE

Test	Conditions	Test rate	Result
HEAT TREATMENT	HOT ROLLED		
TIGHTNESS TEST WITH FLUX LEAKAGE TEST	EN 10246-1: 1996	EACH PIPE/TUBE	SATISFACTORY
APPEARANCE AND DIMENSIONS (D01)		EACH PIPE/TUBE	SATISFACTORY

(A04, B06)

MARKING, IDENTIFICATION

B	 PAINT STENCILED ON ONE SIDE TUBE/PIPE LENGTH MM PIPE NO. (TALLY-NR.) CONTINUOUSLY PAINT STENCILED MANUFACTURER'S MARK MANUFACTURER'S NAME TERMS OF DELIVERY EN 10297-1 E470 305 X 14.2 HEAT-NO. WA 85290370 V&M ITEM-NO B FRONT FACE BOTH SIDES RED
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(Z01)

The supplied products are in compliance with the requirements of the order



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Spett. HI-TECH METAL
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 Dimensioni: 305 x 14,2 1,186 KG Pezzi: 1 Colata/Entrata: 256926
 Vs. Rif. crd. n. 6

F. ZAMBRUNO  Responsabile della Qualità

V&M DEUTSCHLAND GmbH Werk Rath-Slopfen Rathor Kreuzweg 106 40472 Düsseldorf	 VALLOUREC & MANNESMANN TUBES Vallorec Group	INSPECTION CERTIFICATE 3.1 EN 10204 2004 No. 26539RS12 Page 3 / 3 Date 03.05.2012
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(A05 202 200)

Date	03.05.2012
Validated by	Inspection Representative
	WARTEN 
☎	+49(0)21 9603954
☎	+49(0)21 9602216
@	CERTIFICATES-RS- PLUG@VMTUBES.DE
Stamp	


Indication in parentheses correspond to attributes according to EN 10146

This testimony and certification respectively may neither be modified nor used for other products. Offences are recorded as falsification of documents and will be subject to criminal prosecution.

sicam SPA

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Spett. HI-TECH METAL
Certificato emesso il 22/01/2014 Fatt. n° 1195 del 22/01/2014
Dimensioni : 305 x 14,2 1,186 KG Pezzi: 1 Colata/Entrata: 256926
Vs.Rif ord. n. 6

F. ZAMBRUNO  Responsabile della Qualità



ESW Röhrenwerke GmbH
 Auestraße 25, D-52249 Eschweiler
 Tel. 02403 / 792-181 Verkauf - 205 Qualitätsstelle
 Fax 02403 / 792-180 Verkauf - 270 Qualitätsstelle

Abnahmeprüfzeugnis / Inspection certificate / Certificat de réception EN 10204 3.1

Besteller / Purchaser / Acheteur Sicam Società Italiana Commercio Acciai e Metalli SPA Via P. Rondoni N.1 20146 Milano ITALIEN	DIN EN ISO 9001 von LRQA und TÜV Cert. DGRU/ PED 97/23/EG Art. 1, Abs 4.3. TÜV-Rheinland Industrie Service GmbH Kenn-Nr. 0035. OM-System nach EN 764- 5, Abs 4.2. und AD 2000-Merkblatt W0	ESW-Werks-Nr. / Our Order No. / N° Cde Usine 1110845 / 23 / 1 Bestell-Nr. / Purchase Order No. / N° Cde Acheteur 112 Zusatzangaben des Kunden
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Rev: 0

Erzeugnis / Product / Produit Schmelze / Heat No. / No coulée Stück / Quantity / Nombre Abmessung / Dimension / Dimensions Länge / Length / Longueur Maler / Meter / Mètre Masse / Mass / Masse	Nahtlose warmgewalzte Stahlrohre / Seamless hot rolled steel tubes / Tubes d'acier sans soudure laminés à chaud Stahlbezeichnung / Steel designation / Désignation de l'acier E470+AR Lieferzustand / Delivery condition / Etat de livraison
258958	
5	
219,1 x 40 mm	
5500-6500 mm	
29,14 m	
5197 kg	

Kennzeichnung / Marking / Marquage:
ESW EN 10297-1 E470 AS 258958 1110845/023 219,1 x 40

Prüfbedingungen / Technical requirements / Specifications techniques
DIN EN 10297-1/03

Geschäftsführer: AR-Vorsitzender: Amtsgericht Aachen	Dipl.-Betw. Herbert Lenzen Manfred Less HRB 11390 Ust. IdNr. DE 121 737 288	Telefon +49 2403 792-0 E-Mail info@esw-rohre.de www.esw-rohre.de	IBAN: DE123905 0007 0005 1006 82 SWIFT BIC: AACSDE33	Bankverbindung: Sparkasse Aachen Konto-Nr. 3 100 082 BLZ 390 500 00
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01.06.2012 Seite 1 v. 2



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SPA

Spett. HI-TECH METAL
 Certificato emesso il 22/01/2014 Fatt n° 1196 del 22/01/2014
 Dimensioni : 219,1 x 40 1.842 KG Pezzi: 2 Colata/Entrata: 258958
 Vs Rif. ord. n. 6

F. ZAMBARDINO Responsabile della Qualità

Beichtigung und Abmessung/ Visual & dimensional inspection/ Contrôle aspect et dimensions **O.B. / Ok / Satisfaisant**
 Vorwechslungsprüfung/ PMI/ Vérification de la nuance **O.B. / Ok / Satisfaisant**

Schmelze / Heat No / No coulée		Y = Basic oxygen steelmaking process									
258958		Erschmelzungsart / Melt practice / Mode d'elaboration									
C %	Si %	Mn %	P %	S %	Cu %	Cr %	Ni %	Mo %	V %	N %	Al %
0.173	0.35	1.57	0.011	0.023	0.07	0.220	0.100	0.03	0.110	0.005	0.026
Nb %	As %	Sn %	Ti %	Co %	Ca %	Zr %	B %	W %	Sb %	CEV %	J-Faktor
0.001	0.002	0.006	0.003	0.012	0.002		0.0003			0.518	

Zugversuch / Tensile testing / Essais de traction:		Probentyp/Type of specimen/Type d'éprouvette:				
Schmelzen Nr./ Cast no / N° de coulée	Reh / Test- strength/ Limite élastique [MPa]	Rm / Yield strength/ Limite élastique [MPa]	Zugfestigkeit/ Tensile strength [MPa]	Bruchdehnung/ Elongation/ Allongement [%]	Einschnürung/ Reduction of Area /Coeff. de striction %	Pt. Abrn / Specimen size/ Dim. d'éprouvette [mm]
258958	Reh 430	Rm 600	Rp 2"	A5 17	Z	
min						
max	477	654	26			25,50 x 13,3
						0,73
						Long

Straightness: 1,0-1000 mm

Es wird bestätigt daß die gelieferten Erzeugnisse den techn. Lieferbedingungen des Auftrages entsprechen. We certify that the supplied products comply with the order specification. Nous attestons que les produits délivrés correspondent aux conditions techniques de la commande. / Dieses Dokument wurde mittels EDV erstellt und ist ohne Unterschrift rechtsgültig. / This document was prepared by means of electronic data processing and is valid without signature. / Ce document a été rédigé automatiquement et est valide sans signature.

Eschweiler, den 01.06.2012

gez. Chouadi
 Der Abnahmebeauftragte
 Works Inspector
 L'expert d'usine

01.06.2012

Seite 2 v. 2

Spett. HI-TECH METAL
 Certificato emesso il 22/01/2014 Fatt. n° 1195 del 22/01/2014
 Dimensioni: 219,1 x 40 1,842 KG Pezzi: 2 Colata/Entrata: 258958
 Vs Rif. ord. n. 6

F. ZAMBARDINO Responsabile della Qualità

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Inspection certificate EN 10 204 - 3.1	A02	Issuing department Quality inspection	A05	Purchaser order no	A07	Our order no 161757-40	A08	Invoice no	A19	Certificate no and date 14586041 2013-12-03	A03
Purchaser SSAB Swedish Steel Spa DDT n°501078 del 03/12/13	A11	Product Abrasion resistant steel plate	B01	Marking (Stamping) Steel grade, Manufacturer, MATERIAL ID	B06	Standard/rules OX	B02	Steel grade HARDOX 450	B16	Internal code 20633	B07
		Quantity B08 1	Dimensions [mm] T 20 W 2000 L 6000	B09-B11 L 6000	B12	Deliv. Cond. Q	B04				
		Consignee Quadri Siderurgica Via Piave 42/46 Civitanova Marche (MC)	A06	Customer marks 6344	B15						
MATERIAL ID 108575-372693											

Chemical composition

Heat no 108575	C	Si	Mn	P	S	Cr	Ni	Mo	B	EW	C14
	.19	.49	1.37	.009	.002	.25	.06	.018	.001	.47	.340

C71-C92 Carbon equivalent: etc
CEV (EW) = C + Mn/6 + (Cr+Mo+V)/5 + (Ni+Cu)/15
C14 = CET = C + (Mn+Mo)/10 + (Cr+Cu)/20 + Ni/40

Test type	C04	Millicode	C00	Specimen position	C01	Direction	C02	Treatment	B05	Specimen type	C10	Temp [degr C]	C03	Test results
Hardness test (HBW)	714905			Tail end				Delivery condition						C32 Ave 441

CERTIFICATO VALIDO PER LA **HARDOX** SP. 20.000
 FORNITI ALLA DITTA **VITTEC**
 CON NS/DDT. N° **4406**
 COPIA CONFORME ALL'ORIGINALE
QUADRI UMBERTO SIDERURGICA S.p.A.

	It is hereby certified that the material described above complies with the requirements of the order.	Z02
This certificate is produced with EDP and valid without signature Quality Inspection Department / Ivarsson / H Brnning		Z01
		A04
HARDOX WEAR PLATE www.hardox.com		A22