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Type Inspection Certificate 3.1 EN 10204

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Number 10520599207 Issued On 16/10/2020

WELDING PROCESS QUALIFICATION: ALL THE LASER WELDING PROCESS ARE QUALIFIED ACCORDING EUROPEAN PRESSURE EQUIPMENT DIRECTIVE PED 97/23/EC BY THE NOTIFIED BODY N.1233 EUOPED WITH WELDING PROCEDURE QUALIFICATION WPQR N° PM0907A001 Registration no. 10M203 AND WPQR N° PM907A002 Registration no. 11M017. STILL VALID UNDER PED 2014/68/EU PER ARTICLE 48 CLAUSE 3.

Customer  
INVESTA SP. Z O.O.  
UL.ZASTAWNA 27  
83000 PRUSZCZ GDANSKI PL

Code: 000023130

Consignee  
Investa Sp. z o.o.  
Smolice 1g, Tulipan Park - Hal  
95010 Stryków PL

Delivery Nn 8355823376  
Of 16/10/2020  
Delivery note nr 1005011120

Quality Control  
Q.M.D./Q.M. S.Toscana  
Plant Of Forlì

Pages  
13/20

Material  
59004635

Test specification: EN 10217-7 TC1  
Stainless steel grade: TP 304L 1.4307/1.4301 X2CrNi18-9/X5CrNi18-10  
Tolerances: ISO 1127 D3-T3

Welding process  
LASER WELDING

Order Nr 1191262049/10 Client Order CZZ20C02297

Description  
TXT002 26,9x2,6x6000 TP304L LAS Z

Part Number Client Date 9/10/2020

Item	Identification Nr	Heat	Quantity MTL	Quantity KG	Quantity PZZ	Delivery conditions	Reworks
1	20K6002254	0536644	546	805	91	W0	BRUSHED

WE CERTIFY THAT THE ABOVE MENTIONED PRODUCTS COMPLY WITH THE TERMS OF ORDER CONTRACT AND THE STANDARDS RECALLED IN THE PRESENT TEST CERTIFICATE

Identification Nr	Chemical Type	C (%)	Si (%)	Mn (%)	P (%)	S (%)	N (%)	Cr (%)	Ni (%)
20K6002254	RAW MATERIAL	.027	.320	1.750	.0330	.0010	.0730	18.030	8.120

Identification Nr	Type of mechanical test	Rp 0.2 [MPa]	Rp 1.0 [MPa]	Rm [MPa]	A5 (%)
20K6002254	TUBE	399	439	649	43.2

MARCEGAGLIA SPECIALTIES FORLIMPOPOLI PLANT SYSTEM CERTIFICATIONS QUALITY SYSTEM CERTIFIED ACCORDING TO EN 9001:2015 AND IATF 16949:2016 AND ISO 3834-2:2005 AND A SAFETY SYSTEM CERTIFIED ACCORDING TO OHASAS 18001:2007 AND AN ENVIROMENTAL SYSTEM CERTIFIED ACCORDING TO ISO 14001:2015. MARCEGAGLIA SPECIALTIES FORLIMPOPOLI PRODUCT CERTIFICATIONS DVGW ACCORDING TO GW541 LASER AND TIG WELDED TUBES STAINLESS STEEL GRADE 1.4404 DIA FROM 15.00 TO 108.00MM AND GRADE 1.4521 FROM 15.00 TO 54.00MM. TUV AD2000 W2W10 AND PED ANNEX I, PARAGRAPH 4.3 LASER AND TIG WELDED TUBES STAINLESS STEEL GRADE 1.4301, 1.4306, 1.4307, 1.4401, 1.4404, 1.4541, 1.4571, 1.4435, 1.4436 THICKNESS FROM 0.80 TO 4.00MM AND DIAMETRS FROM 8.00 TO 283.00 MM. EHEDG FOR DAIRY TUBES TXT015. EUROPEAN DIRECTIVE 1935:2004 FOR DAIRY TUBES TXT003, TXT014, TXT015.

NON DESTRUCTIVE TESTS  
EDDY CURRENT TEST FOR THE VERIFICATION OF HYDRAULIC LEAKTIGHTNESS ACCORDING TO EN ISO 10893-1:2011: CONFORM  
EDDY CURRENT TEST FOR THE DETECTION OF IMPERFECTIONS ACCORDING TO EN ISO 10893-2:2011: CONFORM  
ANTIMIXING TEST: CONFORM  
VISUAL INSPECTION AND DIMENSIONAL CONTROLS: CONFORM

DESTRUCTIVE TESTS  
DRIFT EXPANDING TEST ACCORDING TO EN ISO 8493:2005: CONFORM  
FLATTENING TEST ACCORDING TO EN ISO 8492:2004: CONFORM  
RING EXPANDING TEST ACCORDING TO EN ISO 8495:2004: CONFORM  
TENSILE TEST ACCORDING TO EN ISO 6892-1:2009  
INTERGRANULAR CORROSION TEST ACCORDING TO EN ISO 3651-2:1998: CONFORM

Marking

Remarks:  
CHEMICAL COMPOSITION ACCORDING TO EN 10028-7 TUBE TO EN 10217-7 TC1 AND DIRECTIVE 2014/68/EU (PED), WELDING FACTOR V=1