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Type Inspection Certificate 3.1 EN 10204

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Number 10521368303

Issued On 11/05/2021

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 8355112636
Of 11/05/2021
Delivery note nr 1005006177

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

Pages
25/28

Material
59004664

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
1191343442/70

Client Order
CZZ21C00819

Description
TXT002 33,7x2,6x6000 TP304L LAS Z

Part Number

Client Date
3/29/2021

Item	Identification Nr	Heat	Quantity MTL	Quantity KG	Quantity PZZ	Delivery conditions	Reworks
1	21RE001178	0462017	366	700	61	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 (%)
21RE001178	RAW MATERIAL	.027	.380	1.640	.0290	.0010	.0740	18.060	8.050

Identification Nr	Type of mechanical test	Rp 0.2 [MPa]	Rp 1.0 [MPa]	Rm [MPa]	A5 (%)
21RE001178	TUBE	180	215	470 670	40

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 W2IW10 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
(LGO:MARCEGAGLIA) \$DIAMETRO\$ X \$SPESSORE_NOM\$ HEAT N°\$COLATA\$ EN 14301 / EN 14307 - TP 304 / TP 304L EN 10217-7 TC1 \$STATO DIFORNITURA\$ \$SIGLA\$ \$DATA\$ \$ORAS\$

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