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Type Inspection Certificate 3.1 EN 10204

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Number 10522133026

Issued On 25/02/2022

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: 0000023130

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

Delivery Nn 8365803842
Of 25/02/2022
Delivery note nr 1005002028

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

Pages
15/18

Material
59004702

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
1191464152/10

Client Order
CZZ22C00202

Description
TXT002 42,4x2,6x6000 TP304L LAS Z

Part Number

Client Date
2/3/2022

Item	Identification Nr	Heat	Quantity MTL	Quantity KG	Quantity PZZ	Delivery conditions	Reworks
1	22RE000316	0542334	222	540	37	W0	BRUSHED
2	22RE000322	0542334	198	462	33		

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 (%)
		0.03	1	2	0.045	0.015	0.11	17.5 19.5	8 10
22RE000316	RAW MATERIAL	.027	.340	1.770	.0300	.0010	.0670	18.010	8.080
22RE000322	RAW MATERIAL	.027	.340	1.770	.0300	.0010	.0670	18.010	8.080

Identification Nr	Type of mechanical test	Rp 0.2 [MPa]	Rp 1.0 [MPa]	Rm [MPa]	A5 (%)
		180	215	470 670	40
22RE000316	TUBE	371	410	600	49.9
22RE000322	TUBE	371	410	600	49.9

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 1.4301 / EN 1.4307 - TP 304 / TP 304L EN 10217-7 TC1 \$Stato di Fornitura\$ \$Sigla\$ \$Data\$ \$Ora\$

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