



U. S. Steel Košice, s.r.o. A01
 Vstupný areál U. S. Steel
 044 54 Košice
 Slovak Republic

Inspection certificate No.:
 EN 10 204:2004/3.1

A02-A03

4879 / 2022

A06 Purchaser :

TASLA Armatura Sp. z o.o.
 27-450 Stalowa Wola, ul. Grabskiego 38
 tel. 15 813 43 76; 77, fax 15 843 22 66
 NIP 865-00-13-543, KRS 0000056442
 rury@tasla.com.pl
RURY STALOWE

A05 Producer :
 U.S. Steel Košice, s.r.o , Rúrovňa

Z02 Date :
 02.11.2022

B01 Product : SPIRALLY WELDED STEEL PIPES – SAWH

B01 According : API Spec. 5L:18*/ISO3183:2019; EN10219-1/06;
 EN10217-1/19; EN10217-5/19

B03 Specification : -

*Except 9.13.2.2.c, E.3.2.2, C.4.3.

A07 Purchaser's order No.: P1250822/USS

A08 Manufacturer's work order number: XR2A0040

A10 Packing Sheet/ Item No.: 122R0240401

A09 Purchaser article number: 6T6C6BI210

B02 Steel designation:
 BM / L245M PSL2; S235JRH / P235TR2 /
 P235 GH TC1

C70 Steelmaking process:
 B O F

B06 Marking:
 Outside: USS Kosice•EN 10219-1,2•S235JRH•SAWH EN 10217-1,5•P235TR2 P235GH TC1•Pipe No. •TK 1-23
 API Spec.5L•ISO 3183•D•t•BM•PSL 2•SAWH•D•t•L 245 M•PSL2•6,7 MPa•TESTED•Pipe lenght
 Inside:

B08 No. of Pieces:	B12 Th. Mass:	B14 Total length:	B09 Dimensions, Pipe No.:
10	22150 kg	120.4 m	Ø 610 x 12.5 mm ; 12.00 m ; - 0 + 50 mm

B10 Pipe No.:	B07 Heat No.:	C00 Test No.:	
		C71	C00
22-4635801-01-01,-02,-03,-04,-05,-07,-08	46358	545,546	1443
22-4635803-01-01,-02	46358	545,546	1443
22-4636304-01-07	46363	539,540	1440

Visual inspection	D01 Satisfactory
Dimensional inspection: API Spec. 5L:2018, EN ISO 3183:2019; EN 10219-2:2019; EN 10217-1/19; EN 10217-5/19	Satisfactory
Hydrostatic pressure test: 6,7 MPa – 10 s	Satisfactory
Welding procedures are prepared and approved acc.to: EN 15614-1	
Operators and Welders are certified acc.: EN ISO 14732 and EN ISO 9606-1	
Requirements: Weld factor: V=1,0	
Manufacturer of coils: U.S.Steel Košice, s.r.o	
Magnetism residual test on pipe ends: API Spec. 5L:2018, EN ISO 3183:2019	Satisfactory

Non-destructive testing :	D02 Satisfactory
100% weld test by UT acc. to EN ISO 10893-11:2011, class U2H or by RT acc. to EN ISO 10893-7:2019, class B	Satisfactory
Method-Indicator: UT: 1,6 mm diameter drilled hole; RT: EN ISO 19232-1/ EN ISO 19232-5, W17/D11 for th.<=6; W16/D11 for 6<th<=8; W15/D10 for 8<th.<=12; W14/D9 for 12<th.<=20 /mm/	Satisfactory
15mm zone adjacent to the coil end welds test by UT acc. to EN ISO 10893-8:2011, Annex A, class U2	Satisfactory
NDT Operators are certified acc. to EN ISO 9712	Satisfactory



Test Results

Chemical composition: %

Heat No.	Product Analysis	C	Mn	Si	P	S	Al	Cu	Ni	Cr	B	Ti	V	Nb	Mo	CE llw	CE Pcm	Cu+Ni+Cr+Mo max 0.70
		max 0.16	max 1.20	max 0.35	max 0.025	max 0.015	min 0.020	max 0.30	max 0.30	max 0.30	max 0.001	max 0.03	max 0.02	max 0.01	max 0.08	max 0.35	max 0.25	
46358	-	0.14	0.63	0.19	0.013	0.005	0.038	0.021	0.010	0.015	0.000	0.001	0.001	0.002	0.002	0.25	0.18	0.05
46363	-	0.14	0.65	0.20	0.022	0.007	0.037	0.036	0.014	0.029	0.000	0.001	0.001	0.002	0.003	0.26	0.19	0.08
46358	545	0.14	0.64	0.20	0.013	0.004	0.039	0.021	0.009	0.014	0.000	0.001	0.001	0.002	0.002	0.25	0.18	0.05
46358	546	0.14	0.63	0.19	0.012	0.004	0.039	0.021	0.009	0.014	0.000	0.001	0.001	0.002	0.002	0.25	0.18	0.05
46363	539	0.14	0.65	0.18	0.020	0.006	0.037	0.033	0.018	0.037	0.000	0.001	0.001	0.002	0.003	0.25	0.18	0.09
46363	540	0.14	0.64	0.18	0.020	0.006	0.037	0.034	0.018	0.036	0.000	0.001	0.001	0.002	0.003	0.25	0.18	0.09

C71

Mechanical tests

C00 - C50

Test No.	Dimensions			** (°C)	Tensile test					C50 Bend test	Impact test - pipe body *		Impact test - seam weld *		Impact test - HAZ *	
	(mm)				(MPa)						(J)		(J)		(J)	
	C40 a0	C41 b0	C02 Specimen		C03 Test temper.	C11 Yield strength	C12 Tensile strength	C13 Elongation	C14 Ratio		C42 Single values	C43 Average value	C42 Single values	C43 Average value	C42 Single values	C43 Average value

Requirements	REH (Rp02)	Rm	A5	REH (Rp02)/RM	mm	KV	KV	KV
EN10219-1/06; EN10217-1/19; EN10217-5/19	min 235	360-500(2) min 360(3)	min 24	%	Ø 37.5	(10,0x8,0 mm) min 27	(10,0x8,0 mm) min 27	(10,0x8,0 mm) min 27
API Spec. 5L/18*; ISO3183/19	Rt05 245-450	Rm 415-655(2) min 415(3)	Af min 29	Rt05/RM %	Ø 37.5	(10,0x8,0 mm) min 27	(10,0x8,0 mm) min 27	(10,0x8,0 mm) min 27

Results

1443	S	S	2		316	451	30											
1443	S	S	2		311	456	45	0.68										
1443	S	S	3			478												
1443	S	S	3			490												
1443	S	S	3						Satisfactory									
1443	8.00	10.00	2	0						134,224,245	201							
1443	8.00	10.00	3	0								203,158,173	178					
1443	8.00	10.00	4	0											146,141,126	138		
1440	S	S	2		323	467	31.5											
1440	S	S	2		326	471	42	0.69										
1440	S	S	3			499												
1440	S	S	3			501												
1440	S	S	3						Satisfactory									



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1440	8.00	10.00	2	0					221,136,80	146					
1440	8.00	10.00	3	0							147,147,149	148			
1440	8.00	10.00	4	0									70,84,79	78	

S-Size acc. to standard ;1-Pipe body-Longitudinal ;2-Pipe body:Transverse ;3-Seam weld-Transverse ;4-Heat-affected zone (HAZ) ;5-Coil end weld

*If test element is less than 10,00 mm, is made by impact test values KV calculation. Values are recalculated in accordance with standard.

**Unless, if not specified alternatively, test must be performed at ambient temperature (23°C +/- 5°C).

Z05

Manufacturer is certified according to EN ISO 9001, EN ISO 14001, EN ISO 50001 and approved according to AD 2000 - Merkblatt W0 and certified according to the Pressure Equipment Directive 2014/68/EU by TÜV-Thüringen e.V. ; NoBo reg.no. 0090

For API/ISO: ZETOM/National Declaration
 Research and Certification Institute in Katowice sp.z o.o AC005,
 National Certificate of Conformity:
 No. 005-UWB-062

National Declaration of Performance Properties: USSK-05/2020
 For EN: ZETOM/National Declaration
 Research and Certification Institute in Katowice sp.z o.o AC005,
 National Certificate of Conformity:
 No. 005-UWB-129; No. 005-UWB-130

National Declaration of Performance Properties: USSK-02/2020; USSK-03/2020

Z01

The Declaration of Performance (DoP), see here:<http://www.usske.sk/en/products/spiral-welded-pipes/declaration-of-conformity>

We hereby confirm that the above product has been manufactured and tested in accordance with the requirements of the contract.
 Document valid also without signature

Z04



09
 Zetom-Katowice
 AC 005



13
 Zetom-Katowice
 AC 005



Z02

Location: Košice

Date: 02.11.2022

Martin Milota
 Inspection representative