

**Norwegian Piping AS**

Idrettsvegen 144  
NO-5353 STRAUME  
Norway

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Fax +47 5631 2301

Reinertsen AS  
KI001 Riser Bytte Snorre  
2017-05-29



100018  
Your order: KI001 Riser Bytte Snorre  
Contact person: Kristin Lithun  
Customer's ref:  
Project: NP160929  
Sales order: 59924  
Print date: 2017-05-29

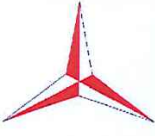


## Certificate List

Customer Order #	Item #	Del. #	Article #	Tag/SI/Art	Description	Qty	Unit	Heat #	Lot #	Manufacturer	Manuf. Cert. #
KI001 Riser Bytte Snorre	1	1730582	Z0000000007696		Pipe UNS S31254 OD 361 (ID 287) x 35,00 MM/WT, L=7.500mm	14	mtr	570810	P000032 8-2017	Rivit S.p.A	Z0001790-2017



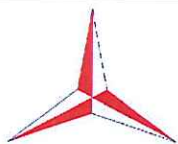
CO #	Item #	Del #	Heat	Lot	Tag/SI/Art	Qty	Description
KI001 Riser Bytte Snorre	1	1730582	570810	P0000328-2017		14	Pipe UNS S31254 OD 361 (ID 287) x 35,00 MM/WT, L=7.500mm

Norwegian Piping CERTIFY that the document hereunto annexed is a TRUE [electronically] COPY of the original document of which it purports to be a copy, having carefully collated and compared the said copy with the said original and found the same to agree therewith. The original documents is in our possession and can be viewed at our premises.  
Norwegian Piping has performed 100% document control of this certificates including all reports and annexes.

 <b>RIVIT</b> S.p.A. Socio Unico VIA PALLADIO, 129 - 38030 CALTRANO (VI) ITALY TEL. 0039 0445 359311 - FAX 0039 0445 359329 http://www.rivit.com - e-mail: info@rivit.com Soggetta a direzione e controllo da parte di Holding Bull srl.		<b>CERTIFICATO DI COLLAUDO</b> <b>INSPECTION CERTIFICATE</b> <b>(EN 10204-2004 Type 3.1)</b>		 																																																																																																																					
Nr. <b>Z0001790-2017</b>		REV. <b>1</b> DEL <b>26/05/2017</b>		Pag <b>1</b>																																																																																																																					
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Descrizione del materiale/Description of material - Dimensioni/Dimensions (mm)				Q.tà/Q.ty (m)	Pz/Pc (Nr)																																																																																																																				
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Construction specification: ASTM A358/A358M-15 cl.1      Dimensional tolerances: ASTM A358/A358M-15 - modified (*) Heat treated at 1170 C /70 min/ Water quenched within 60 s. - 100% X-RAYS (PRIOR Heat Treatment)																																																																																																																									
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Note/Notes: Tests and supplementary test acc. to ASTM A358/A358M and Norsok M-630 Ed. 6, MDS R12 Rev. 5: - Corrosion test acc. to ASTM G48 Meth. A: See report Rivit No. L0755/17.				<b>RIVIT S.p.A.</b> Quality Control System Department <b>ISPETTORE - Inspector</b>																																																																																																																					

The quality Management System supports the requirements of Annex I, chapt. 4.3 of Pressure Equipment Directive (PED) 2014/68/CE.





# RIVIT

S.p.A.

VIA PALLADIO, 129 - 36030 CALTRANO (VI) ITALY  
TEL. 0039 0445 359311 - FAX 0039 0445 359329  
Http://www.rivit.com - e-mail: info@rivit.com  
Soggetta a direzione e controllo da parte di Holding Bull srl.

## CERTIFICATO DI COLLAUDO INSPECTION CERTIFICATE

(EN 10204-2004 Type 3.1)

Nr. Z0001790-2017

REV. 1

DEL 26/05/2017

Pag 2



Cliente/Customer:	NORWEGIAN PIPING AS N-5353 STRAUME			Data: 26/05/2017
Ordine Cliente/Order N°:	70488 160929 .DATED 22.12.2016			
Comm. Rivit/Our Order N°:	C0000498-2016	DDT N°	//////////	Controllo visivo e dimensionale/Visual and dimensional check: OK!
Descrizione del materiale/Description of material - Dimensioni/Dimensions (mm)		Q.tà/Q.ty (m)	Pz/Pc (Nr)	Materiale/Material RT - (X-ray) Nr.
WELDED PIPES UNS S31254 De 361 Th 35 L=7000 mm		14.00	2	UNS S31254 P0000328-2017
ITEM 1 - NP STOCK N. Z0000000007696 - ID 287 MM				

Construction specification: ASTM A358/A358M-15 cl.1

Dimensional tolerances: ASTM A358/A358M-15 - modified (\*)

Heat treated at 1170 C /70 min/ Water quenched within 60 s.

- 100% X-RAYS (PRIOR Heat Treatment)

\*\*\* SEGUE DA PAGINA PRECEDENTE/ FOLLOW FROM PREVIOUS PAGE \*\*\*

### NDE Examination:

- Hydrostatic test at 190 Bar for 15 s. or a time sufficient to permit inspection of the entire length of the welded seam: Satisfactory.
- Dye penetrant test: See report Rivit No. 0262/17.
- Ultrasonic test: See report Delta No. 86/17.

(\*) Wall thickness tolerance: 0/+10%.

Internal diameter tolerance: 0/+5 mm.

- Bevelled ends acc. to ASME B 16.25 Ed. 2012.
- QTR No.: QTR-009.
- Plate Manufacturer: Outokumpu.
- Melting Process: Electric Arc Furnace + AOD.

SNORRE A - RISER PIPES PROJECT.

### LEGENDA/Note

**RT:** Radiografie/Radiographic Test

(%) Lungh. Saldatura/length weld

**ET:** Correnti Indotte/Eddy Current

**UT:** Ultrasuoni/Ultrasonic

**PT:** Liquidi Penetranti/Dye penetrant

**HT:** Prova idraulica/Hydraulic Test

**PMI:** Positive Material Identification

**HB:** Durezza/Hardness Brinell

**HRC:** Durezza/Hardness Rockwell C

**HRB:** Durezza/Hardness Rockwell B

**HV:** Durezza/Hardness Vickers

**Rm:** Carico unitario rottura

Tensile Strength

**Rp0,2%** Carico unitario scost. proporz.

Yield strength

**Rp1%** Carico unitario scost. proporz

Yield strength

**A:** Allungamento % dopo rottura

Elongation % after break

**NO HT:** Non Trattati/ No Heat Treatm.

**WLD:** Saldatura/Welded

Analisi chimica/Chemical Composition

Proprietà Meccaniche/Mechanical Proprieties

Controlli Non Distruttivi - NDE

Condizione superficie: Decapata e passivata

Surface Condition: Pickled and passivated

The material supplied has been found complying with the order requirements

**RIVIT S.p.A.**

Quality Control

System Department

**ISPETTORE - Inspector**



Cliente/Customer:		NORWEGIAN PIPING AS N-5353 STRAUME						
Ordine/Your Order N°:	70488_160929 .DATED 22.12.2016			Comm. Rivit Nr.:	C0000498-2016		Data/Date:	12/05/2017
Descrizione del materiale - Description of material							Lotto Prod/Prod.Lot - Colata/Heat Nr	
Dimensioni/Dimensions (mm)				Pz/Pc (Nr)	Q.tà/Q.ty (m)		P0000328-2017	
WELDED PIPES UNS S31254 De 361 Th 35 L=7000 mm				2	14,00		570810	
ITEM 1 - NP STOCK N. Z0000000007696 - ID 287 MM				Materiale/Mat.		UNS S31254		
Specifica di controllo Testing Procedure	ASME V-RP/023			Estensione RT RT Extension	100% PRIOR HEAT TR.			
Accettabilità Acceptance Standard	ASME VIII DIV.1 UW51			Sensibilità Rad. Image Quality	2/2T-0,94	Apparecchio Equipment	RX 350/20	
Pellicola/Film	MX 125	Formato/size	10 x 48	Penetrametro	ASTM 1B/3B 11	Posizione/Location	Source Side	
Schermi al piombo mm Lead Screens	0,05-0,10	Parete attrave. Radiat. Thro.	Single	Macchia focale Focus Size	5,5 x 5,5 mm	Densità pellicola Film Density	1,8-4	
Distanza fuoco film mm Focus-to-object distance	800	Intensità mA Current	12	Tensione KV Voltage	320	Tempo esposizione Exposure Time	130 s.	
Nr. Pellicola/Film No.	Tratto/Tract	Difetti/Defects		Matricola/ Welder ID	Densità/ Film Density	Esito/ Judgement	LEGENDA/NOTE	
032801/2017	1/ 2			236 - 246	2,60	S	<b>DIFETTI/DEFECTS</b>  IG= Inclusioni Gas/Gas inclusion IW= Inclusioni di W/W inclusion GP= Porosità da Gas / Gas pockets IM= Incisioni marginali/Marginal incision RI= Ripresa irregolare/Irregular Root CE= Cordone est. Irregolare/ Ext Irregular head CI= Cordone Int. Irregolare/ Int. Irregular head DS= Dislivellamento/ Edges misalignment EP= Eccessiva penetrazione/ Excess Penetration DF= Difetto pellicola/Film defect RT= Ritiri/Shrinkages MF= Mancata fusione/Lack of fusion CR= Cricche/Cracks SC= Scorie/Slags <b>ESITO/JUDGEMENT</b> R= Riparare/ To Repair S= Soddisfacente/Satisfactory A1-2-3= Accettabile dopo la 1-2-3 Riparazione Accettable after the 1-2-3 repair	
	2/ 3			236 - 246	2,60	S		
	3/ 4			236 - 246	2,60	S		
	4/ 5			236 - 246	2,60	S		
	5/ 6			236 - 246	2,60	S		
	6/ 7			236 - 246	2,60	S		
	7/ 8			236 - 246	2,60	S		
	8/ 9			236 - 246	2,60	S		
	9/ 10			236 - 246	2,60	S		
	10/ 11			236 - 246	2,60	S		
	11/ 12			236 - 246	2,60	S		
	12/ 13			236 - 246	2,60	S		
	13/ 14			236 - 246	2,60	S		
	14/ 15			236 - 246	2,60	S		
	15/ 16			236 - 246	2,60	S		
	16/ 17			236 - 246	2,60	S		
	17/ 18			236 - 246	2,60	S		
	032802/2017			1/ 2				236 - 246
2/ 3		236 - 246	2,60	S				
3/ 4		236 - 246	2,60	S				
4/ 5		236 - 246	2,60	S				
5/ 6		236 - 246	2,60	S				
6/ 7		236 - 246	2,60	S				
7/ 8		236 - 246	2,60	S				
8/ 9		236 - 246	2,60	S				
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10/ 11		236 - 246	2,60	S				
11/ 12		236 - 246	2,60	S				
12/ 13		236 - 246	2,60	S				
13/ 14		236 - 246	2,60	S				
14/ 15		236 - 246	2,60	S				
15/ 16		236 - 246	2,60	S				
16/ 17		236 - 246	2,60	S				
17/ 18		236 - 246	2,60	S				
Ug=0,24 mm.		1/ 2					236 - 246	2,60
	2/ 3	236 - 246			2,60	S		
	3/ 4	236 - 246			2,60	S		
	4/ 5	236 - 246			2,60	S		
	5/ 6	236 - 246			2,60	S		
	6/ 7	236 - 246			2,60	S		
	7/ 8	236 - 246			2,60	S		
	8/ 9	236 - 246			2,60	S		
	9/ 10	236 - 246			2,60	S		
	10/ 11	236 - 246			2,60	S		
	11/ 12	236 - 246			2,60	S		
	12/ 13	236 - 246			2,60	S		
	13/ 14	236 - 246			2,60	S		
	14/ 15	236 - 246			2,60	S		
	15/ 16	236 - 246			2,60	S		
	16/ 17	236 - 246			2,60	S		
	17/ 18	236 - 246			2,60	S		
							Sviluppo: Automatico Film Processing: Automatic	
				DELTA S.r.l. P. Sgarbossa M° LIVELLO CIC-PND UNI-EN 473 RT-PT-MT		ISPETTORE Inspector		



## QUALITY CONTROL DEPARTMENT



### Laboratory Test Report

Certificate No.:	L 0755/17	Rev.	0	Date:	18/05/2017
Client:	NORWEGIAN PIPING AS.				
Purchase order no.:	70488_160929.DATED 22.12.2016.				
Job Rivit:	C0498/2016.				
Material description:	ITEM 1 - NP STOCK N. Z0000000007696 - ID 287 MM WELDED PIPES UNS S31254 De 361 Th 35 L=7000 mm				
Construction normative:	ASTM A358/A358M-15 cl.1 + Norsok M-630 Ed. 6, MDS R12 Rev. 5				
Production lot number:	0328/17				
No. of pipes on production lot:	2				
Rt number from:	032801/17	to	032802/17		
Heat number:	570810				

Type of testing:	Corrosion test: Ferric Chloride Pitting Test.
Testing normative:	ASTM G48 met. A.
Ferric Chloride Test Solution:	Approximately 6% FeCl <sub>3</sub> by weight (100g of FeCl <sub>3</sub> .6H <sub>2</sub> O in 900ml distilled water).
Test Speciment Preparation:	120-grit abrasive paper (Wet polishing).

Time	Hours	24	Dimensions (mm)		Weight			Weight Loss
Temp.	°C	50	Thickness	10,09	Initial	Final	Loss	g/m <sup>2</sup>
			Width	39,75	(g)	(g)	(g)	
Area	Lat. (mm <sup>2</sup> )	6729	Length	59,46	189,1322	189,1322	0,0000	0,000

Acceptance criteria:	Weight Loss < 4 g/m <sup>2</sup> .
Note:	No pitting at 20X magnification.
Examination results:	SATISFACTORY.

Operator:	Document controlled:	Inspector:
	 RIVIT S.p.A. Quality Control System Department	





## QUALITY CONTROL DEPARTMENT



### Dye penetrant test examination report

Certificate no.:	0262/17	Rev.	0
Date:	22/05/2017		

Client:	NORWEGIAN PIPING AS.		
Purchase order no.:	70488_160929.DATED 22.12.2016.		
Job Rivit:	C0000498/2016.		
Material description:	ITEM 1 - NP STOCK N. Z0000000007696 - ID 287 MM WELDED PIPES UNS S31254 De 361 Th 35 L=7000 mm		
Construction normative:	ASTM A358/A358M-15 cl.1 + Norsok M-630 Ed. 6, MDS R12 Rev. 5		
Production lot number:	0328/17		
Number of pipes on production lot:	2		
Rt number from:	032801/17	to	032802/17
Heat number:	570810		


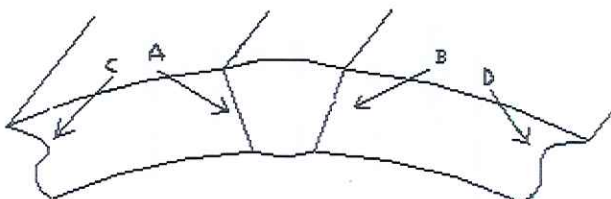
Pipe test, Rt no.	032801/17	to	//
Extension check:	100% of external welding surfaces on 10% of pipes.		
Procedure:	RIVIT RP/PROC/024 - ASME V Article 6		
Acceptance standard	RIVIT RP/PROC/024 - ASME CODE SECT. VIII DIV. 1 App. 8.		
Temperature [°C]:	Ambient.		

x	Water washable	x	Visible	Fluorescent
	Solvent removable		Visible	Fluorescent
	Post emulsified		Visible	Fluorescent

Cleaner:	VELNET	Penetrant:	RED-WW	Emulsifier:	//
Developer:	ROTRIVEL UWHITE-W	Trade name:	CGM	Cleaning:	Paper
Penetrant application:	Brush	Penetrant Minimum time:	10 min	Emulsifier application:	//
Penetrant removal:	WATER	Developer application:	Spry	Drying process:	//
Checking time:	Min 10 Max 60 minutes	Developing Time	10 min	Cleaning after examination:	Yes.

Examination results:	SATISFACTORY.
Note:	

Operator: F. Giordano 1° LIVELLO CIPND UNEN473 RT-PT-MT	Document controlled: L. BATTISTA LIVELLO 2 - EN473 RT-PT-VT	Inspector:
---	--	------------

		<b>CERTIFICATO CONTROLLO ULTRASUONI</b> <b>Ultrasonic Test Report</b>				REPORT UT N.		86/17			
						PAG 1		DI 1			
						Sheet		of			
OGGETTO Object		WELD AND BODY PIPE		COMM Job		C0498-2016 NO		LOCALITA' Site		Caltrano (VI)	
COLATA Heat		570810		POS./LOTTO Pos./Lot		328/17		PFC Pfc		P0328-2017	
QUANTITA' Quantity		2		DA From		Vedi Note		A To		Vedi Note	
								Heat Treatment		Before P.W.H.T. <input type="checkbox"/> After P.W.H.T. <input checked="" type="checkbox"/> N.A. P.W.H.T. <input type="checkbox"/> After H.D. <input type="checkbox"/>	
MATERIALE Material		UNS S31254		Ø L mm		Ø= 361.0 L= 7000		SPESS. Th.		35.00	
										ACCOPP. Couplant COLLA GEL Cellulosic paste	
										TECNICA Technique ECO IMPULSO Pulse Echo	
NORM AND GENERAL PROCEDURE Norma e Procedura generale				ASTM E213-PND UT 114				ACCEPTANCE LEVEL Livello Accettabilità			
TEST-BLOCK ID. Sigla test-block				420				CALIBRAZIONE Calibration			
								ASTM E213-PND UT 114			
								411			
STRUMENTO Equipment											
RDG 600 Gilardoni											
N°. SONDA Probe ID	ONDA Propagat.	TIPO Type	MHz	SEZIONE Dimens.	ANGOLO Angle						
1	T	MWB	2	8X9	45°						
2											
3											
4											
POSIZIONI D'ESPLORAZIONE Position Exploration											
SCAN POSITION				PROBE N.				SCAN POSITION			
A-B				1							
C-D				1							
NOTE -RT 32801/17 to 32802/17											
RISULTATI DEL CONTROLLO Final Result				CONFORMING				NOT CONFORMING			
ESECUTORE Performed by				APPROVATO Approved				ISPETTORE CLIENTE Customer Inspector			
II LEVEL ISO 9712 N. Sgarbossa								BIAZZALE GIROLAMO LIVELLO 2- EN473			
FIRMA - Signature				FIRMA - Signature				FIRMA - Signature			
DATA Date				DATA Date				DATA Date			
19/05/2017											



<b>CERTIFICATE - ZEUGNIS - CERTIFICAT</b>		Page Seite	1(2)
<b>EN 10 204-3.1</b>			
Date - Datum	Load - Ladung - Charge No	Cert.No - Zeugnis Nr	
170424	9713	7048325.R00	



Your order - Ihre Bestellung - Votre commande		Outokumpu Order - Auftrag - Ordre		Pack - Kolli - Colis No
F0000008/2017/RITA		700015		0
Purchaser - Besteller - Acheteur		Requirements - Anforderungen - Exigences		
Rivit S.P.A. Via Palladio 129		PED 2014/68/EU / EN 10028-7:2007 EN 10088-2:14 ASME SA-240M Code Sect. II. Part A. Ed.2015 ASTM A240M-16a NORSOK Standard MDS-R15 Rev.5 NACE Standard MR0175-03/ISO 15156-3 NACE Standard MR0103-2012 A480/A480M EN 10 029 - C Length tolerance:-0/+10 mm See below for further requirements		
IT-36030 CALTRANO VICENZA (VI) ITALIEN				
Dest				
Certificate via Email				
Product - Erzeugnisform - Produit				
Stainless steel plate, hot rolled Solution annealed, pickled/1D/No.1 Finish				
Grade - Werkstoff - Nuance		*		
254 SMO 1.4547/UNS S31254				

Brand-Mark Herstellerzeichen Signe du Producteur	* 	Inspectors stamp Abnahme - Stempel Estamp de l'expert	* 	Melting process Erschmelzungsart Procédé de fusion	E+AOD
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Marking - Kennzeichnung - Marquage

Plate No, Dimension, Heat No, Lot No, Incl. \*

Extent of delivery - Lieferumfang - Etendue de livraison		Heat No Schmelze Nr Coulée		Lot No Los Nr Lot No	
Item Pos	Pcs Anzahl Nombre	Dimension mm	Abmessung		
2	4	36 * 150 * 400		570810	328310

Plate No 5276 2603,-2604,-2605,-2606  
Blech Nr  
Tôle No

Chemical composition - Chemische Zusammensetzung - Composition chimique%											
	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	N	
Min	0.000	0.0	0.0	0.000	0.000	19.5	17.5	6.0	0.50	0.18	
Max	0.020	0.7	1.0	0.030	0.010	20.5	18.5	6.5	1.00	0.25	
570810	0.011	0.4	0.4	0.022	0.001	19.9	17.8	6.1	0.62	0.19	

Test results - Prüfergebnisse - Résultats des essais (1N/mm² = 1 MPa)

Mechanical Properties		Tensile testing (ASTM) Centre	
Plate-No	Direc.	Top/Bot	Location
	T = Transverse L = Longitudinal	F = Front B = Back	P = Flat C = Round 1 = Center 2 = Close to Surface 3 = Standard 4 = At 1/4 of thickness

Plate-No	Direc.	Top/Bot	Location	Form	Temp.	Rp 0,2	Rm	A50
					C	N/mm2	N/mm2	%
Min						310	655	35
Max								
2602	T	F	1	C	20	310	671	57

Plate-No	Direc.	Top/Bot	Location	Form	Temp.	Rp 0,2	Rp 1,0	Rm	A5	A50
					C	N/mm2	N/mm2	N/mm2	%	%
Min						310	340	655	40	35
Max								850		
2602	T	F	4	C	20	322	350	673	57	59

**RIVIT S.p.A.**  
36030 CALTRANO (VI) ITALY  
QUALITY CONTROL SYSTEM DEPARTMENT  
COPY ACCORDING TO THE ORIGINAL ONE

**RIVIT - C.Q. DEPT.**  
REGISTRATO N° 2017  
CODICE MATERIALE N° 3237

The results comply with the requirements of the order.

Outokumpu Stainless AB  
Business Area Quarto Plate  
Quarto Plate Europe  
SE-693 81 Degerfors, Sweden  
Tel. +46 586 470 00, Fax +46 586 470 16, [www.outokumpu.com](http://www.outokumpu.com)  
Registered office: Stockholm, Sweden.  
Reg. No. 556001-8748, Vat No. SE556001874801



Computer generated original  
Quality Inspector

Linda Hjalmarsson



CERTIFICATE - ZEUGNIS - CERTIFICAT			Page Seite	2(2)
EN 10 204-3.1				
Date - Datum	Load - Ladung - Charge No	Cert.No - Zeugnis Nr		
170424	9713	7048325.R00		



#### Hardness Rockwell B

Plate-NoDirec. Top/BotLocation Form Temp. HRB  
C

Min  
Max  
2602 T F 3 P 20 96  
82

#### Corrosion

ASTM G48 Method A +50 °C/24h:

Plate-NoDirec. Top/BotLocation Form Temp. Max  
C g/m2x24h

Min  
Max  
2602 T F 3 P 50 4  
0

#### Other Information

Heat treated at 1200°C and Quenched in water.

Dimensional control, visual inspection and grade check(PMI) :Approved

Certified acc. to AD2000-Guideline W0 and

Pressure Equipment Directive (2014/68/EU)

annex I, sec. 4.3 by Certification body for

pressure equipment of the TÜV NORD Systems

notified body, reg.-no. 0045

Holding time approximately 1 minute/mm plate thickness

Norsok M650-QTR No.: QTR\_S31354 Rev.1

Here continue the requirements:

Width tolerance:-0/+5 mm

Ultrasonic testing see appendix :



QUALITY CONTROL SYSTEM DEPARTMENT  
COPY ACCORDING TO THE ORIGINAL ONE

Outokumpu Stainless AB  
Business Area Quarto Plate  
Quarto Plate Europe  
SE-693 81 Degerfors, Sweden  
Tel. +46 586 470 00, Fax +46 586 470 16, [www.outokumpu.com](http://www.outokumpu.com)  
Registered office: Stockholm, Sweden.  
Reg. No. 556001-8748, Vat No. SE556001874801



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Quality Inspector

*[Signature]*

Linda Hjalmarsson



**ULTRASONIC INSPECTION CERTIFICATE**  
**ULTRASCHALLPRÜFZEUGNIS**  
**CERTIFICAT DE CONTRÔLE PAR ULTRA-SONS**



Ref. Gunnar Karlsson	Testing date - Prüfungsdatum - Date de contrôle 2017-04-21	Certificate No. - Zeugnis Nr - Certificat No. 7048325.R00
	Date of certificate - Zuegnisdatum - Date de certificat 2017-04-24	Appendix - Anlage - Annexe 1

**MATERIAL IDENTIFICATION - MATERIALIDENTIFIKATION - IDENTIFICATION DU MATERIEL**

Purchaser - Besteller - Acheteur Rivit S.P.A. Via Palladio 129 IT-36030 CALTRANO VICENZA (VI) ITALIEN	Your order - Ihre Bestellung - Votre commande F0000008/2017/RITA	Outokumpu order - Auftrag - Ordre 700015	Item - Pos 2
Grade - Werkstoff - Nuance 1.4547;254 SMO;UNS S31254	Lot No - Los Nr - Lot No 328 310	Heat No - Schmelze Nr - Cauté 570810	Dimension - Abmessungen - Dimension (mm) 36 x 150 x 400
Plate No - Blech Nr - Tôle No 5276 2603, -2604, -2605, -2606			

**TESTING PRESUMPTIONS - PRÜFVORAUSSETZUNG - CONDITIONS D'ESSAI**

Testing method - Prüfmethode - Méthode d'essai Pulse echo/contact technique - Impuls-Echo kontakttechnik - Contrôle par contact/réflexion	Testing specification - Prüfspezifikation - Spécification d'essai Outokumpu specification: OS 1490 Other spec.-Andere spez.-Autre: Ultraljudprovning av plåt	Rev.
Inspection by - Überwachung von - Contrôle par Outokumpu Stainless, Degerfors	Acceptance standard - Zulässigkeitsgrenze - Critère d'acceptation ASTM A 578; Level C-S1	
Testing scope - Prüfungsbereich - Etendue d'essai Surface, 100 %		
Notes - Bemerkung - Remarques OS 1490		

**EQUIPMENT - GERÄT - EQUIPMENT**

Instrument - Gerät - Appareil P-scan 4/Sonatest 250		No - Nr - No 206/100223	
Probe - Prüfkopf - Palpeur TRL 4/SEB 4	Dim. probe - Abm. prüfkopf - Dim. Palpeur 6x20mm	Frequency - Frequenz - Fréquence 3MHz/4MHz	Angle - Einschaltwinkel - Angle -
Couplant - Ankopplung - Couplage Water	Notes - Bemerkung - Remarques		

**SETTINGS**

Reference method - Bezugsmethode - Méthode de référence Backwall-Reflection (BR)	Ref. level - Bezugshöhe - Eche de référence TVG/DAC	
Sensitivity - Empfindlichkeit - Sensibilité Reference level +6dB	Scanning rate - Prüfungsgeschwindigkeit - Vitesse d'essai ≤150 mm/s	Pulse energy - Impulsstärke - Puissance 1
Notes - Bemerkung - Remarques		

**TESTING CONDITIONS**

Surface condition - Oberfläche - Etat de surface Stainless Steel, Hot rolled, Pickled
Notes - Bemerkung - Remarques

**TEST RESULTS - PRÜFERGEBNISSE - RESULTAT D'ESSAI**

Reporting level - Registrierschwelle - Seuil d'enregistrement			
<input checked="" type="checkbox"/>	No discontinuity indications above the reporting level - Keinefehler grösser als registrierschwelle - Aucune indications supérieure seuil 'enregistrierment		<input type="checkbox"/> See annexure - Stehe anlage - Voir annexe
<input checked="" type="checkbox"/>	Disposition - Beschluss - Evaluation Accepted - Akzeptiert - Approuvé	<input type="checkbox"/> Disposition - Beschluss - Evaluation Rejected - Kassiert - Rébute	<input type="checkbox"/> Further investigation - Weiter untersuchung - Examen supplémentaire
Notes - Bemerkung - Remarques			

**OPERATOR, INSPECTOR - PRÜFER, PRÜFAUFSICHT - OPERATEUR, CONTRÔLEUR**

Testing performed by - Abnahme durch - Opérateur Gunnar Karlsson	Level acc. - Niveau gem. - Niveau s. 2	Sign. 
Testing performed by - Abnahme durch - Opérateur	Level acc. - Niveau gem. - Niveau s. 2	Sign.
Approved by - Akzeptiert von - Approuvé par Outokumpu Stainless/Gunnar Karlsson	Inspector - Prüfaufsicht - Contrôleur	Inspector - Prüfaufsicht - Contrôleur
Position - Stellung - Poste Level 2 acc. to EN 473	Agency - TUO - Agence d'inspection	Agency - TUO - Agence d'inspection
Sign.	Sign.	Sign.
Notes - Bemerkung - Remarques	This certificate is based on internal report - Dieses zeugnis basiert auf dem internen prübericht - Ce certificat est basé sur le procès-verbal interne	No - Nr - No 

QUALITY CONTROL SYSTEM DEPARTMENT  
 COPY ACCORDING TO THE ORIGINAL ONE



**CERTIFICATE - ZEUGNIS - CERTIFICAT**

 Page  
Seite 1(2)

**EN 10 204-3.1**

 Date - Datum Load - Ladung - Charge No Cert.No - Zeugnis Nr  
**170424 9716 7048327.R00**


Your order - Ihre Bestellung - Votre commande

**F0000008/2017/RITA**

Purchaser - Besteller - Acheteur

**Rivit S.P.A.**
**Via Palladio 129**
**IT-36030 CALTRANO VICENZA (VI)  
ITALIEN**

Dest

Certificate via Email

Product - Erzeugnisform - Produit

**Stainless steel plate, hot rolled**
**Solution annealed, pickled/1D/No.1 Finish**

Grade - Werkstoff - Nuance

**254 SMO**
**1.4547/UNS S31254**

Outokumpu Order - Auftrag - Ordre Pack - Kolli - Colis No

**700015**
**0**

Requirements - Anforderungen - Exigences

**PED 2014/68/EU / EN 10028-7:2007**
**EN 10088-2:14**
**ASME SA-240M Code Sect. II. Part A. Ed.2015**
**ASTM A240M-16a**
**NORSOK Standard MDS-R15 Rev.5**
**NACE Standard MR0175-03/ISO 15156-3**
**NACE Standard MR0103-2012**
**A480/A480M**
**EN 10 029 - C**
**Length tolerance:-0/+10 mm**
**See below for further requirements**

 Brand-Mark  
Herstellerzeichen  
Signe du Producteur

 Inspectors stamp  
Abnahme - Stempel  
Estamp de l'expert

 Melting process  
Erschmelzungsart  
Procédé de fusion

**E+AOD**

Marking - Kennzeichnung - Marquage

**Plate No, Dimension, Heat No, Lot No, Incl. \***

Extent of delivery - Lieferumfang - Etendue de livraison

Item Pos	Pcs Anzahl Nombre	Kg	Dimension mm	Abmessung	Heat No Schmelze Nr Coulée	Lot No Los Nr Lot No
1	1		36 * 2103 * 7000		570810	328310

 Plate No  
Blech Nr  
Tôle No  
**5276 2602**

 Chemical composition - Chemische Zusammensetzung - Composition chimique %  
Heat - Schmelze - Coulée No

	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	N		
Min	0.000	0.0	0.0	0.000	0.000	19.5	17.5	6.0	0.50	0.18		
Max	0.020	0.7	1.0	0.030	0.010	20.5	18.5	6.5	1.00	0.25		
570810	0.011	0.4	0.4	0.022	0.001	19.9	17.8	6.1	0.62	0.19		

 Test results - Prüfergebnisse - Résultats des essais (1N/mm<sup>2</sup> = 1 MPa)

Direc. T = Transverse L = Longitudinal	Top/Bot F = Front B = Back	Form P = Flat C = Round	Location 1 = Center 2 = Close to Surface 3 = Standard 4 = At 1/4 of thickness
--	----------------------------------	-------------------------------	---

**Mechanical Properties**
**Tensile testing (ASTM) Centre**

Plate-NoDirec. Top/BotLocation Form Temp. Rp 0,2 Rm A50

	C	N/mm2	N/mm2	%
Min		310	655	35
Max				

	T	F	1	C	20	310	671	57
2602								

**Tensile testing**

Plate-NoDirec. Top/BotLocation Form Temp. Rp 0,2 Rp 1,0 Rm A5 A50

	C	N/mm2	N/mm2	N/mm2	%	%
Min		310	340	655	40	35
Max				850		

	T	F	4	C	20	322	350	673	57	59
2602										

The results comply with the requirements of the order.

 Outokumpu Stainless AB  
Business Area Quarto Plate  
Quarto Plate Europe  
SE-693 81 Degerfors, Sweden  
Tel. +46 586 470 00, Fax +46 586 470 16, [www.outokumpu.com](http://www.outokumpu.com)  
Registered office: Stockholm, Sweden.  
Reg. No. 556001-8748, Vat No. SE556001874801

 Computer generated original  
Quality Inspector

 Daniel Mälman  
Daniel Mälman

 RIVIT S.p.A.  
36030 CALTRANO (VI) ITALY  
QUALITY CONTROL SYSTEM DEPARTMENT  
COPY ACCORDING TO THE ORIGINAL ONE

 RIVIT - C.Q. DEPT.  
REGISTRATO N° 217  
CODICE MATERIALE N° 3238

CERTIFICATE - ZEUGNIS - CERTIFICAT			Page Seite	2(2)
EN 10 204-3.1				
Date - Datum	Load - Ladung - Charge No	Cert.No - Zeugnis Nr		
170424	9716	7048327.R00		



#### Hardness Rockwell B

Plate-NoDirec. Top/BotLocation Form Temp. HRB  
C

Min						
Max						96
2602	T	F	3	P	20	82

#### Corrosion

ASTM G48 Method A +50 °C/24h:

Plate-NoDirec. Top/BotLocation Form Temp. Max  
C g/m2x24h

Min						
Max						4
2602	T	F	3	P	50	0

#### Other Information

Heat treated at 1200°C and Quenched in water.

Dimensional control, visual inspection and grade check(PMI) :Approved

Certified acc. to AD2000-Guideline W0 and

Pressure Equipment Directive (2014/68/EU)

annex I, sec. 4.3 by Certification body for

pressure equipment of the TÜV NORD Systems

notified body, reg.-no. 0045

Holding time approximately 1 minute/mm plate thickness

Norsok M650-QTR No.: QTR\_S31354 Rev.1

Here continue the requirements:

Width tolerance:-0/+5 mm

Ultrasonic testing see appendix :



QUALITY CONTROL SYSTEM DEPARTMENT  
COPY ACCORDING TO THE ORIGINAL ONE

Outokumpu Stainless AB  
Business Area Quarto Plate  
Quarto Plate Europe  
SE-693 81 Degerfors, Sweden  
Tel. +46 586 470 00, Fax +46 586 470 16, [www.outokumpu.com](http://www.outokumpu.com)  
Registered office: Stockholm, Sweden.  
Reg. No. 556001-8748, Vat No. SE556001874801



Computer generated original  
Quality Inspector

*Daniel Mälman*

Daniel Mälman



**ULTRASONIC INSPECTION CERTIFICATE**  
**ULTRASCHALLPRÜFZEUGNIS**  
**CERTIFICAT DE CONTRÔLE PAR ULTRA-SONS**



Ref. Gunnar Karlsson	Testing date - Prüfungsdatum - Date de contrôle 2017-04-24	Certificate No. - Zeugnis Nr - Certificat No. 7048327.R00
	Date of certificate - Zuegnisdatum - Date de certificat 2017-04-25	Appendix - Anlage - Annexe 1

**MATERIAL IDENTIFICATION - MATERIALIDENTIFIKATION - IDENTIFICATION DU MATERIEL**

Purchaser - Besteller - Acheteur Rivit S.P.A. Via Palladio 129 IT-36030 CALTRANO VICENZA (VI) ITALIEN	Your order - Ihre Bestellung - Votre commande F0000008/2017/RITA	Outokumpu order - Auftrag - Ordre 700015	Item - Pos 1
Grade - Werkstoff - Nuance 1.4547;254 SMO;UNS S31254	Lot No - Los Nr - Lot No 328 310	Heat No - Schmelz Nr - Coulée 570810	Dimension - Abmessungen - Dimension (mm) 36 x 2103 x 7000
Plate No - Blech Nr - Tôle No 5276 2602			

**TESTING PRESUMPTIONS - PRÜFVORAUSSETZUNG - CONDITIONS D'ESSAI**

Testing method - Prüfmethode - Méthode d'essai Pulse echo/contact technique - Impuls-Echo kontakttechnik - Contrôle par contact/réflexion	Testing specification - Prüfspezifikation - Spécification d'essai Outokumpu specification: OS 1490 Other spec.-Andere spez.-Autre: Ultraljudprovning av plå	Rev.
Inspection by - Überwachung von - Contrôle par Outokumpu Stainless, Degerfors	Acceptance standard - Zlassigkeitgrenze - Critère d'acceptation ASTM A 578; Level C-S1	
Testing scope - Prüfumfana - Etendue d'essai Surface, 100 %		
Notes - Bemerkung - Remarques		

**EQUIPMENT - GERÄT - EQUIPMENT**

Instrument - Gerät - Appareil P-scan 4/Sonatest 250		No - Nr - No 206/100223	
Probe - Prüfkopf - Palpeur TRL 4/SEB 4	Dim. probe - Aom. prüfkopf - Dim. Palpeur 6x20mm	Frequency - Frequenz - Fréquence 3MHz/4MHz	Angle - Einschallwinkel - Angle -
Couplant - Ankopplung - Couplage Water	Notes - Bemerkung - Remarques		

**SETTINGS**

Reference method - Bezugsmethode - Methode de référence Backwall-Reflection (BR)	Ref. level - Bezugshöhe - Eche de référence TVG/DAC	
Sensitivity - Empfindlichkeit - Sensibilité Reference level +6dB	Scanning rate - Prüfungsgeschwindigkeit - Vitesse d'essai ≤150 mm/s	Pulse energy - Impulsstärke - Puissance 1
Notes - Bemerkung - Remarques		

**TESTING CONDITIONS**

Surface condition - Oberfläche - Etat de surface Stainless Steel, Hot rolled, Pickled
Notes - Bemerkung - Remarques

**TEST RESULTS - PRÜFERGEBNISSE - RESULTAT D'ESSAI**

Reporting level - Registrierungsschwelle - Seuil d'enregistrement		
<input checked="" type="checkbox"/> No discontinuity indications above the reporting level - Keinefehler grösser als registrierschwelle - Aucune indications supérieures seuil d'enregistrement	<input type="checkbox"/> See annexure - Siehe anlage - Voir annexe	
<input checked="" type="checkbox"/> Disposition - Beschluss - Evaluation Accepted - Akzeptiert - Approuvé	<input type="checkbox"/> Disposition - Beschluss - Evaluation Rejected - Kassiert - Rébute	<input type="checkbox"/> Further investigation - Weiter untersuchung - Examen supplémentaire
Notes - Bemerkung - Remarques		

**OPERATOR, INSPECTOR - PRÜFER, PRÜFAUFSICHT - OPERATEUR, CONTRÔLEUR**

Testing performed by - Abnahme durch - Opérateur Gunnar Karlsson	Level acc. - Niveau gem. - Niveau s. 2	Sign. 
Testing performed by - Abnahme durch - Opérateur	Level acc. - Niveau gem. - Niveau s. 2	Sign.
Approved by - Akzeptiert von - Approuvé par Outokumpu Stainless/Gunnar Karlsson	Inspector - Prüfaufsicht - Contrôleur	Inspector - Prüfaufsicht - Contrôleur
Position - Stellung - Poste Level 2 acc. to EN 473	Agency - TUO - Agence d'inspection	Agency - TUO - Agence d'inspection
Sign.	Sign.	Sign.
Notes - Bemerkung - Remarques	This certificate is based on internal report - Diesen zeugnis basiert auf dem internen prübericht - Ce certificat est basé sur le procès-verbal interne	No - Nr - No  36030 CALTRANO (VI) ITALY

QUALITY CONTROL SYSTEM DEPARTMENT  
 ACCORDING TO THE ORIGINAL ONE