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Acciaierie Valbruna S.p.A.



QUALITY MANAGEMENT SYSTEM
CERTIFIED BY LLOYD'S REGISTER

261440

CERTIFICATO DI COLLAUDO
ABNAHMEPRUEFZEUGNIS
INSPECTION CERTIFICATE
CERTIFICAT DE RECEPTION
EN 10204 (2004) , 3.1

36100 VICENZA (Italia) - Viale della scienza, 25 z.I.
Stab.: 39100 BOLZANO (Italia) - Via A. Volta, 4

Cliente / Dealer/Purchaser/Cliant
VALBRUNA STAINLESS INC.
2400 TAYLOR STREET WEST
48801-FORT WAYNE, IN 48801-US

Produttore: **ACCIAIERIE VALBRUNA S.P.A.**
Hersteller/Usine producteur

Avviso di Spedizione: D-VI13037231
Lieferanzsper/Peeding ts/B.L.

Certificato nr: MEST445698/2013/
Prüfung/Test/Essai

Conferma ordine nr: EI13009582
Werkz/Our Order/Ret. nr.

Marchio di Fabbrica:
Zeichen des Lieferwerkes
Trade mark
Sigs de l'usine producteur



Stato di fornitura: Forged - Annealed Peeled
Lieferzustand/Delivery state/Etat de livraison

Tipo di Elaborazione: E+AOD
Erzuehnungsart/Mehting process/Mode d'elaboration

Punzone del Collaudatore:
Stampel des Werksachverständigen
Inspector's stamp/Poinçon de l'essayeur

Specifiche:
Anforderungen / Requirements / Exigences

VSI 1. 2205 A
ASME SA479 2010 S32205 A (2)
ASTM A276 2013 S31803 A
ASTM A479 2012 S31803 A
ASTM E582 2005 .

API 6A 20 ANNEX M (0)
ASTM A182 2012B S31803 A (3)
ASTM A276 2013 S32205 A
ASTM A479 2012 S32205 A
NACE MR0175 2009 S31803 A (5)

ASME SA479 2010 S31803 A (1)
ASTM A182 2012B S32205 A (4)
ASTM A370 2012A .
ASTM A923 2008 METHOD C

- (0) ISO 10423:2009 MODIFIED
- (1) SEC.II PT.A 2010 EDITION ADD. 2011a
- (3) For products machined directly from bar refer to ASTM A479.
- (5) ANSVNACE MR0175/ISO 15156-3, second edition 2009-10-15

- (0) ERRATA 1 dated January 2011
- (2) SEC.II PT.A 2010 EDITION ADD. 2011a
- (4) For products machined directly from bar refer to ASTM A479.
- (5) Technical circular 1:2011 Published 2011-06-14

Qualità: 2205/F51/F60
Werkstoff/Grade/Qualité

Marca: V225MN
Markenbezeichnung
Brand/Numero

Tolleranza: -0/+0,0625"
Toleranz/Allowance/Tolérance

Punzonatura: 2205/F51/F60
Kernzeichnung/Marking/Marquage

Pos. nr. Pos. nr. Item nr. Nr. de pozis	Oggetto Objekt Product description Descrip. du produit	Dimensioni - In Abmessungen Dimension Dimension	Lunghezza - In Länge Length Longueur	Colate Schmelze Heat Coulée	Pezzi Stückzahl Pieces Pièces	Peso - LB Gewicht Weight Poids	Lotto nr. Lohnr. Lot nr. Lot nr.
0230	Round	7,0938	138 / 138	261440	1	1.556	316407860

TEST ALLO STATO DI FORNITURA

Test on delivery condition Prüfung auf Lieferzustand produkt test a l'état de fourniture Prueba sobre el material así como entregado

TEST	Provetta/Probando Abmessung/Dimensions Lap. Dim. Dims Inch Dim. Dims Weld Dim. Thickness Lap. dim. mm	°F	Posiz. Boglio Position Position	Snervimento Bredgnesse Yield Stress Unité elastic Rp 0,2% k.s.L	Snervimento Bredgnesse Yield Stress Unité elastic	Resistenza Zugfestigkeit Tensile strength Résistance à traction Rm k.s.L	Allungamento Bruchdehnung Elongation Allongement E 4d %	Strizione Einschnürung Reduction of area Striction RA %	Resistenza Kerbschlagarbeit Impact Value Resistance	Durezza Härte Hardness Dureté HB		
	Valori richiesti 1 Anforderungen/Required values Valeurs dimension	min max		70	-	95	-	25	-	45	-	253
A	12,5	68	L	76		108	43	77			241	

TEST		min	max
A	Delta Ferrite	35,0	55,0
A	Corrosion ASTM A923 "C" mdd	10,00	0,09 mdd

TEST	Provetta/Probando Abmessung/Dimensions Lap. Dim. Dims Inch Dim. Dims Weld Dim. Thickness Lap. dim. mm	°F	Posiz. Boglio Position Position	Resistenza Kerbschlagarbeit Impact Value Resistance KV ft/lbs	Espansione laterale Lateral Expansion Lateral ex Inches			Shear Shear % Shear %				
	Valori richiesti 1 Anforderungen/Required values Valeurs dimension	min max		25	25	25	-	-	-	-	-	
B	10X10	-51	L	69	71	72	0,037	0,038	0,039	50	50	50

1)-Inch/Inch-Messung, T-Transversalquer, Q-Tangenzialtangential

Mechanical properties according to ASTM A370.
Ferrite content tested according to ASTM E562.

Vicenza, 19/12/13 VCC008 (Mod. MCE2)	Il collaudatore di stabilimento / der Werksachverständige / Works inspector / L'agent d'usine <i>M. Rizzotto</i>	Pagina - 1 di 2
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Acciaierie Valbruna S.p.A.



QUALITY MANAGEMENT SYSTEM
CERTIFIED BY LLOYD'S REGISTER

CERTIFICATO DI COLLAUDO ABNAHMEPRUEFZEUGNIS INSPECTION CERTIFICATE CERTIFICAT DE RECEPTION EN 10204 (2004) , 3.1

36100 VICENZA (Italia) - Viale della scienza, 25 z.l.
Stab.: 39100 BOLZANO (Italia) - Via A. Volta, 4

Clienti / Besteller/Purchaser/Client
VALBRUNA STAINLESS INC.
2400 TAYLOR STREET WEST
46801-FORT WAYNE, IN 46801-US

Produttore: **ACCIAIERIE VALBRUNA S.P.A.**
Hersteller/Hersteller/Usine producer

Avviso di Spedizione: D-VI13037231
Lieferungsge/Packing list/S.L.

Ordine nr: 37144 STOCK HOUSTON
Bestel/Your order/Commande

Certificato nr: MEST445698/2013/
Prüfung/Test/Essai

Conferma ordine nr: EH3009592
Werkz/Our Order/Not. nr.

Marchio di Fabbrica:
Zeichen des Werkschwermetzes
Trade mark
Sigle de l'usine producteur



Stato di fornitura: Forged - Annealed Peeled
Lieferzustand/Delivery state/Etat de livraison

Tipo di Elaborazione: E+AOD
Erhitzungsart/Heating process/Mode d'elaboration

Funzione del Collaudatore:
Stempel des Werksschwermetzes
Inspector's stamp/Poligon de l'essayeur

Analisi chimica

Chemische Zusammensetzung/Chemical Analysis/Analyse chimique

Colata / Heat Schmelze/Coûlée	min 35,0 max 36,0	0,030	0,30 0,60	1,30 1,70	22,00 23,00	8,00 9,50	0,50	5,00 6,00	-	-	0,030	0,030	0,010	0,100	0,140 0,200	-
	PRE	C %	Si %	Mn %	Cr %	Mo %	Cu %	Ni %	Co %	Al %	P %	S %	V %	N %		
261440	35,8	0,028	0,50	1,40	22,50	3,16	0,32	5,80	0,083	0,013	0,030	0,001	0,072	0,168		
Colata / Heat Schmelze/Coûlée	min - max 0,100	0,200														
261440		Cb(Nb)% 0,029		Al+Nb+V 0,114												

Furnace monitoring method: thermocouple.
Annealing temperature: 1980 °F for 1 h/H2O.
Micro and macro etch test: OK
Furnace calibrated according to API 6A REV 20th ED ANNEX M.
Corrosion test per ASTM A923 Method C (77F/24h): ok.
Corrosion test per ASTM A923 Method C (26C/24h): ok.
Material is DFARS Compliant

ALLEGATI Anlagen Enclosure P.I. :

UT13007320

Tab N.ro 1	Inclusion Rating	A	B	C	D
	Thin	0	1,5	0	1,5
	Heavy	0	1,0	0	1,5

Sono state soddisfatte tutte le condizioni richieste
Die gesamte Anforderungen sind lt. Anlage erfüllt
The material has been furnished in accordance with the requirements
Le matériel a été trouvé conforme aux exigences

Controllo antimescolanza: OK
Verwechslungsprüfung: spektroskopisch durchgeführt
Anfröhring testing performed: OK
Contrôle antimeslange test: r.a.s.

Controllo visivo e dimensionale: soddisfa le esigenze
Beobachtung und Ausmessung: ohne Beanstandung
Visual inspection and dimensional checks: satisfactory
Contrôle visuel et dimensionnel: satisfaisant

Melted and manufactured in Italy No welding or weld repair Material free from Mercury contamination
We declare that the finished product is checked for radioactive contamination through Portal System when it leaves the production plant.

The Quality Management System is Certified acc. Pressure Equipment Directive (97/23/EC) Annex 1, s. 4.3 by TUEV and LLOYD'S

Any act of tampering, modification, alteration, counterfeiting and/or falsification and/or any other action which modifies the contents of this test certificate shall constitute a violation of applicable civil and criminal laws. Acciaierie Valbruna shall protect its rights and interests before any competent court, authority and jurisdiction.

The supplied product conforms to requirements expressly requested by the purchaser and conforms to requirements specified by certified norms and standards. Should the product be used for more severe, critical and/or in any case different applications than those the material is generally intended for, any different and/or supplementary requirements shall be specifically demanded, at least, upon order of the Product by the Purchaser. Acciaierie Valbruna SpA shall not be responsible for any improper use of the Products.

Vicenza, 19/12/13

V00006
(Mod. MCE2)

Il collaudatore di stabilimento / der Werksschwermetzes / Works inspector / L' agent d' usine

M. Rizzotto

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Acciaierie Valbrunas.p.A.

35100 VICENZA (Italia) - Viale della Scienza, 25 z.l.

CERTIFICATO Certificate - Zeugnis - Certificat N° UT13007320

CONTROLLO CON ULTRASUONI

Ultrasonic testing - Ultraschallprüfung - Contrôle par ultrasons

mod. UT02

Cliente : VALBRUNA STAINLESS INC.

Customer - Besteller - Client

Lotto nr : 316407860

Mill order - Uns.Auftr. - A/R

MARCA Grade Qualität Nuance	DIMENSIONI - In Size Abmessungen Dimensions	COLATA Heat Schmelze Coulée	BARRE Bars Stäbe Barres	PESO Weight Gewicht Poids	LUNGHEZZA - In Length Länge Longueur
V225MN	Round 7,0938	281440	N. 1	LB : 1.556	138 138
T. TERMICO H.Treatment Wärmebehandlung T.Termique		ESECUZIONE Condition Ausführung Execution		RUGOSITÀ Roughness Rauigkeit Rugosité	
Annealed		Peeled		< 6 µm	
			TOLLERANZA Tolerance Tolérance Tolérance		
			-0/+0,0625"		

Riferimento : PROC CND 040

According to - Nach - Selon

Normativa : ASTM A388

Regulations - Vorschrift - Règlements

SONDE Probes Prüfköpfe Palpeurs	TIPO ONDA Type of wave Wellenart Type d'onde	MHZ MHz MHz MHz	DIMENSIONI Dimension Abmessungen Dimensions	ANGOLO Angle Winkel Angle
64 ELEMENT	LONG.	2,25	128X25	0°

STRUMENTO : OLYMPUS PHASE ARRAY

Equipment - Gerät - Appareil

ACCOPIANTE : WATER + 0253 SA

Couplant - Koppelmittel - Couplage

VEL.CONTROLLO : 20 m/min

Scanning rate - Prüfgeschwindigkeit - Vitesse d'essai

COEFFICIENTE ATTENUAZIONE :

Attenuation - Schallschwächungskoeff. - Coefficient d'atténuation

SONDA LW	DAC-DAK-CAD	[X]	FBH-KSR-FFP	SONDA SW	DAC-DAK-CAD	FBH-KSR-FFP
	ECO DI FONDO Back reflect - Rückwendebo - Echo du fond	AVG-DGS				AVG-DGS

CONTROLLO AUTOMATICO [X]

Automating scanning - Automatische Prüfung - Contrôle automatique

CONTROLLO MANUALE

Manual scanning - Manuelle Prüfung - Contrôle manuel

NOTE DEL CONTROLLO :

Notes result - Prüfungsbemerkungen - Notes d'essai

CONFORME [X]

Compliant - Konform - Conforme

NON CONFORME []

Not Compliant - Nicht Konform - Pas Conforme

ISPEZIONATO DA

Inspected by

VERIFICATO DA

Verified by

S.Stefani
EN 473/ISO 9712.
LEV. 2
N. 2772.

APPROVATO DA

approved by

COLLAUDATORE

Inspector - Abnahmesachsverst -
Inspecteur

FIRMA

DATA : 19/12/13

Date - Date

FIRMA

FIRMA