

C123459



COGNE ACCIAI SPECIALI S.p.a.

11100 AOSTA - VIA PARAVERA, 16  
TEL +39.0165.3021 - FAX +39.0165.302286  
CAP. SOC. 100.000.000 EUR INT. VERS.  
C.F. 02187350967  
VAT: IT00571320076 - R.E.A. n. AO-50474

Company with management systems IGO  
approved and certified according to ISO 9001,  
ISO/TS 16949 e ISO 14001.

INSPECTION CERTIFICATE 3.1 (EN 10204:2004)  
(A03) DOCUMENT NUMBER 2015001352  
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(A06) CUSTOMER : COGNE SPECIALTY STEEL USA, INC  
(A07) CUSTOMER'S ORDER : ASA P033724  
(A01) MANUFACTURER'S WORKS : AOSTA, VIA PARAVERA 16 - ITALY  
(A05) PRODUCER OF THE DOC: QUALITY DEPARTMENT  
(A08) MANUFACTURER'S WORKS ORDER NO: 25184819 /30 (A04) MARK OF THE MANUFACTURER : COGNE  
(A09) DISPATCH NOTE : 80942088 /10 (B14) WEIGHT : 10,811.29  
THE CERTIFIED PRODUCTS ARE COMPLYING TO THE PURCHASE ORDER

INTERNAL SPEC. : AMSQSQS763\_API6A  
(B01) PRODUCT : 51209 SPE ROUGHPEELED ROUND BARS TOLERANCE : + 0,0985 - 0  
(B03) SURFACE FINISH :  
(B04) PRODUCT DELIVERY CONDITION: RS SOLUTION ANNEALED  
(B09) PRODUCT DIMENSIONS (Inch): 11.000 (B10) LENGTH (inch) 00120 /00168  
(B02) GRADE : AISI 316/316L - UNS31600/31603 INTERNAL GRADE : F316L IMCO  
(B07) IDENTIFICATION HEAT NO: 401668 (B07) IDENTIFICATION LOT NO.: 561100  
(B06) MARKING OF THE PRODUCT : 316L TEST PIECE N. : 110

REFERENCE NORMS: ASTM A276, ASTM A479, ASTM A484, ASTM A193B8MCL1, ASME SA276, ASME SA479, ASME SA484, ASME SA193B8MCL1, AMS-QQS-763(replacing FEDQSQS763 on 7/1/98), AMS 5653F, AMS 5648K, NACE MR0175/ISO15156-3, NACE MR0103, NORSOK MDSS01Rev3, EN 10272.

REFERENCE NORMS FOR CHEMICAL COMPOSITION AND MECHANICAL PROPERTIES: ASTM A182/ASME SA182, ASTM A314, EN 10222-5. AISI 316/316L UNS S31600/S31603, EN 1.4401/1.4404.

SOLUTION TREATED AT 1050°C / 1 min x mm / WATER.

STEELMAKING AEF + AOD

QTC ON PROLONGATION OF BARS TESTS AT MID RADIUS (CENTER POS. FOR SIZES <2 INCHES).

HOT FORGED

REDUCTION RATIO 7.0  
INITIAL STATUS 0.0

(C71) CHEM. COMP. - LADLE ANALYSIS ACCORDING ASTM E1019-A751-E1086-E415-A580

Control lot No. - Weight : 020000555242 - 95,900 KG  
ELEMENTS C Si Mn P S N Cr Mo Ni Cu  
OBTAINED 0.028 0.36 1.77 0.027 0.025 0.074 17.05 2.08 10.20 0.30  
ELEMENTS Co  
OBTAINED 0.18

HARDNESS TEST IN AS DELIVERED CONDITION

Control lot No. - Weight : 020000555422 - 5,958 KG  
SPECIFICATION ASTMA370-E10 HARDNESS TEST HB TESTING METHOD : 10/3000  
OBTAINED 166

IMPACT TEST IN AS DELIVERY CONDITION

Control lot No. - Weight : 020000555422 - 5,958 KG  
SPECIFICATION EN ISO 148-1-KV2 (C02) DIRECTION OF THE TEST PIECE: T  
(C40) TYPE OF TEST PIECE KV  
(C03) TEST TEMPERATURE °C 20  
MEASUREMENT UNIT J  
OBTAINED 280 282 277

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GRAIN SIZE  
Control lot No. - Weight :020000555422 - 5,958 KG  
SPECIFICATION ASTME112 --  
OBTAINED 4 6

HEAT TREATMENT PERFORMED IN CALIBRATED FURNACES ACCORDING TO INTERNAL PROCEDURE PR-GDQ.ITT COMPLYING WITH API6A.  
CORROSION TEST ACCORDING TO ASTM A262 Practice E EN ISO 3651-2: SATISFACTORY.  
SURFACE CONTROL BY VISUAL INSPECTION: CONFORMING.  
DIMENSIONAL CONTROL ACCORDING TO ASTM A484: CONFORMING.  
ULTRASONIC TEST ACCORDING TO EN 10308 Class.3, equivalent to  
ASTM A388 FBH5 (for size <=250 mm) and FBH8 (sizes >250 mm): SATISFACTORY.  
ANTIMIX TEST: SATISFACTORY.

TENSILE TEST  
Control lot No. - Weight :020000555422 - 5,958 KG  
SPECIFICATION ASTMA370-EB-0.5"SPEC (C02) DIRECTION OF THE TEST PIECE: T

MEASUREMENT UNIT	Rm B KSI	Rp02_B KSI	Z B %	A12 B %
OBTAINED	82	39	81.6	4,0 D 65.0

NO WELDING REPAIR ON THE MATERIAL  
MARKING: PRODUCER LOGO, MATERIAL NO, HEAT NO, LOT NR.  
THE PRODUCT SATISFIES CE DIRECTIVES: 2011/65 - 2000/53 2002/95(RoHS) 2003/11 - 2005/618 AND PED 97/23/EC.  
THE MATERIAL IS FREE OF ANY MERCURY, MERCURY COMPOUNDS AND OR RADIUM CONTAMINATION AT TIME OF SHIPMENT AND WAS PRODUCED WITHOUT  
USING OZONE DEPLETING SUBSTANCES OF CLASS I AND II.  
QUALITY SYSTEM CERTIFIED BY I.G.Q ACCORDING TO UNI EN ISO  
9001:2008 - ISO/TS 16949:2009 (THE LAST ONE ONLY FOR HOT ROLLED-PEELED-GROUND, STAINLESS STEEL BARS AND ATOMIZED METALLIC POWDERS).  
ALL THE NORMS MENTIONED ARE INTENDED IN THEIR LATEST REVISION AT THE DATE OF ISSUE OF THIS DOCUMENT.  
COUNTRY OF ORIGIN: ITALY, THE MATERIAL COMPLIES WITH FAR DFARS  
252.225-7009 ALT 1.  
THE ABOVE ARE TRUE AND CORRECT RESULTS OF TESTS ON SAMPLES OF THE MATERIAL. RESULTS ARE CONFORM TO THE SPECIFICATION(S) APPLICABLE  
AND ARE RECORDED.  
THE RECORDING OF FALSE, FICTIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THIS DOCUMENT MAY BE PUNISHABLE AS A FELONY UNDER U.S.  
FEDERAL STATUTES.  
SOLUTION TREATED AT 1050°C +-15°C / 1 min x mm / WATER.