



A04

Tata Steel UK Limited

20" H.F.I Mill
Brenda Road
Hartlepool Cleveland UK TS25 2EG

A01

Telephone: + 44 (0) 1429 266611
Email: tubesalesUK@tatasteelurope.com

INSPECTION CERTIFICATE

EN10204 Type 3.1

A02

Page No. 01 of 03

Date	31/01/25	Z02
Cert No.	280/2505/0356	A03
Del. Note		

Customer	A06
TATA INTERNATIONAL METALS (AMERICAS) LIMITED	
475 NORTH MARTINGALE ROAD SUITE 400 SCHAUMBURG ILLINOIS 60173, USA	

Quality Management System
Approved to ISO 9001

Tata Steel Ref.No.	GXM447420	Works	7359	A08
Sales				
Customer Order No.	P/O: PUR3002755 OF 04/SEP/24			A07
Product Description HIGH FREQUENCY INDUCTION WELDED STEEL TUBES GRADE X65M TO API 5L 46TH EDITION, PSL2. MEETS THE REQUIREMENTS OF EN ISO 15156-2 / NACE MR0175 ANNEX A.2 AND EN ISO 17945 / NACE MR0103 13.1.1. CHARPY IMPACT TESTED ON ALL HEAT NUMBERS AT +32 DEGREES FAHRENHEIT (0 DEGREES CELSIUS) ON THE PIPE BODY. WELD SEAM ULTRASONICALLY TESTED.				

L=Longitudinal		T=Transverse	B=Body	W=Weld	KV=Charpy	V-Notch	HV=Hardness Vickers(10Kg Load)		DT=Drop Weight Tear Test									
Item No.	B08	B09-B12			B07	Pipe No.	Tensile Test				Impact/Hardness Tests					Steel Making Process		C70
	Number of Pieces	Product Dimensions (in)	Cast/Heat No.	Yield Stress Re (psi)	Tensile Strength Rm (psi)		Elong A% 2IN	Hydro Pressure (psi)	C01 C02	C40 C30 Test Type	C41 Width (mm)	C03 Temp (C)	C42 C31 Values Ft Lb	C43 C32 Ave Ft Lb			C50-C69 D02-D99	
															Other Tests			
															FLATTENING TEST SATISFACTORY ULTRASONIC TESTS SATISFACTORY TENSILE TEST PIECE: RECTANGULAR 330MM X 38.1MM X ACTUAL WALL THICK BODY CVN:15FT-LB AVE / 12FT-LB IND (MIN) UT REF INDICATOR:OD/ID LONGITUDINAL NOTCHES N10. WELD SEAM NORMALISED 900C MIN. CE (PCM): 0.25% MAX IF C=< 0.12% CE (IIW): 0.43% MAX IF C> 0.12% STEELMAKING/COIL ROLLING: TATA STEEL PORT TALBOT UK PIPE MANUFACTURING: TATA STEEL HARTLEPOOL UK COUNTRY OF MELT AND POUR: UK			

C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	B	CU	N	CA	NB	SN	TI	V	CEV			
Cast No.																						

Code Numbers in accordance with EN 10168 (see overleaf).
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CE & UKCA marking under the CPR 305/2011/EU and S.I. 2019 No. 456 respectively shown on Hartlepool 20" mill inspection documents are affixed according to harmonized standards EN 10210-1 & EN 10219-1 only.
Hartlepool 20" mill Quality System complies with Annex 1 para 4.3 of 2014/68/EU (PED) and S.I. 2016 No. 1105.
Note - only tubes in accordance with EN 10217 (TR1 grades excluded) have a presumption of conformity with the PED.

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CHRIS STEVENS
Section Manager Technical
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18 Grosvenor Place London SW1X 7HS Company Reg.No.02280000.

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							C01 C02 C10	C11 Yield Stress Re (psi)	C12 Tensile Strength Rm (psi)	C13 Elong A% 2IN	D02 Hydro Pressure (psi)	C01 C02	C40 C30 Test Type	C41 Width (mm)	C03 Temp (C)	C42 C31 Values Ft Lb	C43 C32 Ave Ft Lb	C50-C69 D02-D99				
							Other Tests															
11	30	18.000IN OD X 0.375IN 42' 0"-43' 6" 1279'10"			7T33654	0315205	W T B T	69908 RATIO	100656 95580 .73	31	2320 5.0 SECS	T B T B T B T B	KV KV KV KV	7.5 7.5 7.5 7.5	00 -46 00 -46	69 66 62 56 48 43 59 58 57 33 40 46	66 49 58 40	% SHEAR = 100:100:100 = 100 % SHEAR = 085:070:070 = 075 % SHEAR = 100:100:100 = 100 % SHEAR = 080:090:095 = 088				

C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	B	CU	N	CA	NB	SN	TI	V	CEV	PCM		
Cast No.																						
7T33654 LADLE		.11	.199	1.56	.012	.002	.019	.001	.011	.039	.0002	.010	.0057	.000	.047	.002	.003	.058	.38	.20		
7T33654 PROD		.11	.202	1.58	.012	.001	.020	.002	.012	.043	.0003	.010	.0058	.000	.050	.002	.003	.062	.39	.21		
7T33654 PROD		.11	.201	1.57	.011	.001	.019	.003	.012	.043	.0004	.010	.0049	.000	.050	.002	.003	.061	.39	.21		
7T33658 LADLE		.10	.200	1.47	.013	.002	.061	.001	.016	.034	.0002	.032	.0043	.000	.044	.003	.003	.057	.37	.19		
7T33658 PROD		.11	.202	1.51	.013	.001	.058	.003	.018	.035	.0003	.034	.0041	.000	.049	.003	.002	.061	.39	.20		
7T33658 PROD		.11	.203	1.51	.013	.001	.058	.003	.018	.035	.0003	.034	.0038	.000	.049	.003	.002	.061	.39	.21		

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															Other Tests				
11	13	18.000IN OD X 0.375IN 42' 0"-43' 6" 544' 0"	7T33658	0315505	W T B T	68748 RATIO	96015 .72	32	2320 5.0 SECS	T B T B	KV	7.5	00	48 56 52	52	% SHEAR = 095:100:100 = 098			
11	13	18.000IN OD X 0.375IN 42' 0"-43' 6" 555' 0"	7T33773	0315407	W T B T	71939 RATIO	100366 .72	26	2320 5.0 SECS	T B T B	KV	7.5	00	27 27 27	27	% SHEAR = 100:090:080 = 090			
																% SHEAR = 100:100:100 = 100			
																% SHEAR = 075:070:070 = 072			
***	*****	*****	*****	*****	*****	END OF TEST CERTIFICATE			*****	*****	*****	*****	*****	*****	*****				

C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	B	CU	N	CA	NB	SN	TI	V	CEV	PCM		
Cast No.																						
7T33773 LADLE		.11	.165	1.53	.017	.006	.045	.001	.023	.040	.0002	.052	.0031	.000	.044	.002	.001	.061	.39	.21		
7T33773 PROD		.11	.165	1.55	.016	.005	.044	.004	.024	.042	.0002	.053	.0024	.000	.046	.003	.001	.063	.40	.21		
7T33773 PROD		.11	.164	1.53	.015	.004	.043	.004	.025	.043	.0002	.053	.0029	.000	.044	.003	.001	.063	.40	.21		

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