

Z02
A05

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Fax: +44 (0)1429 527344

Date	07/08/19	Z02
Cert No.	340/1932/0004	A03
Del. Note		

Page No. 2 of 2

Customer A06

Liberty Pipes Ref.No.		Sales		LPH190174		Works		50075/		1		A08	
Customer Order No.				Customer Reference								A07	
PO PII LIB 0004				EXXON MOBIL PII. PO 4540187138									
Product Description and Dimensions												B01-B04 B09-B12	
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCr PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T													

B06/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

B07 Cast/Heat No.	Pipe No.	C00 Test Piece No.	Tensile Test										Impact/Hardness Tests							Steel Making Process		C70		
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	Ratio Re/ Rm	B05	D02 Hydro Pressure PSI	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	C42 C31 Values F/LB			C43 C32 Ave F/LB	B05		BOS	
																	Other Tests		C50-C69 D02-D99					
471627											2320	HAZ	T	KVE KVF	0.39	32	309 305 306 100 100 100	307 100						
XX																								

C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 471627	LADLE	.08	.31	1.66	.012	.001	.045	.014	.036	.034	n/a	.0001	.0017	n/a	.022	n/a	.0038	.035	.017	.001	n/a	n/a	.18	.37
Plate No. 2421871	PLATE	.07	.29	1.59	.011	.001	.042	.009	.033	.032	n/a	.0002	.0017	n/a	.019	n/a	.0034	.032	.016	.001	n/a	n/a	.17	.35
2421881	PLATE	.08	.28	1.60	.012	.001	.042	.010	.034	.031	n/a	.0002	.0018	n/a	.019	n/a	.0036	.033	.017	.001	n/a	n/a	.17	.36

Code Numbers in accordance with EN10168 (see overleaf).

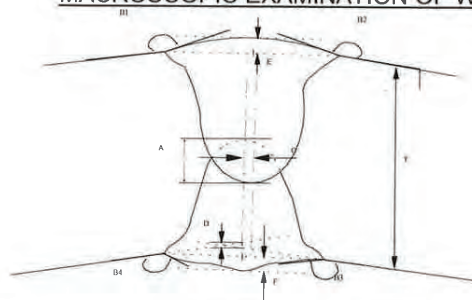
Alteration to this document or its use for other products shall be regarded as falsification of documents and be subject to criminal jurisdiction.

The products covered by this inspection document are certified by Liberty Pipes Limited and comply with the requirements of the Product Description.
A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd. Notified body No. 0041 and has been found to meet the requirements of PED (2014/68/EU).

Z01	D.Williams Manager - SAW Mills Quality	Z02 A05
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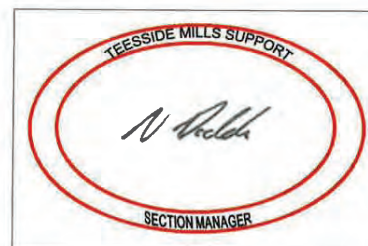
VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01654	471627	L M COX	26/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
3.5 mm	160.9 Degrees	159.4 Degrees	158.7 Degrees	167.6 Degrees	1 mm	0.7 mm	2.7 mm	2.0 mm



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The Special Managers, their firm, partners, employees, advisers, representatives and agents and the Official Receiver as liquidator shall incur no personal liability under, or by virtue of, this document, nor in relation to any related matter or claim howsoever, whenever, and wherever arising, and whether such claim is formulated in contract and/or tort or by reference to any other remedy or right, and in whatever jurisdiction or forum. No liability (whether based in tort or contract or statute or otherwise) including, without limitation, any liability in connection with non-performance or breach or termination (whether by repudiation, disclaimer or otherwise), or any penalty or liability for liquidated damages, arising from actions or inactions of either the Official Receiver as liquidator or the Special Managers shall give rise to any liquidation expenses unless expressly accepted in writing.

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Date	07/08/19	Z02
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Page No. 1 of 2

Customer

Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/	1	A08
Customer Order No.			Customer Reference			A07
PO PII LIB 0004		EXXON MOBIL PII. PO 4540187138				
Product Description and Dimensions						B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCr PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T						

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPV HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged																					
B07 Cast/Heat No.	Pipe No.	C00 Test Piece No.	Tensile Test								Impact/Hardness Tests						Steel Making Process		C70		
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	R05 Ratio Re/Rm	D02 Hydro Pressure PSI	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	Values F/LB		C42 C31 F/LB	C43 C32 Ave F/LB	B05 Other Tests	C50-C69 D02-D99
471632	DWM 01822		B W	T T	S S	75127	91080 91516	36.82		2320	BM	T	KVE	0.39	32	326	324	327	326	ADDITIONAL INFORMATION ON S.O.C. RADIOGRAPHY AND UST SATISFACTORY TBT- 180 FROM LONGITUDINAL WELD 2.76 INS X 1.50 INS. X ACTUAL W.T. BO- 90 FROM LONGITUDINAL WELD BO.CVN.30 AVE.22 IND.(MIN) (FT LBS) WELD/HAZ 30 AVE 22 IND(MIN) (FT LBS) FORWARD&REVERSE BENDS SATISFACTORY HARDNESS AND MACRO SATISFACTORY ALL CHEMICAL COMBINATIONS COMPLY. CHEM ANALYSIS '---' = TRACE VALUES	
											BO	T	KVE	0.39	32	324	316	326	322		
											CLM	T	KVE	0.39	32	120	119	123	121		
												T	KVF			95	95	95	95		
											CLO	T	KVE	0.39	32	122	112	117	117		
												T	KVF			95	90	95	93		
											FLM	T	KVE	0.39	32	162	310	321	265		
												T	KVF			70	100	100	90		
											F2M	T	KVE	0.39	32	308	311	305	308		
												T	KVF			100	100	100	100		
											F5M	T	KVE	0.39	32	325	322	322	323		
													T	KVF			100	100	100	100	

Intertek

☐ Reviewed

☒ Witnessed

Initial: *[Signature]*

Date: *7.8.9.*

G3 - 0160

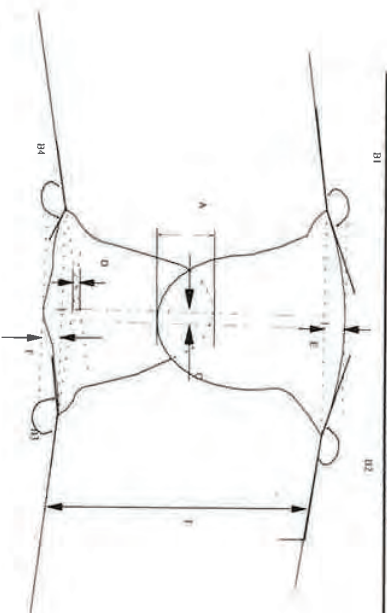
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C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 471632	LADLE	.08	.32	1.65	.010	.001	.043	.013	.043	.038	n/a	.0001	.0015	n/a	.026	n/a	.0035	.036	.015	.001	n/a	n/a	.18	.37
Plate No. 2421691	PLATE	.07	.31	1.60	.009	---	.038	.009	.039	.042	n/a	.0002	.0015	n/a	.026	n/a	.0032	.034	.015	.001	n/a	n/a	.17	.35
2421711	PLATE	.07	.30	1.61	.009	---	.038	.009	.038	.042	n/a	.0001	.0015	n/a	.026	n/a	.0035	.034	.015	.001	n/a	n/a	.16	.35

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VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01822	471632	L M COX	31/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (OD)	4.5mm MAX
F = WELD RE-INFORCEMENT (ID)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
4.2 mm	155.9 Degrees	156.5 Degrees	160.3 Degrees	152.4 Degrees	1 mm	0.0 mm	2.6 mm	2.2 mm

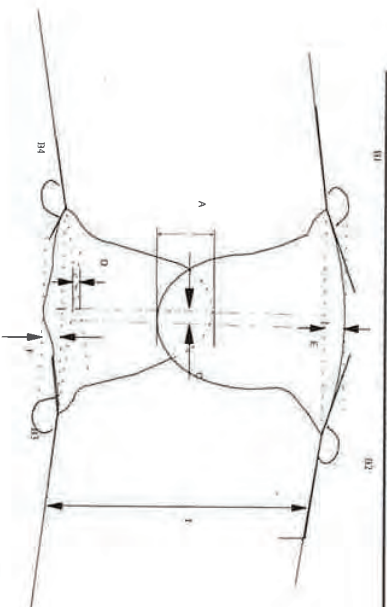
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 Testing Solutions Teesside



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VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01538	471631	L M COX	29/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (OD)	4.5mm MAX
F = WELD RE-INFORCEMENT (ID)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
4.2 mm	156.8 Degrees	158.1 Degrees	168.3 Degrees	160.2 Degrees	1 mm	0.7 mm	2.8 mm	1.7 mm



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A02

Page No. 1 of 2

Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/	1	A08
Customer Order No.			Customer Reference			A07
PO PII LIB 0004		EXXON MOBIL PII. PO 4540187138				
Product Description and Dimensions						B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCr PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T						

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged																					
B07 Cast/Heat No.	Pipe No.	C00 Test Piece No.	Tensile Test								Impact/Hardness Tests									Steel Making Process	
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	Ratio Re/Rm	B05	D02 Hydro Pressure PSI	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	C42 C31 Values F/LB	C43 C32 Ave F/LB	B05	BOS	Other Tests
471630	DWM 01560		BW	T	S	76432	92821 93836	34.82			2320	BM	T	KVE	0.39	32	316 141 129	195			ADDITIONAL INFORMATION ON S.O.C. RADIOGRAPHY AND UST SATISFACTORY TBT- 180 FROM LONGITUDINAL WELD 2.76 INS X 1.50 INS. X ACTUAL W.T. BO- 90 FROM LONGITUDINAL WELD BO.CVN.30 AVE.22 IND.(MIN) (FT LBS) WELD/HAZ 30 AVE 22 IND(MIN) (FT LBS) FORWARD&REVERSE BENDS SATISFACTORY HARDNESS AND MACRO SATISFACTORY ALL CHEMICAL COMBINATIONS COMPLY. CHEM ANALYSIS '---' = TRACE VALUES
												BO	T	KVE	0.39	32	100 100 100	100			
												CLM	T	KVE	0.39	32	100 100 100	100			
													T	KVF			108 119 125	117			
													T	KVF			90 90 95	92			
													T	KVE	0.39	32	119 111 125	119			
													T	KVF			90 80 90	87			
													T	KVE	0.39	32	313 326 306	315			
													T	KVF			100 100 100	100			
													T	KVE	0.39	32	293 305 312	303			
													T	KVF			100 100 100	100			
													T	KVE	0.39	32	320 318 313	317			
													T	KVF			100 100 100	100			

C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 471630	LADLE	.08	.31	1.65	.013	.001	.043	.009	.036	.035	n/a	.0003	.0017	n/a	.040	n/a	.0032	.036	.017	.001	n/a	n/a	.18	.37
Plate No. 2421521	PLATE	.08	.31	1.59	.013	.001	.040	.009	.033	.038	n/a	.0003	.0017	n/a	.036	n/a	.0067	.035	.016	.001	n/a	n/a	.18	.36
2422141	PLATE	.07	.32	1.63	.011	---	.038	.008	.045	.035	n/a	.0002	.0016	n/a	.045	n/a	.0046	.035	.014	.002	n/a	n/a	.17	.36

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Hartlepool UK TS25 2EF

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INSPECTION CERTIFICATE

EN10204 Type 3.1

A02

Date	07/08/19	Z02
Cert No.	340/1932/0007	A03
Del. Note		

Page No. 2 of 2

Customer A06

Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/	1	A08
Customer Order No.	Customer Reference					A07
PO PII LIB 0004		EXXON MOBIL PII. PO 4540187138				
Product Description and Dimensions						B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCR PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T						

B06/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VHN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

B07 Cast/Heat No.	Pipe No.	C00 Test Piece No.	Tensile Test									Impact/Hardness Tests						Steel Making Process		C70	
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	Ratio Re/ Rm	B05	D02 Hydro Pressure PSI	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	C42 C31 Values F/LB	C43 C32 Ave F/LB	B05		BOS
																					Other Tests
471630											2320	HAZ	T	KVE KVF	0.39	32	287 306 305 100 100 100	299 100			
XX																					

C71-C99		Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 471630	LADLE	.08	.31	1.65	.013	.001	.043	.009	.036	.035	n/a	.0003	.0017	n/a	.040	n/a	.0032	.036	.017	.001	n/a	n/a	.18	.37	
Plate No. 2421521	PLATE	.08	.31	1.59	.013	.001	.040	.009	.033	.038	n/a	.0003	.0017	n/a	.036	n/a	.0067	.035	.016	.001	n/a	n/a	.18	.36	
2422141	PLATE	.07	.32	1.63	.011	---	.038	.008	.045	.035	n/a	.0002	.0016	n/a	.045	n/a	.0046	.035	.014	.002	n/a	n/a	.17	.36	

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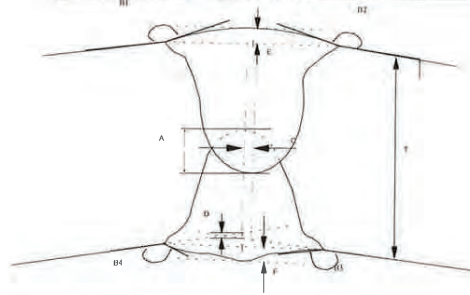
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A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd. Notified body No. 0041 and has been found to meet the requirements of PED (2014/68/EU).

Z01 D.Williams
Manager - SAW Mills Quality

Z02
A05

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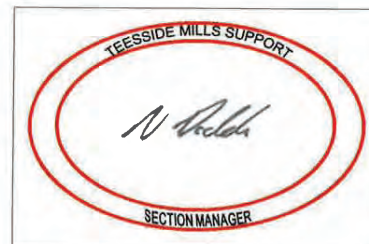
VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01560	471630	L M COX	23/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
3.5 mm	153.7 Degrees	159.2 Degrees	160.1 Degrees	162.2 Degrees	1 mm	0.5 mm	2.6 mm	1.9 mm



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 Testing Solutions Teesside

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Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/	1	A08
Customer Order No.	Customer Reference					A07
PO PII LIB 0004			EXXON MOBIL PII. PO 4540187138			
Product Description and Dimensions						B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCr PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T						

B06/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VHN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

B07 Cast/Heat No.	Pipe No.	C00 Test Piece No.	Tensile Test								D02 Hydro Pressure PSI	Impact/Hardness Tests						Steel Making Process		C70
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	B05 Ratio Re/ Rm	C01		C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	C42 C31 Values F/LB	C43 C32 Ave F/LB	B05 Other Tests	C50-C69 D02-D99	
471635									2320	HAZ	T	KVE	0.39	32	314 308 307	310				
XX END OF TEST CERTIFICATE XX																				
intertek ☐ Reviewed ☒ Witnessed Initial: <i>Rui</i> Date: <i>2.8.19</i> GB - Q160																				

C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 471635	LADLE	.08	.32	1.64	.010	.001	.042	.010	.031	.032	n/a	.0001	.0013	n/a	.028	n/a	.0035	.035	.015	.001	n/a	n/a	.18	.37
Plate No. 2421731	PLATE	.07	.31	1.60	.010	.001	.039	.009	.039	.034	n/a	.0002	.0013	n/a	.028	n/a	.0038	.033	.014	.001	n/a	n/a	.17	.35
2422091	PLATE	.08	.31	1.59	.010	.001	.041	.009	.033	.033	n/a	.0002	.0012	n/a	.028	n/a	.0043	.032	.014	.001	n/a	n/a	.17	.35

Code Numbers in accordance with EN10168 (see overleaf).

Alteration to this document or its use for other products shall be regarded as falsification of documents and be subject to criminal jurisdiction.

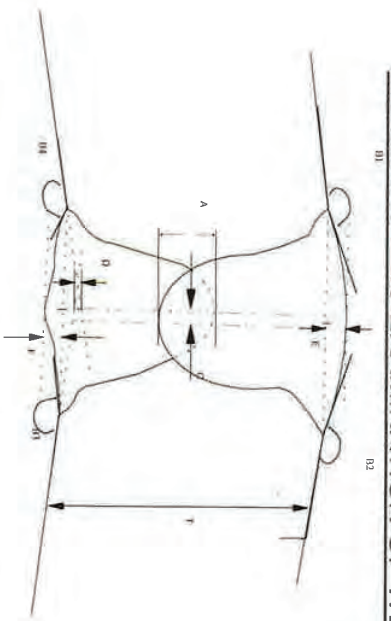
The products covered by this inspection document are certified by Liberty Pipes Limited and comply with the requirements of the Product Description.
A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd. Notified body No. 0041 and has been found to meet the requirements of PED (2014/68/EU).

Z01 D.Williams
Manager - SAW Mills Quality

This document has been prepared by a computer system and is valid without signature.

Z02
A05

VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01726	471635	L M COX	29/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
4.4 mm	151.8 Degrees	156.0 Degrees	161.5 Degrees	164.4 Degrees	0 mm	0.6 mm	3.1 mm	2.3 mm

British Steel Ltd (In Compulsory Liquidation)
 Testing Solutions Teesside

N. Mills
 SECTION MANAGER

Intertek
☒ Reviewed
☐ Witnessed
 Initial: *LMC*
 Date: *28.8.19*
 GB - 0160

The Special Managers, their firm, partners, employees, advisers, representatives and agents and the Official Receiver as liquidator shall incur no personal liability under or by virtue of this document, nor in relation to any related matter or claim whatsoever, whenever, and wherever arising, and whether such claim is formulated in contract and/or tort or by reference to any other remedy or right, and in whatever jurisdiction or forum. No liability (whether based in tort or contract or statute or otherwise) shall arise, without limitation, any liability in connection with non-performance or breach or termination (whether by repudiation, disclaimer or otherwise), or any penalty or liability for liquidated damages, arising from actions or omissions of either the Official Receiver as liquidator or the Special Managers shall give rise to any liquidation expenses unless expressly accepted in writing.

Telephone: +44 (0)1429 266611
Fax: +44 (0)1429 527344

Page No. 2 of 2

Customer	A06
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Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/	1	A08
Customer Order No.	Customer Reference					A07
PO PII LIB 0004		EXXON MOBIL PII. PO 4540187138				
Product Description and Dimensions						B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCr PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T						

B06/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

B07 Cast/Heat No.	Pipe No.	C00 Test Piece No.	Tensile Test								B05	D02 Hydro Pressure PSI	Impact/Hardness Tests						Steel Making Process		C70
			C01	C02	C10	C11	C12	C13	Ratio Re/ Rm	C40 C30 Test Type			C41	C03	C42 C31 Values F/LB	C43	B05	BOS			
			Yield Stress Re PSI	Tensile Stress Rm PSI	Elong A% 2*	Width (in)	Temp (°F)	Ave F/LB					Other Tests	C50-C69 D02-D99							
471636										2320	HAZ	T	KVE KVF	0.39	32	223 218 235 100 100 100	225 100				
XX																					

C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 471636	LADLE	.08	.32	1.66	.012	.001	.043	.008	.031	.039	n/a	.0002	.0015	n/a	.033	n/a	.0039	.036	.014	.001	n/a	n/a	.18	.37
Plate No. 2421891	PLATE	.08	.31	1.63	.011	.001	.041	.006	.032	.041	n/a	.0003	.0015	n/a	.034	n/a	.0042	.035	.015	.001	n/a	n/a	.18	.37
2422201	PLATE	.08	.31	1.63	.011	.001	.041	.006	.032	.042	n/a	.0003	.0014	n/a	.034	n/a	.0044	.035	.015	.001	n/a	n/a	.18	.37

Code Numbers in accordance with EN10168 (see overleaf).

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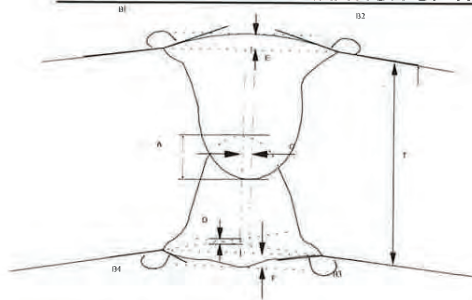
The products covered by this inspection document are certified by Liberty Pipes Limited and comply with the requirements of the Product Description.
A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd. Notified body No. 0041 and has been found to meet the requirements of PED (2014/68/EU).

Z01 D.Williams
Manager - SAW Mills Quality

Z02
A05

This document has been prepared by a computer system and is valid without signature.

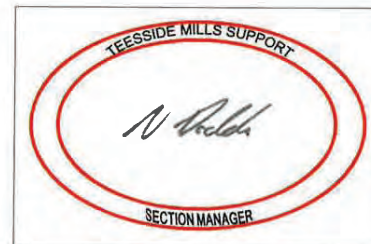
VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01554	471636	L M COX	23/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
3.7 mm	158.1 Degrees	151.9 Degrees	165.6 Degrees	159.1 Degrees	0 mm	0.6 mm	2.9 mm	1.8 mm



British Steel Ltd (In Compulsory Liquidation)
 Testing Solutions Teesside

The Special Managers, their firm, partners, employees, advisers, representatives and agents and the Official Receiver as liquidator shall incur no personal liability under, or by virtue of, this document, nor in relation to any related matter or claim howsoever, whenever, and wherever arising, and whether such claim is formulated in contract and/or tort or by reference to any other remedy or right, and in whatever jurisdiction or forum. No liability (whether based in tort or contract or statute or otherwise) including, without limitation, any liability in connection with non-performance or breach or termination (whether by repudiation, disclaimer or otherwise), or any penalty or liability for liquidated damages, arising from actions or inactions of either the Official Receiver as liquidator or the Special Managers shall give rise to any liquidation expenses unless expressly accepted in writing.

Z01 D.Williams Z02
Manager - SAW Mills Quality A05

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Telephone: +44 (0)1429 266611
Fax: +44 (0)1429 527344

Page No. 2 of 2

Customer	A06
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Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/	1	A08
Customer Order No.	Customer Reference					A07
PO PII LIB 0004		EXXON MOBIL PII. PO 4540187138				
Product Description and Dimensions						B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCr PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T						

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged																					
B07 Cast/Heat No.	Pipe No.	C00 Test Piece No.	Tensile Test								Impact/Hardness Tests						Steel Making Process				
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm FSI	C13 Elong A% 2"	Ratio Re/Rm	B05 D02 Hydro Pressure PSI	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	C42 C31 Values F/LB		C43 C32 Ave F/LB	B05	BOS Other Tests	
471639										2320	HAZ	T	KVE KVF	0.39	32	289 221 270 260	100 100 100 100				
XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX END OF TEST CERTIFICATE XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX																					

C71-C99 Analysis %		C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 471639	LADLE	.07	.33	1.66	.012	.001	.048	.011	.036	.037	n/a	.0002	.0018	n/a	.038	n/a	.0027	.036	.016	.001	n/a	n/a	.17	.37
Plate No. 2421541	PLATE	.07	.31	1.61	.011	.001	.046	.010	.036	.037	n/a	.0002	.0015	n/a	.039	n/a	.0031	.034	.015	.001	n/a	n/a	.17	.36
2421551	PLATE	.07	.32	1.62	.011	.001	.046	.010	.036	.038	n/a	.0002	.0017	n/a	.039	n/a	.0026	.034	.015	.001	n/a	n/a	.17	.36

Code Numbers in accordance with EN10168 (see annex 1)

Code Numbers in accordance with EN10168 (see overleaf).

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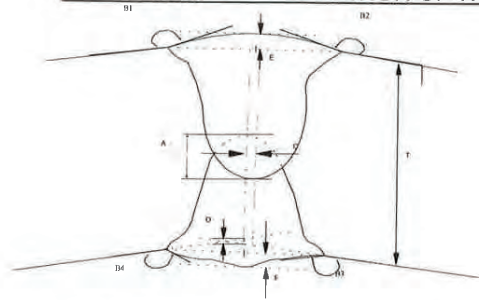
The products covered by this inspection document are certified by Liberty Pipes Limited and comply with the requirements of the Product Description.
A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd. Notified body No. 0041 and has been found to meet the requirements of PED (2014/68/EU).

Z01 D.Williams
Manager - SAW Mills Quality

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Z02
A05

VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM02043	471639	C HERBERT	24/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
4.8 mm	151.3 Degrees	158.3 Degrees	155.8 Degrees	157.2 Degrees	1 mm	0.1 mm	2.8 mm	2.1 mm



British Steel Ltd (In Compulsory Liquidation)
Testing Solutions Teesside

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A04

Liberty Pipes Limited

Hartlepool 42" Mill
Brenda Road
Hartlepool UK TS25 2EF

A01

Telephone: +44 (0)1429 266611
Fax: +44 (0)1429 527344

INSPECTION CERTIFICATE

EN10204 Type 3.1

A02

Date 07/08/19 Z02
Cert No. 340/1932/0015 A03
Del. Note

Page No. 1 of 2

Customer A06

Liberty Pipes Ref.No. Sales LPH190174 Works 50075/ 1 A08
Customer Order No. Customer Reference A07
PO PII LIB 0004 EXXON MOBIL PII. PO 4540187138
Product Description and Dimensions B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCR PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T

306/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

B07 Cast/Heat No.	Pipe No.	COO Test Piece No.	Tensile Test										Impact/Hardness Tests						Steel Making Process			C70								
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	Ratio Re/ Rm	B05	D02 Hydro Pressure PSI	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	C42 C31 Values F/LB		C43 C32 Ave F/LB	B05	Steel Making Process									
																	Other Tests	C50-C69 D02-D99												
471638	DWM 01625		B W	T T	S S	73387	91516 92676	36.80			2320	BM	T	KVE	0.39	32	333 319 321 324				ADDITIONAL INFORMATION ON S.O.C. RADIOGRAPHY AND UST SATISFACTORY TBT- 180 FROM LONGITUDINAL WELD 2.76 INS X 1.50 INS. X ACTUAL W.T. BO- 90 FROM LONGITUDINAL WELD BO.CVN.30 AVE.22 IND.(MIN) (FT LBS) WELD/HAZ 30 AVE 22 IND(MIN) (FT LBS) FORWARD&REVERSE BENDS SATISFACTORY HARDNESS AND MACRO SATISFACTORY ALL CHEMICAL COMBINATIONS COMPLY. CHEM ANALYSIS '---' = TRACE VALUES									
																						BO	T	KVE	0.39	32	171 319 321 270			
																						CLM	T	KVE	0.39	32	118 113 115 115			
																						CLO	T	KVE	0.39	32	114 106 120 114			
																						FLM	T	KVE	0.39	32	316 309 324 316			
																						F2M	T	KVE	0.39	32	305 289 289 294			
																						F5M	T	KVE	0.39	32	320 315 316 317			
																								KVF			100 100 100 100			
																								KVF			100 100 100 100			

Interlock

☐ Rejected

☒ Witnessed

Initial: *RJ*

Date: *7-8-9*

CS-3071

XX

C71-C99 Analysis %		C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No.	LADLE	.07	.32	1.64	.011	.001	.048	.009	.034	.035	n/a	.0001	.0019	n/a	.024	n/a	.0038	.035	.014	.001	n/a	n/a	.17	.36
Plate No.	PLATE	.07	.31	1.59	.011	.001	.046	.009	.033	.038	n/a	.0002	.0021	n/a	.022	n/a	.0045	.033	.013	.001	n/a	n/a	.17	.35
2460341	PLATE	.07	.30	1.57	.010	.001	.046	.007	.036	.036	n/a	.0002	.0014	n/a	.039	n/a	.0040	.033	.015	.001	n/a	n/a	.17	.35

Code Numbers in accordance with EN10168 (see overleaf).

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Z01 D.Williams
Manager - SAW Mills Quality

Z02
A05

This document has been prepared by computer system and is valid without signature.

A01

Hartlepool 42" Mill
Brenda Road
Hartlepool UK TS25 2EF

Telephone: +44 (0)1429 266611
Fax: +44 (0)1429 527344

INSPECTION CERTIFICATE A02

EN10204 Type 3.1

A02

Date	07/08/19	Z02
Cert No.	340/1932/0015	A03
Del. Note		

Page No. 2 of 2

Customer A06

Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/	1	A08
Customer Order No.	Customer Reference					A07
PO PII LIB 0004		EXXON MOBIL PII. PO 4540187138				
Product Description and Dimensions						B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCr PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T						

B06/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

B07 Cast/Heat No.	Pipe No.	C00 Test Piece No.	Tensile Test								Impact/Hardness Tests						Steel Making Process				C70					
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	Ratio Re/ Rm	B05	D02 Hydro Pressure PSI	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (*F)	Values		C42 C31 Ave F/LB	C43 C32 F/LB		B05	Steel Making Process			
																	C01	C02					C40 C30 Test Type	C41 Width (in)	C03 Temp (*F)	Values
471638										2320	HAZ	T	KVE KVF	0.39	32	305 284 302 296 100 100 100 100								C50-C69 D02-D99		
XX																										

C71-C99 Analysis %		C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 471638	LADLE	.07	.32	1.64	.011	.001	.048	.009	.034	.035	n/a	.0001	.0019	n/a	.024	n/a	.0038	.035	.014	.001	n/a	n/a	.17	.36
Plate No. 2460341	PLATE	.07	.31	1.59	.011	.001	.046	.009	.033	.038	n/a	.0002	.0021	n/a	.022	n/a	.0045	.033	.013	.001	n/a	n/a	.17	.35
2460481	PLATE	.07	.30	1.57	.010	.001	.046	.007	.036	.036	n/a	.0002	.0014	n/a	.039	n/a	.0040	.033	.015	.001	n/a	n/a	.17	.35

Code Numbers in accordance with EN10168 (see overleaf).

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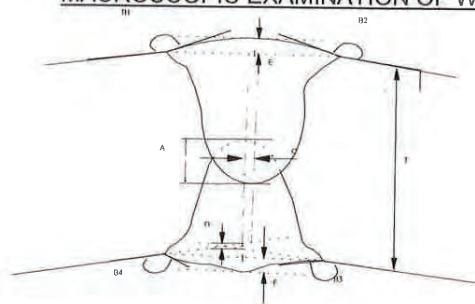
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Z01 D.Williams
Manager - SAW Mills Quality

Z02
A05

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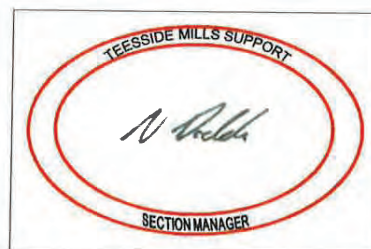
VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01625	471638	C HERBERT	26/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

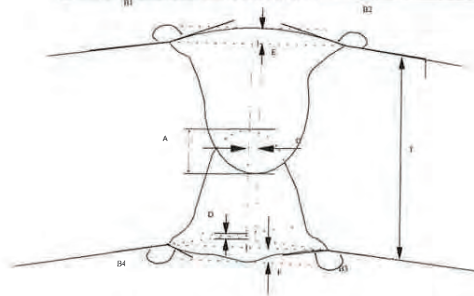
A	B1	B2	B3	B4	C	D	E	F
4.5 mm	153.8 Degrees	155.2 Degrees	162.4 Degrees	152.7 Degrees	0 mm	0.6 mm	2.8 mm	2.1 mm



British Steel Ltd (In Compulsory Liquidation)
 Testing Solutions Teesside

The Special Managers, their firm, partners, employees, advisers, representatives and agents and the Official Receiver as Liquidator shall incur no personal liability under, or by virtue of, this document, nor in relation to any related matter or claim howsoever, whenever, and wherever arising, and whether such claim is formulated in contract and/or tort or by reference to any other remedy or right, and in whatever jurisdiction or forum. No liability (whether based in tort or contract or statute or otherwise) including, limitation, any liability in connection with non-performance or breach or termination (whether by repudiation, disclaimer or otherwise), or any penalty or liability for liquidated damages, arising from omissions or inactions of either the Official Receiver, liquidator or the Special Managers shall give rise to any liquidation expenses unless expressly accepted in writing.

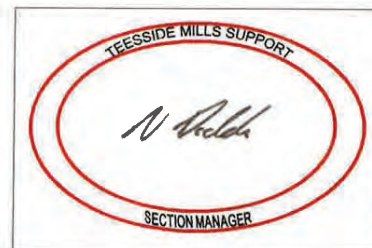
**VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD**



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01543	472135	L M COX	22/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
4.5 mm	156.6 Degrees	156.8 Degrees	162.3 Degrees	161.6 Degrees	1 mm	0.5 mm	2.9 mm	2.0 mm



British Steel Ltd (In Compulsory Liquidation)
Testing Solutions Teesside

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A04

Liberty Pipes Limited

Hartlepool 42" Mill
Brenda Road
Hartlepool UK TS25 2EF

A01

Telephone: +44 (0)1429 266611
Fax: +44 (0)1429 527344

INSPECTION CERTIFICATE

EN10204 Type 3.1

A02

Date	07/08/19	Z02
Cert No.	340/1932/0022	A03
Del. Note		

Customer	A06
----------	-----

Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/	1	A08
Customer Order No.	Customer Reference					A07
PO PII LIB 0004		EXXON MOBIL PII. PO 4540187138				
Product Description and Dimensions						B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCR PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T						

B06/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

Cast/Heat No.	Pipe No.	Test Piece No.	Tensile Test					D02 Hydro Pressure	Impact/Hardness Tests					Steel Making Process					C70																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
			C01	C02	C10	C11	C12		C13	B05	C40 C30 Test Type	C41 Width	C03 Temp	Values	C42 C31	C43 C32 Ave	B05	Other Tests																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																													
						Yield Stress Re PSI	Tensile Stress Rm PSI	Elong A% 2"	Ratio Re/ Rm																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						



C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 472136	LADLE	.08	.33	1.67	.013	.001	.024	.005	.027	.034	n/a	.0003	.0017	n/a	.018	n/a	.0048	.037	.017	.001	n/a	n/a	.18	.37
Plate No. 2460771	PLATE	.08	.31	1.59	.012	.001	.020	.003	.025	.036	n/a	.0003	.0018	n/a	.017	n/a	.0054	.035	.015	.001	n/a	n/a	.17	.35
2460861	PLATE	.08	.32	1.62	.014	---	.020	.004	.026	.037	n/a	.0003	.0019	n/a	.017	n/a	.0073	.038	.016	.001	n/a	n/a	.17	.36

Code Numbers in accordance with EN10168 (see overleaf).

Alteration to this document or its use for other products shall be regarded as falsification of documents and be subject to criminal jurisdiction.

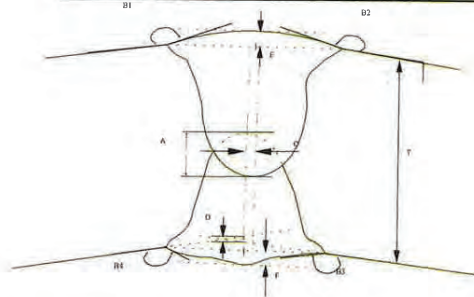
The products covered by this inspection document are certified by Liberty Pipes Limited and comply with the requirements of the Product Description.
A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd. Notified body No. 0041 and has been found to meet the requirements of PED (2014/68/EU).

Z01 D.Williams
Manager - SAW Mills Quality

Z02
A05

This document has been prepared by a computer system and is valid without signature.

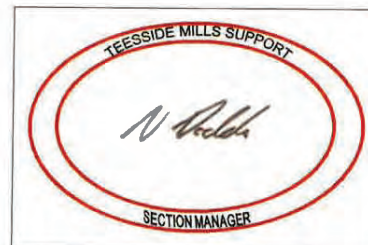
**VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD**



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM02127	472136	C HERBERT	23/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

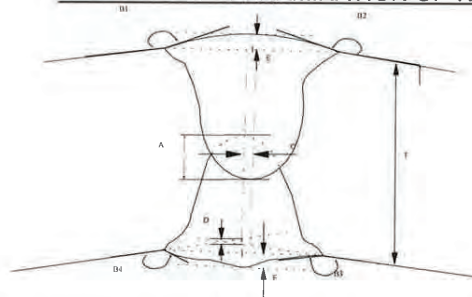
A	B1	B2	B3	B4	C	D	E	F
4.1 mm	150.0 Degrees	153.4 Degrees	151.5 Degrees	162.6 Degrees	1 mm	0.1 mm	2.9 mm	2.0 mm



British Steel Ltd (In Compulsory Liquidation)
Testing Solutions Teesside

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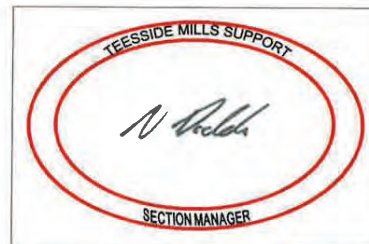
VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM02217	472138	L M COX	31/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
4.4 mm	160.6 Degrees	154.0 Degrees	156.8 Degrees	155.1 Degrees	1 mm	0.2 mm	2.7 mm	2.1 mm



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A04

Liberty Pipes Limited

Hartlepool 42" Mill
Brenda Road
Hartlepool UK TS25 2EF

A01

Telephone: +44 (0)1429 266611
Fax: +44 (0)1429 527344

INSPECTION CERTIFICATE

EN10204 Type 3.1

A02

Date 07/08/19 Z02
Cert No. 340/1932/0027 A03
Del. Note

A06

Customer

Page No. 1 of 2

Liberty Pipes Ref.No.

Sales LPH190174

Works 50075/ 1

Customer Order No.

Customer Reference

PO PII LIB 0004

EXXON MOBIL PII. PO 4540187138

Product Description and Dimensions

SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCR PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T

B01-B04
B09-B12

B06/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

Cast/Heat No.	Pipe No.	Test Piece No.	Tensile Test					B05	D02 Hydro Pressure	Impact/Hardness Tests					Steel Making Process		BOS	Other Tests	C50-C69 D02-D99
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	Ratio Re/Rm	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	Values F/LB	C42 C31 F/LB	C43 C32 Ave F/LB		
472145	DWM 01907		B	T	S	77883	92386 92966	37	.84	2320	BM	T	KVE	0.39	32	286 319 324310			
			W	T	S						BO	T	KVF	0.39	32	100 100 100100			
											CLM	T	KVF	0.39	32	311 314 229285			
											CLO	T	KVE	0.39	32	100 100 100100			
											FLM	T	KVF	0.39	32	129 129 117125			
											F2M	T	KVE	0.39	32	100 100 100100			
											F5M	T	KVF	0.39	32	113 111 117114			
													KVF			95 95 100 97			
													KVF			169 294 305256			
													KVF			80 100 100 93			
													KVE			299 301 308302			
													KVE			100 100 100100			
													KVF			296 316 322311			
																100 100 100100			



ADDITIONAL INFORMATION ON S.O.C. RADIOGRAPHY AND UST SATISFACTORY TBT- 180 FROM LONGITUDINAL WELD 2.76 INS X 1.50 INS. X ACTUAL W.T. BO- 90 FROM LONGITUDINAL WELD BO.CVN.30 AVE.22 IND. (MIN) (FT LBS) WELD/HAZ 30 AVE 22 IND (MIN) (FT LBS) FORWARD&REVERSE BENDS SATISFACTORY HARDNESS AND MACRO SATISFACTORY ALL CHEMICAL COMBINATIONS COMPLY. CHEM ANALYSIS '---' = TRACE VALUES

C71-C99 Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 472145 LADLE	.08	.30	1.66	.011	.001	.037	.013	.039	.045	n/a	.0003	.0017	n/a	.023	n/a	.0035	.036	.016	.001	n/a	n/a	.18	.37
Plate No. 2461481 PLATE	.08	.30	1.60	.011	.001	.046	.013	.048	.043	n/a	.0003	.0015	n/a	.029	n/a	.0057	.036	.015	.001	n/a	n/a	.18	.36
2461491 PLATE	.08	.29	1.60	.011	.001	.038	.013	.041	.046	n/a	.0003	.0017	n/a	.024	n/a	.0060	.035	.015	.001	n/a	n/a	.18	.36

Code Numbers in accordance with EN10168 (see overleaf).

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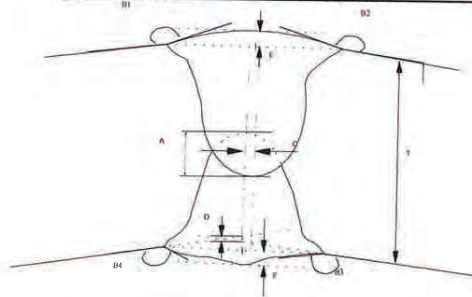
The products covered by this inspection document are certified by Liberty Pipes Limited and comply with the requirements of the Product Description. A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd. Notified body No. 0041 and has found to meet the requirements of PED (2014/68/EU).

Z01 D.Williams
Manager - SAW Mills Quality

Z02
A05

This document has been prepared by a computer system and is valid without signature.

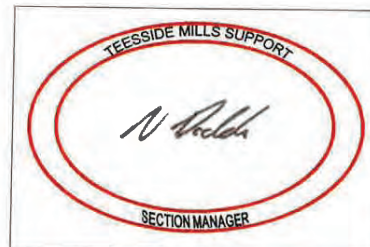
VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01907	472145	L M COX	22/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
5.1 mm	160.4 Degrees	150.0 Degrees	160.5 Degrees	159.8 Degrees	1 mm	0.1 mm	2.9 mm	2.3 mm



British Steel Ltd (in Compulsory Liquidation)
Testing Solutions Teesside

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A04

Liberty Pipes Limited

Hartlepool 42" Mill
Brenda Road
Hartlepool UK TS25 2EF

A01

Telephone: +44 (0)1429 266611
Fax: +44 (0)1429 527344

Customer

A06

INSPECTION CERTIFICATE

EN10204 Type 3.1

A02

Date 07/08/19 Z02
Cert No. 340/1932/0030 A03
Del. Note

Page No. 1 of 2

Liberty Pipes Ref.No.

Sales LPH190174

Works 50075/ 1

Customer Order No.

Customer Reference

PO PII LIB 0004

EXXON MOBIL PII. PO 4540187138

Product Description and Dimensions

SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCR PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T

B01-B04
B09-B12

B06/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

B07 Cast/Heat No.	Pipe No.	C00 Test Piece No.	Tensile Test										Impact/Hardness Tests										Steel Making Process		C70
			C01	C02	C10	C11 Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	Ratio Re/ Rm	B05	D02 Hydro Pressure PSI	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	Values F/LB	C42 C31 F/LB	C43 C32 Ave F/LB	B05	BOS				
																					Other Tests				
472150	DWM 01679		B W	T T	S S	73967	91516 93546	35.81			2320	BM	T	KVE	0.39	32	163 330 329 274				ADDITIONAL INFORMATION ON S.O.C. RADIOGRAPHY AND UST SATISFACTORY TBT- 180 FROM LONGITUDINAL WELD 2.76 INS X 1.50 INS. X ACTUAL W.T. BO- 90 FROM LONGITUDINAL WELD BO.CVN.30 AVE.22 IND.(MIN) (FT LBS) WELD/HAZ 30 AVE 22 IND(MIN) (FT LBS) FORWARD&REVERSE BENDS SATISFACTORY HARDNESS AND MACRO SATISFACTORY ALL CHEMICAL COMBINATIONS COMPLY. CHEM ANALYSIS '---' = TRACE VALUES	C50-C69 D02-D99			
intertek ☐ Reviewed ☐ Witnessed Initial:  Date: 8.8.20 GB - C160 CERT CONTINUED OVERLEAF																									

intertek
Reviewed
Witnessed
Initial: [Signature]
Date: 8.8.19
GB - 0160

ADDITIONAL INFORMATION ON S.O.C.
RADIOGRAPHY AND UST SATISFACTORY
TBT- 180 FROM LONGITUDINAL WELD
2.76 INS X 1.50 INS. X ACTUAL W.T.
BO- 90 FROM LONGITUDINAL WELD
BO.CVN.30 AVE.22 IND. (MIN) (FT LBS)
WELD/HAZ 30 AVE 22 IND (MIN) (FT LBS)
FORWARD&REVERSE BENDS SATISFACTORY
HARDNESS AND MACRO SATISFACTORY
ALL CHEMICAL COMBINATIONS COMPLY.
CHEM ANALYSIS '---' = TRACE VALUES

C71-C99	Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 472150	LADLE	.08	.33	1.65	.012	.001	.031	.008	.028	.035	n/a	.0004	.0017	n/a	.024	n/a	.0035	.036	.016	.001	n/a	n/a	.18	.37
Plate No. 2460641	PLATE	.08	.33	1.58	.011	.001	.028	.008	.027	.041	n/a	.0003	.0016	n/a	.022	n/a	.0023	.035	.015	.001	n/a	n/a	.17	.35
2460651	PLATE	.08	.33	1.59	.011	.001	.030	.007	.028	.040	n/a	.0003	.0017	n/a	.022	n/a	.0036	.034	.016	.002	n/a	n/a	.18	.36

Code Numbers in accordance with EN10168 (see overleaf).

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Z01 D.Williams
Manager - SAW Mills Quality

Z02
A05

This document has been prepared by a computer system and is valid without signature.

Telephone: +44 (0)1429 266611
Fax: +44 (0)1429 527344

A06

A02

Date	07/08/19	Z02
Cert No.	340/1932/0030	A03
Del. Note		

Page No. 2 of 2

Liberty Pipes Ref.No.

Sales LPH190174

Works 50075/ 1

Customer Order No.

Customer Reference

PO PII LIB 0004

EXXON MOBIL PII. PO 4540187138

Product Description and Dimensions

B01-B04
B09-B12

SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCR PLATE TO API 5L GRADE
X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API
SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L
46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013).
36.00ins O.D x 0.625ins W.T

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

[illegible]

C71-C99 Analysis %		C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 472150	LADLE	.08	.33	1.65	.012	.001	.031	.008	.028	.035	n/a	.0004	.0017	n/a	.024	n/a	.0035	.036	.016	.001	n/a	n/a	.18	.37
Plate No. 2460641	PLATE	.08	.33	1.58	.011	.001	.028	.008	.027	.041	n/a	.0003	.0016	n/a	.022	n/a	.0023	.035	.015	.001	n/a	n/a	.17	.35
2460651	PLATE	.08	.33	1.59	.011	.001	.030	.007	.028	.040	n/a	.0003	.0017	n/a	.022	n/a	.0036	.034	.016	.002	n/a	n/a	.18	.36

Code Numbers in accordance with EN10168 (see overleaf).

The products covered by this certificate are:

Code Numbers in accordance with EN10168 (see overleaf).

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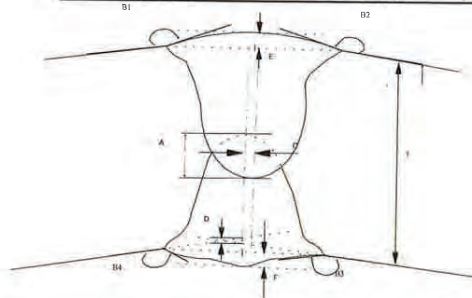
The products covered by this inspection document are certified by Liberty Pipes Limited and comply with the requirements of the Product Description.
A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd. Notified body No. 0041 and has been found to meet the requirements of PED (2014/68/EU).

Z01 D.Williams
Manager - SAW Mills Quality

Z02
A05

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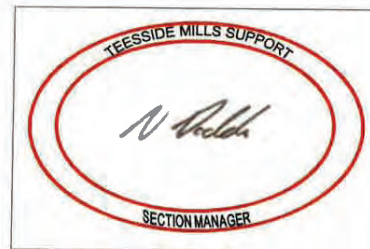
VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01679	472150	L M COX	29/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
4.4 mm	157.6 Degrees	157.4 Degrees	166.6 Degrees	163.2 Degrees	1 mm	0.6 mm	2.8 mm	1.9 mm



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 Testing Solutions Teesside

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A04

Liberty Pipes Limited

Hartlepool 42" Mill
Brenda Road
Hartlepool UK TS25 2EF

A01

Telephone: +44 (0)1429 266611
Fax: +44 (0)1429 527344

Customer

A06

INSPECTION CERTIFICATE

EN10204 Type 3.1

A02

Date 07/08/19 Z02
Cert No. 340/1932/0031 A03
Del. Note

Page No. 1 of 2

Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/ 1	A08
Customer Order No.	Customer Reference		A07		
PO PII LIB 0004		EXXON MOBIL PII. PO 4540187138			
Product Description and Dimensions					
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCR PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T					

B06/A10

B=Body W=Weld L=Longitudinal T=Transverse S=Stripped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VPN HR=Hardness Rockwell DT=Drop Weight Tear Test A=Annealed N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged																									
B07		C00	Tensile Test										Impact/Hardness Tests										Steel Making Process		C70
Cast/Heat No.	Pipe No.	Test Piece No.	C01	C02	C10	C11	C12	C13	Ratio	B05	D02	C01	C02	C40	C41	C03	C42	C43	B05	BOS					
						Yield Stress Re	Tensile Stress Rm	Elong A%	Re/Rm		Hydro Pressure			Test Type	Width	Temp	Values	C31 Ave	C32 Ave	Other Tests					
						PSI	PSI	2"			PSI				(in)	(°F)	F/LB	F/LB							
472151	DWM 01547		B	T	S	73677	90210 92096	36.82			2320	BM	T	KVE	0.39	32	318 221 296	278		ADDITIONAL INFORMATION ON S.O.C. RADIOGRAPHY AND UST SATISFACTORY TBT- 180 FROM LONGITUDINAL WELD 2.76 INS X 1.50 INS. X ACTUAL W.T. BO- 90 FROM LONGITUDINAL WELD BO.CVN.30 AVE.22 IND. (MIN) (FT LBS) WELD/HAZ 30 AVE 22 IND (MIN) (FT LBS) FORWARD&REVERSE BENDS SATISFACTORY HARDNESS AND MACRO SATISFACTORY ALL CHEMICAL COMBINATIONS COMPLY. CHEM ANALYSIS '---' = TRACE VALUES					
			W	T	S							BO	T	KVF	0.39	32	100 100 100	100							
												CLM	T	KVE	0.39	32	128 319 314	254							
														KVF			100 100 100	100							
												CLO	T	KVE	0.39	32	127 111 124	121							
														KVF			90 80 95	88							
												FLM	T	KVE	0.39	32	111 107 108	108							
														KVF			90 90 80	87							
												F2M	T	KVE	0.39	32	308 294 291	297							
														KVF			100 100 100	100							
												F5M	T	KVE	0.39	32	294 254 240	263							
														KVF			100 100 100	100							
														KVF			319 315 318	317							
																	100 100 100	100							
XX																									



C71-C99		Analysis %		C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No.	LADLE	.08	.32	1.67	.011	.001	.034	.007	.024	.036	n/a	.0003	.0019	n/a	.018	n/a	.0036	.036	.017	.001	n/a	n/a	.18	.37		
Plate No.	PLATE	.08	.32	1.63	.012	.001	.032	.007	.024	.037	n/a	.0003	.0019	n/a	.018	n/a	.0057	.037	.016	.001	n/a	n/a	.18	.36		
2460541	PLATE	.07	.31	1.59	.011	.001	.032	.006	.025	.037	n/a	.0004	.0017	n/a	.019	n/a	.0038	.034	.016	.001	n/a	n/a	.17	.35		

Code Numbers in accordance with EN10168 (see overleaf).

Alteration to this document or its use for other products is prohibited.

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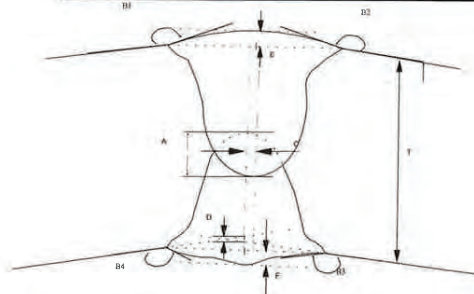
The products covered by this inspection document are certified by Liberty Pipes Limited and comply with the requirements of the Product Description. A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd. Notified body No. 0041 and has been found to meet the requirements of PED (2014/68/EU).

Z01 D.Williams
Manager - SAW Mills Quality

Z02
A05

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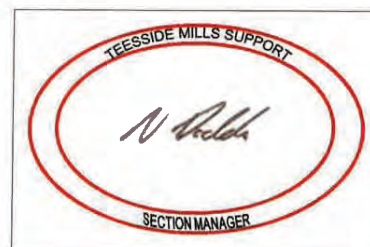
VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01547	472151	L M COX	23/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
4.7	159.4	159.9	166.5	162.0	1	0.2	2.7	1.8
mm	Degrees	Degrees	Degrees	Degrees	mm	mm	mm	mm



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Telephone: +44 (0)1429 266611
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A02

Page No. 1 of 2

A06

Liberty Pipes Ref.No.	Sales	LPH190174	Works	50075/	1	A08
Customer Order No.	Customer Reference					A07
PO PII LIB 0004		EXXON MOBIL PII. PO 4540187138				
Product Description and Dimensions						B01-B04 B09-B12
SAW STEEL LINEPIPE UOE MANUFACTURED FROM TMCr PLATE TO API 5L GRADE X70M IN ACCORDANCE WITH PII 29-01-05 UPSTREAM LINE PIPE - API SPECIFICATION 5L/ISO 3183 NOV 2017, PII 72-03-01 JUNE 2017 AND API 5L 46TH EDITION (2018). ALSO COMPLIES WITH API 5L 45TH EDITION (2013). 36.00ins O.D x 0.625ins W.T						

B=Body W=Weld L=Longitudinal T=Transverse S=Striped Out Section C=Round Bar KV=Charpy Impact CL=Centre Line FL=Fusion Line F2=F/Line+2mm F5=F/Line+5mm O=Outside I=Inside
M=Mid-Thickness R=Root E=Absorbed Energy F=Fibrosity HV=Hardness VP N=Normalised NT=Normalised and Tempered SR=Stress Relieved SA=Strain Aged

Cast/Heat No.	Pipe No.	Test Piece No.	Tensile Test										Impact/Hardness Tests										Steel Making Process	
			C01	C02	C10	Yield Stress Re PSI	C12 Tensile Stress Rm PSI	C13 Elong A% 2"	Ratio Re/Rm	B05	D02 Hydro Pressure PSI	C01	C02	C40 C30 Test Type	C41 Width (in)	C03 Temp (°F)	Values F/LB	C42 C31 F/LB	C43 C32 Ave F/LB	B05	BOS	Other Tests		
																					C50-C69 D02-D99			
472153	DWM 01501		B W	T T	S S	74837	90935 91951	36.82		2320	BM	T	KVE KVF	0.39 0.39	32 32	313 309 131 251 100 100 100 100					ADDITIONAL INFORMATION ON S.O.C. RADIOGRAPHY AND UST SATISFACTORY TBT- 180 FROM LONGITUDINAL WELD 2.76 INS X 1.50 INS. X ACTUAL W.T. BO- 90 FROM LONGITUDINAL WELD BO.CVN.30 AVE.22 IND.(MIN) (FT LBS) WELD/HAZ 30 AVE 22 IND(MIN) (FT LBS) FORWARD&REVERSE BENDS SATISFACTORY HARDNESS AND MACRO SATISFACTORY ALL CHEMICAL COMBINATIONS COMPLY. CHEM ANALYSIS '---' = TRACE VALUES			
CERT CONTINUED OVERLEAF																								

C71-C99 Analysis %		C	SI	MN	P	S	CR	MO	NI	AL	AS	B	CA	CO	CU	H	N	NB	TI	V	O	SN	PCM	CEV
Cast No. 472153	LADLE	.08	.31	1.67	.010	.001	.036	.007	.028	.044	n/a	.0003	.0018	n/a	.025	n/a	.0040	.035	.017	.001	n/a	n/a	.18	.37
Plate No. 2460351	PLATE	.08	.31	1.63	.010	.001	.035	.007	.028	.050	n/a	.0003	.0019	n/a	.026	n/a	.0035	.035	.015	.001	n/a	n/a	.17	.36
2461151	PLATE	.08	.33	1.64	.010	.001	.033	.006	.026	.046	n/a	.0003	.0021	n/a	.022	n/a	.0044	.035	.016	.001	n/a	n/a	.18	.37

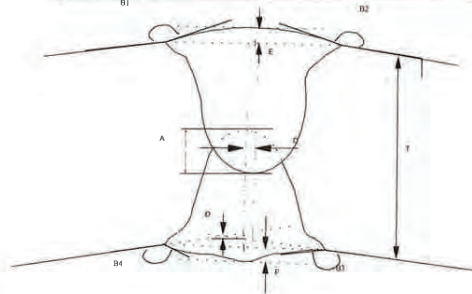
Code Numbers in accordance with EN10168 (see overleaf)

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A specific assessment for materials has been performed on the SAW Mills quality system by BV UK Ltd, Notified body No. 0041 and has been found to meet the requirements of PED (2014/68/EU).

Z02
A05

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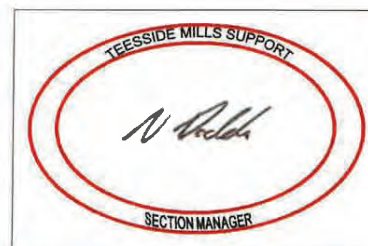
VAN LEEUWEN
EXXON MOBIL PII
MACROSCOPIC EXAMINATION OF WELD



PIPE NUMBER	CAST NUMBER	TESTED BY	DATE TESTED
DWM01501	472153	L M COX	22/07/2019

FEATURE	SPECIFICATION REQUIREMENTS
A = DEPTH OF INTERPENETRATION	3mm MIN
B1 = CONTACT ANGLE	110° MIN
B2 = CONTACT ANGLE	110° MIN
B3 = CONTACT ANGLE	110° MIN
B4 = CONTACT ANGLE	110° MIN
C = WELD MISALIGNMENT	3mm MAX
D = RADIAL OFFSET OF PLATE EDGES	1.6mm MAX
E = WELD RE-INFORCEMENT (O/D)	4.5mm MAX
F = WELD RE-INFORCEMENT (I/D)	3.5mm MAX
T = NOMINAL PIPE WALL THICKNESS	15.88mm

A	B1	B2	B3	B4	C	D	E	F
4.2 mm	155.4 Degrees	157.4 Degrees	159.2 Degrees	159.4 Degrees	0 mm	0.3 mm	3.0 mm	2.1 mm



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