



DURA-BOND PIPE 1
CERTIFIED TEST REPORT
(IN ACCORDANCE WITH EN 10204:2004 "Type 3.1")

DATE: 7/9/2025

HEAT# CB1515

DP1 Job Number / DP1 Contract Code	P.O. Number	O.D. (IN.)	WALL (IN.)	GRADE	MATERIAL CONDITION:	Specification(s):
JO24-800-55-M51D	STOCK	16	0.375	X65M	High Frequency Welded Thermomechanical Rolled	API 5L 46th Edition PSL2

Name STOCK
Ship To:
Pipes Made At: Dura-Bond Pipe 1, 301 4th Avenue, McKeesport, PA 15132

Notes:

- 1 This Report shall not be reproduced or altered without the prior written approval of Dura-Bond Pipe.
- 2 The steel is 100% melted and manufactured in the USA. No Repairs on any part of the pipe by Welding.
Steel Making Facility: Nucor, Gallatin Coil Making Facility: Nucor, Gallatin
- 3 The chemical test results were conducted and recorded in accordance with ASTM E415. Tensile and Charpy V-Notch Testing has been performed as per ASTM A370.
- 4 Minimum temperature for normalizing of weld seam is 1675 Degrees F.
- 5 Residual magnetism has been verified at least 1 pipe / 4 hr: 35 Max Single / 30 Max Avg (4 readings @ 90°)
- 6 Full length of Ultrasonic testing of welds for longitudinal defects. Standard (3) 1/8" through holes at least 50 mm apart, one on centerline, and one 1/8" on each side of weld centerline, and 1/4" FBH for HAZ (Laminar defects)
- 7 Flattening test has been performed and checked out ok in accordance with the specification requirements.
- 8 Full length visual inspection has been performed on each pipe and checked out ok.
- 9 Full length Electromagnetic Inspection (EMI) has been performed on each pipe as per (3) 1/8" through holes, (1) N10 OD Notch. Frequency Start & end of turn and every four hours, or when the last pipe of the most recent calibration reaches the final inspection station.
- 10 Full length visual inspection has been performed on each pipe and checked out ok.
- 11 Full length Electromagnetic Inspection (EMI) has been performed on each pipe as per: Start & end of turn and every four hours, or when the last pipe of the most recent calibration reaches the final inspection station.
- 12 Hydro-testing of each pipe has been performed at 100% SMYS at 3070 psi. 100% SMYS Test Minimum Dwell Time: 10 sec
- 13 Hardness complies with NACE MR0175

THIS IS TO CERTIFY THAT THE PRODUCT DESCRIBED HEREIN WAS MANUFACTURED, SAMPLED, TESTED AND/OR INSPECTED IN ACCORDANCE WITH THE SPECIFICATION(S) AND FULLFILLS THE REQUIREMENTS IN SUCH RESPECTS.

PREPARED BY THE OFFICE OF: Kenneth Heil
Director of Quality

Date: Wednesday, July 9, 2025



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TRANSVERSE PIPE BODY & WELD TENSILE TESTING

Pipe#	Test Type/ Orientation	Width (In.)	Yield Strength (0.5% EUL)		Tensile Strength		Y/T		Elongation% in 2"	Testing Frequency
			Min. (psi)	65,300	Min. (psi)	77,600			22.1	
			Max. (psi)	87,000	Max. (psi)	110,200	Max.	0.93		
XF25-0283-04	Strip/T/B	1.5	80,900		89,700		0.90		28.1	
XF25-0283-04	Strip/T/W	1.5			86,700					
XF25-0310-16	Strip/T/B	1.5	75,600		88,800		0.85		29.7	
XF25-0310-16	Strip/T/W	1.5			85,000					
LEGEND: L-Longitudinal T-Transverse B-Body W-Weld HAZ - Heat Affected Zone										

CHARPY V-NOTCH IMPACT TESTING

Pipe#	Test Location / Orientation	Sample Size	Absorbed Energy (ft-lbs)				Temp (F)	% Shear				Testing Frequency
			Avg per Heat		13.3		-20°F	Avg per Heat		Info Only		
			Min Specimen		10.0			Min Specimen		Info Only		
		2/3	1	2	3	Average		1	2	3	Average	
XF25-0283-04	Body/T	2/3	98	86	94	93	-20°F	100	100	100	100	1 set per Heat

HEAT & PRODUCT ANALYSIS

Heat#	Analysis	C	Mn	P	S	Si	Al	Nb	V	Ti	Cu	Ni	Cr	Mo	Ca	N	B	Nb+V+Ti	Pcm	IIW
	Min(%)	-	-	-	-	0.15	0.010	-	-	-	-	-	-	-	-	-	-	-	-	-
	Max(%)	0.10	1.60	0.018	0.005	0.30	0.054	0.084	0.065	0.023	0.20	0.15	0.20	0.10	0.0045	0.010	0.0005	0.15	0.20	0.40
CB1515	Heat	0.04	1.53	0.012	0.001	0.210	0.033	0.064	0.054	0.019	0.100	0.06	0.05	0.01	0.002	0.010	0.0001	0.137	0.139	0.328
CB1515	Product1	0.04	1.48	0.012	0.001	0.210	0.033	0.062	0.054	0.019	0.110	0.06	0.06	0.01	0.002	0.000	0.0002	0.135	0.138	0.324
CB1515	Product2	0.04	1.48	0.012	0.001	0.200	0.032	0.062	0.054	0.019	0.110	0.06	0.05	0.01	0.002	0.000	0.0001	0.135	0.136	0.321

Pcm is based on the following equation: $C + Si/30 + (Mn + Cu + Cr)/20 + Ni/60 + Mo/15 + V/10 + 5B$

IIW is based on the following equation: $C + Mn/6 + (Cr + Mo + V)/5 + (Cu + Ni)/15$

HARDNESS TESTING

Max. Individual Value		99				
Pipe#	Test Location	Body1	HAZ1	Weld	HAZ2	Body2
XF25-0283-04	OD	85	89	82	89	80
XF25-0283-04	MIDWALL	89	91	91	90	92
XF25-0283-04	ID	89	89	91	88	92

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