



A04

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

A01

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Email: tubesalesUK@tatasteelleurope.com

INSPECTION CERTIFICATE EN10204 Type 3.1

A02

Date 13/09/22 Z02
Cert No. 280/2237/0103 A03
Del. Note

Page No. 02 of 02

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.	Sales	GXM424260	Works	6878	A08
Customer Order No.	P/O: PUR3001828. OF 18/APR/22				A07
Product Description	HIGH FREQUENCY INDUCTION WELDED STEEL TUBES TO API 5L PSL2 46TH EDITION GRADE X65M. HARDNESS ONLY FOR NACE MR0175.				B01-B04

MADE IN UK

L=Longitudinal T=Transverse B=Body W=Weld KV=Charpy V-Notch HV=Hardness Vickers(10Kg Load) DT=Drop Weight Tear Test																
Item No.	Number of Pieces	Product Dimensions (in)	Cast/Heat No.	Pipe No.	Tensile Test					Impact/Hardness Tests					Steel Making Process	
					C01 C02 C10	Yield Stress Re (psi)	C11 Tensile Strength Rm (psi)	C12 Elong A% 2IN	D02 Hydro Pressure (psi)	C01 C02 C30 Test Type	C40 Width (mm)	C41 Temp (C)	C42 C31 Values Ft Lb	C43 C32 Ave Ft Lb	BASIC OXYGEN STEEL	
															Other Tests	
7	75	20.000IN OD X 0.375IN 42' 0"-43' 0" 3222' 4"	7T13611	3004306	W T B T W T B T		101816		2200 10.0 SECS	T B	KV	7.5	00	58 66 59	60	% SHEAR = 100:100:100 = 100
7	47	20.000IN OD X 0.375IN 42' 0"-43' 0" 2013' 2"	7T13613	3004805	T W T B T	69763 RATIO	99206 .70	28	2200 10.0 SECS	T B	KV	7.5	00	48 47 46	47	% SHEAR = 100:100:100 = 100
7	24	20.000IN OD X 0.375IN 42' 0"-43' 0" 1030' 3"	7T14239	3005215	W T B T	66572 RATIO	91519 .72	28	2200 10.0 SECS	T B	KV	7.5	00	78 77 72	76	% SHEAR = 100:100:100 = 100
***** 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.																						
7T13613 LADLE		.11	.298	1.48	.021	.002	.030	.002	.016	.054	.0004	.019	.0063	.003	.047	.014	.003	.051	.37	.20		
7T13613 PROD		.11	.283	1.50	.019	.001	.028	.001	.016	.059	.0003	.017	.0066	.002	.039	.014	.003	.052	.37	.20		
7T13613 PROD		.11	.283	1.50	.020	.001	.027	.002	.017	.057	.0004	.017	.0059	.002	.041	.014	.003	.052	.38	.20		
7T14239 LADLE		.11	.313	1.56	.015	.002	.021	.001	.014	.056	.0003	.013	.0045	.002	.050	.004	.003	.052	.38	.20		
7T14239 PROD		.11	.298	1.59	.013	.001	.019	.000	.016	.056	.0003	.012	.0039	.002	.044	.004	.003	.053	.39	.20		
7T14239 PROD		.11	.300	1.58	.012	.002	.019	.002	.015	.061	.0005	.012	.0052	.002	.043	.004	.003	.052	.39	.21		

Code Numbers in accordance with EN 10168 (see overleaf).
Alterations to this document or its use for other products shall be regarded
as falsification of documents and be subject to criminal jurisdiction.

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.

Z01 The products covered by this inspection document are certified by Tata Steel UK Limited and comply with the requirements of the Order Acknowledgement.

DAVID EVANS
Section Manager Technical
This document has been prepared by a
computer system and is valid without signature.
18 Grosvenor Place London SW1X 7HS Company Reg.No.02280000.

Z02
A05



A04

Tata Steel UK Limited

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Telephone: + 44 (0) 1429 266611
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EN10204 Type 3.1

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Date	15/11/22	Z02
Cert No.	280/2246/0157	A03
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Page No. 01 of 04

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.	GXM424983	Works	7088	A08
Customer Order No.	P/O: PUR3001891.. OF 27/MAY/22			A07
Product Description	HIGH FREQUENCY INDUCTION WELDED STEEL TUBES TO API 5L PSL2 46TH EDITION GRADE X65M. HARDNESS ONLY FOR NACE MR0175.			B01-B04

MADE IN UK

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 Number of Pieces	Product Dimensions (in)	B09-B12 Cast/Heat No.	B07 Pipe No.	C01 C02 C10	Yield Stress Re (psi)	Tensile Test				Impact/Hardness Tests				Steel Making Process				C70			
							C11 Tensile Strength Rm (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	BASIC OXYGEN STEEL					
																		Other Tests				
																			STEELMAKING/COIL ROLLING: TATA STEEL, UK. FLATTENING TEST SATISFACTORY ULTRASONIC TESTS SATISFACTORY TENSILE TEST PIECE: RECTANGULAR 330MM X 38.1MM X ACTUAL WALL THICK BODY CVN:20FT-LB AVE / 15FT-LB IND (MIN) OR REDUCED IN PROPORTION IF SUBSIZE. 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%			

C71-C99		Analysis %	C	SI	MN	P	S	CR	MO	NI	AL	B	CU	N	CA	NB	SN	TI	V	CEV	PCM		
Cast No.																							
7T13611 LADLE			.10	.283	1.48	.017	.002	.040	.007	.036	.050	.0005	.023	.0049	.003	.048	.013	.003	.051	.37	.20		
7T13611 PROD			.11	.270	1.52	.016	.002	.036	.009	.036	.052	.0007	.022	.0060	.003	.040	.013	.003	.052	.38	.21		
7T13611 PROD			.11	.270	1.52	.016	.002	.036	.009	.036	.052	.0006	.022	.0061	.002	.041	.014	.003	.052	.39	.21		

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Note - only tubes in accordance with EN 10217 (TR1 grades excluded) have a presumption of conformity with the PED.DAVID EVANS
Section Manager Technical
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Customer Order No.	P/O: PUR3001891.. OF 27/MAY/22 A07			
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MADE IN UK

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Item No.	B08 Number of Pieces	Product Dimensions (in)	B09-B12 Cast/Heat No.	B07 Pipe No.	C01 C02 C10	Tensile Test				Impact/Hardness Tests				Steel Making Process				C70				
						Yield Stress Re (psi)	C11 Tensile Strength Rm (psi)	C13 Elong A% 2IN	D02 Hydro Pressure (psi)	C01 C02 C10	C40 C30 Test Type	C41 Width (mm)	C03 Temp (C)	C42 C31 Values Ft Lb	C43 C32 Ave Ft Lb	BASIC OXYGEN STEEL						
																Other Tests						
9	15	20.000IN OD X 0.375IN 42' 0"-43' 0" 643' 8"	7T13611	4026105	W T B T W T B T W T B T W T B T		110664		2200 10.0 SECS	T B	KV	7.5	00	87 89 74	83	% SHEAR = 100:100:100 = 100						
9	105	20.000IN OD X 0.375IN 42' 0"-43' 0" 4505' 4"	7T15830	4024612	W T B T W T B T W T B T W T B T	73534 RATIO .75 105732	26	2200 10.0 SECS	T B	KV	7.5	00	117 105 117	113	% SHEAR = 100:100:100 = 100							
				4025205	W T B T W T B T W T B T W T B T	65702 RATIO .72 109068	34	2200 10.0 SECS	T B	KV	7.5	00	108 86 97	97	% SHEAR = 100:100:100 = 100							
9	121	20.000IN OD X 0.375IN 42' 0"-43' 0" 5186' 8"	7T15831	4023205	W T B T W T B T W T B T W T B T	66572 RATIO .69 103992	33	2200 10.0 SECS	T B	KV	7.5	00	124 127 117	122	% SHEAR = 100:100:095 = 098							
					W T B T W T B T W T B T W T B T	66862 RATIO .70	31															
C71-C99 Analysis %																						
Cast No.		C	SI	MN	P	S	CR	MO	NI	AL	B	CU	N	CA	NB	SN	TI	V	CEV	PCM		
7T15830 LADLE		.10	.295	1.46	.015	.002	.015	.003	.022	.030	.0003	.016	.0029	.003	.047	.002	.002	.051	.36	.19		
7T15830 PROD		.11	.288	1.52	.013	.002	.015	.005	.022	.033	.0004	.015	.0033	.003	.041	.001	.002	.051	.38	.20		
7T15830 PROD		.11	.289	1.54	.013	.002	.014	.005	.023	.032	.0004	.015	.0032	.002	.045	.001	.002	.051	.38	.21		
7T15831 LADLE		.10	.293	1.47	.014	.002	.018	.002	.019	.041	.0004	.014	.0051	.002	.047	.002	.003	.048	.36	.19		
7T15831 PROD		.11	.284	1.51	.012	.002	.017	.005	.020	.044	.0005	.013	.0051	.002	.040	.001	.003	.049	.38	.21		
7T15831 PROD		.11	.281	1.51	.012	.000	.018	.001	.019	.046	.0004	.013	.0039	.002	.042	.001	.003	.050	.38	.20		

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mill inspection documents are affixed according to harmonized standards EN 10210-1 & EN 10219-1 only.
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Customer	A06
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475 NORTH MARTINGALE ROAD SUITE 400 SCHAUMBURG ILLINOIS 60173, USA	

Quality Management System
Approved to ISO 9001

Tata Steel Ref.No.	GXM424983	Works	7088	A08
Sales				
Customer Order No.	P/O: PUR3001891.. OF 27/MAY/22			A07
Product Description	HIGH FREQUENCY INDUCTION WELDED STEEL TUBES TO API 5L PSL2 46TH EDITION GRADE X65M. HARDNESS ONLY FOR NACE MR0175.			B01-B04

MADE IN UK

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 Number of Pieces	B09-B12 Product Dimensions (in)	B07 Cast/Heat No.	Pipe No.	Tensile Test					Impact/Hardness Tests					Steel Making Process								C70
					C01 C02 C10	C11 Yield Stress Re (psi)	C12 Tensile Strength Rm (psi)	C13 Elong A% 2IN	D02 Hydro Pressure (psi)	C01 C02 Test Type	C40 C30 Width (mm)	C41 Temp (C)	C42 C31 Values Ft Lb	C43 C32 Ave Ft Lb	BASIC OXYGEN STEEL								
															C50-C69 D02-D99								
													Other Tests										
9	67	20.000IN OD X 0.375IN 42' 0"-43' 0" 5186' 8"	7T15831	4023505	W		104137		2200	T	KV	7.5	00	114	100	% SHEAR = 100:100:100 = 100							
					T				10.0	B				89									
					B	69183	91664	31						97									
					T	RATIO	.75																
				4023607	B	66282	91809	35		T	KV	7.5	00	77	103	% SHEAR = 100:100:100 = 100							
					B	RATIO	.72			B				125									
					W		101816							105									
					T																		
				4023704	W		104862			T	KV	7.5	00	90	92	% SHEAR = 100:100:100 = 100							
					T					B				83									
					B	72664	94274	29						103									
					T	RATIO	.77		2200	T													
				4025705	W		104572		2200	T	KV	7.5	00	66	61	% SHEAR = 100:100:100 = 100							
					T				10.0	B				57									
					B	67878	95145	32	SECS					60									
					T	RATIO	.71																

C71-C99		Analysis %		C	SI	MN	P	S	CR	MO	NI	AL	B	CU	N	CA	NB	SN	TI	V	CEV	PCM		
Cast No.																								
7T15832 LADLE		.10	.3211	.48	.017	.003	.029	.003	.019	.052	.0003	.015	.0046	.001	.047	.005	.003	.048	.37	.20				
7T15832 PROD		.11	.3171	.54	.015	.002	.027	.005	.020	.058	.0004	.014	.0062	.002	.040	.005	.003	.049	.39	.21				
7T15832 PROD		.11	.3121	.53	.014	.002	.026	.005	.020	.058	.0005	.014	.0064	.002	.041	.004	.003	.049	.39	.21				
7T15833 LADLE		.10	.2871	.45	.014	.004	.021	.002	.019	.043	.0003	.016	.0045	.001	.047	.005	.003	.049	.36	.19				
7T15833 PROD		.10	.2751	.44	.009	.003	.017	.004	.019	.050	.0004	.017	.0057	.001	.043	.006	.002	.051	.36	.19				
7T15833 PROD		.10	.2721	.43	.009	.003	.016	.004	.020	.049	.0004	.016	.0048	.001	.043	.006	.002	.051	.35	.19				

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Item No.	B08 Number of Pieces	Product Dimensions (in)	B09-B12 Cast/Heat No.	B07 Pipe No.	C01 C02 C10	Tensile Test				Impact/Hardness Tests					Steel Making Process			
						Yield Stress Re (psi)	C11 Tensile Strength Rm (psi)	C12 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	BASIC OXYGEN STEEL		
																C50-C65 D02-D95		
Other Tests																		
9	64	20.000IN OD X 0.375IN 42' 0"-43' 0" 2748' 0"	7T15833	4025305	W T B T W T B T W T B T	68168 RATIO	91809 .74	34	2200 10.0 SECS	T B	KV	7.5	00	63 70 58	63	% SHEAR = 100:100:100 = 100		
9	99	20.000IN OD X 0.375IN 42' 0"-43' 0" 4246' 8"	7T15834	4023805	W T B T W T B T	66282 RATIO	91374 .72	33	2200 10.0 SECS	T B	KV	7.5	00	72 74 73	73	% SHEAR = 100:100:100 = 100		
				4024405	W T B T W T B T	65847 RATIO	92244 .71	31		T B	KV	7.5	00	69 74 72	72	% SHEAR = 100:100:100 = 100		
*****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.																						
7T15834 LADLE		.09	.279	1.38	.012	.003	.018	.002	.018	.046	.0003	.017	.0051	.001	.049	.007	.002	.051	.34	.18		
7T15834 PROD		.10	.273	1.43	.009	.003	.016	.003	.019	.050	.0004	.016	.0049	.001	.043	.006	.002	.051	.35	.19		
7T15834 PROD		.10	.275	1.44	.009	.003	.016	.004	.020	.051	.0004	.017	.0047	.001	.043	.006	.002	.051	.35	.19		

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