

GLOBAL SEAMLESS TUBES & PIPES PVT. LTD (INDIA)

MILL TEST CERTIFICATE
CERTIFICATE ACCORDING TO EN 10204 : 3.1

PURCHASER NAME :		M/s. UNITED PIPE AND STEEL		TEST CERTIFICATE No.:		GSTP/2750/MU/2023				
PURCHASER ORDER No. :		5048577		TEST CERTIFICATE Date :		13.06.2023				
WORK ORDER No. :		GSTPL/WO/EXP/5863		INVOICE NO:		GSTPLEXP232427				
NAME OF PRODUCT :		CARBON STEEL SEAMLESS PIPES		INVOICE Date :		13.06.2023				
PROCESS OF PIPE/TUBE MANUFACTURE :		CARBON STEEL COLD DRAWN SEAMLESS PIPES								
STEEL MANUFACTURED BY (MELT & POUR):		RASHTRIYA ISPAT NIGAM LIMITED, INDIA								
STEEL MAKING METHOD :		BOF-LF/IRUT-CCM-ROUND METHOD, Fully Killed		Approved QAP No.:-		-----				
SPECIFICATION & GRADE :		ASTM A 106 / A53 / ASME SA 106 / SA 53 , EDD. - 2020 / 2021, NACE MR-0175 & MR-0103								
Sr. No.	GSTPL REF. HEAT NO.	SUPPLIER HEAT NO.	SIZE (Inch)		Quantity				General	
			OD X WT X LENGTH		Nos.	Mtrs.	Feet	MT.	End Condition	Coating
1	RG1241	23E00222	1-1/2" STD X 0.145" X 21.000"		1554	9947.15	32634.00	40.270	Plain End	Black Lacquered
2	RG1239	23D00363	1-1/2" SCH 80 X 0.200" X 21.000"		1147	7341.95	24087.00	39.750	Plain End	
3	RG1291	22F03530	2" STD X 0.154" X 21.000"		925	5920.93	19425.00	32.190	Bevel End	

CHEMICAL COMPOSITION (%)

Sr. No.	HEAT NO.	REQUIRED	%C	%Mn	%S	%P	%Si	%Cr	%Cu	%Mo	%Ni	%V	%CE
				Max	0.30	1.06	0.035	0.035	-	0.400	0.400	0.150	0.400
		MIN	-	0.29	-	-	0.100	-	-	-	-	-	-
1	23E00222	L1/A	0.173	0.650	0.003	0.020	0.150	0.010	0.001	0.001	0.001	0.001	0.283
	RG1241	P1/A	0.171	0.662	0.004	0.017	0.153	0.012	0.007	0.002	0.010	0.003	0.286
2	23D00363	L2/A	0.182	0.690	0.004	0.020	0.148	0.010	0.001	0.001	0.001	0.001	0.299
	RG1239	P2/A	0.180	0.693	0.006	0.019	0.151	0.011	0.006	0.003	0.010	0.003	0.300
3	22F03530	L3/A	0.165	0.690	0.004	0.015	0.140	0.011	0.001	0.001	0.001	0.001	0.282
	RG1291	P3/A	0.167	0.684	0.006	0.017	0.143	0.013	0.007	0.002	0.009	0.004	0.284

MECHANICAL PROPERTIES

Sr. No.	HEAT NO	REQUIRED	TENSILE STRENGTH (MPa)	YIELD STRENGTH (MPa)	ELONGATION (%)	HARDNESS (HRBW)	IMPACT TEST	FLATTENING TEST	FLARING TEST	Bend Test at 90°
			G.L. = 50 mm, G.W = 19.05 mm & Pipe Tested On Longitudinal Strip							
		Max	-	-	-	99 HRBW (Max)	-	-	-	-
		Min	415	240	For SI No 1 = 20%, For SI No 2 = 22% & For SI No 3 = 21%	-	-	-	-	-
1	RG1241		447.14	297.52	37.28	(66 - 67) HRBW	N/A	N/A	N/A	Satisfactory
2	RG1239		442.86	303.68	35.24	(67 - 68) HRBW	N/A	N/A	N/A	Satisfactory
3	RG1291		481.14	338.86	26.90	(70 - 71) HRBW	N/A	N/A	N/A	Satisfactory

NON-DESTRUCTIVE TEST

Sr. No.	HEAT NO	HYDRO-STATIC TEST as per SA530 (100%)	E.C.T. as Per ASTM E-309 (100%)	U.T. AS PER ASTM E-213 (100%)	SURFACE QUALITY		DIMENSION TOLERANCE as per Specification
					IN SIDE	OUT SIDE	
1	RG1241	2500 PSI, duration of 5 Sec. Satisfactory	Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory
2	RG1239		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory
3	RG1291		Satisfactory	N/A	Satisfactory	Satisfactory	Satisfactory

Heat Treatment : Heat Treated Above 650°C (1200°F)

MARKING : GSTP/LOGO/CDS/ASTM A106/A53 ASME SA106/SA53 GR B-S/NACE MR0175, MR0103/SIZE...../HYD. 2500 PSI/H. NO.... /MADE IN INDIA/PO NO. M2942

REMARKS: Legends: 1. L1/A= Ladle Analysis One, P1/A= Product Analysis One, 2. L2/A= Ladle Analysis Two, P2/A= Product Analysis Two, 3. L3/A= Ladle Analysis Three, P3/A= Product Analysis Three, 4. L4/A= Ladle Analysis Four, P4/A= Product Analysis Four, 5. N/A= Not Applicable.

- 100% Tubes Visual Surface Finish & Visual Dimensional Inspection Carried Out By "GSTPL" - Found Satisfactory.
- Mechanical Tests Carried Out By "GSTPL" - Found Satisfactory.
- Chemical Tests Carried Out By "GSTPL" - Found Satisfactory.
- 100% Hydrostatic Test Carried Out By "GSTPL" - Found Satisfactory.
- 100% Eddy Current Test Carried Out By "GSTPL" - Found Satisfactory.
- All The Materials are Free Of Mercury & Lead.

We hereby certify that the material herein described has been Manufacture Sample tested & Inspected in accordance with above standard & specification & satisfy the requirement.

For, GLOBAL SEAMLESS TUBES & PIPES PVT. LTD. (INDIA)




Global Seamless Tubes & Pipes Pvt. Ltd.
QA/QC Manager
Monojit Paul
MANAGER (QA/QC)

Sr. ENGINEER (QA/QC)

MANAGER (QA/QC)

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CORPORATE OFFICE : Plot-Y9, 3rd Floor, EP Block, Setor-V, Salt Lake City, Bidhannagar, Kolkata - 700 091

REGD. OFF : Plot-Y9, 3rd Floor, EP Block, Setor-V, Salt Lake City, Bidhannagar, Kolkata - 700 091

Mob : +91 9051134600 **CIN-U29299WB2019PTC231524**

Web : www.globalseamless.com **EMAIL :** sales@globalseamless.com

WE DO NOT ENCOURAGE ANY CHINESE SUBSTRATE