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Type Inspection Certificate 3.1 EN 10204

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Number 10522600959 Issued On 29/09/2022

WELDING PROCESS QUALIFICATION: ALL LASER WELDING PROCESS ARE QUALIFIED IN ACCORDING EN STANDARDS AND DIRECTIVE PED 2014/68/EU ALL.I PAR.3.1.2 BY THE NOTIFIED BODY 0474 (RINA). THE WPS/WPAR ARE AVAILABLE ON REQUEST AT THE MARCEGAGLIA SPECIALTIES FACTORY IN FORLIMPOPOLI - FC - ITALY.
WPS LASER ACCORDING TO UNI EN ISO 15609-4; WPAR LASER ACCORDING TO UNI EN ISO 15614-11 AND AD2000-MERKBLATT HP 2/1
ALL LASER WELDING OPERATORS ARE QUALIFIED IN ACCORDING TO UNI EN ISO 14732; ALL NDT-ET OPERATORS ARE QUALIFIED IN ACCORDING TO UNI EN ISO 9712

Customer
INVESTA SP. Z O.O.
UL.ZASTAWNA 27
83000 PRUSZCZ GDANSKI PL

Code: 0000023130

Consignee
Investa Sp. z o.o.
Smolice 1g, Tulipan Park - Hal
95010 Stryków PL

Delivery Nn 8365816077
Of 29/09/2022
Delivery note nr 1005008488

Quality Control
Q.M.D./Q.M. S.Toscana
Plant Of Forlì

Pages
20/25

Material
59004664

Test specification: EN 10217-7 TC1

Welding process
LASER WELDING

Order Nr
1191539835/80

Client Order
CZZ22C01551

Description
TXT002 33,7x2,6x6000 TP304L LAS Z

Stainless steel grade: 14307TP 304L 1.4307/1.4301 X2CrNi18-9/X5CrNi18-10
Tolerances: ISO 1127 D3-T3

Part Number

Client Date
22/09/2022

Item	Identification Nr	Heat	Quantity MTL	Quantity KG	Quantity PZZ	Delivery conditions	Reworks
1	22RE002101	0543118	366	700	61	W0	BRUSHED
2	22RE002108	0543682	216	417	36		

WE CERTIFY THAT THE ABOVE MENTIONED PRODUCTS COMPLY WITH THE TERMS OF ORDER CONTRACT AND THE STANDARDS RECALLED IN THE PRESENT TEST CERTIFICATE

Identification Nr	Chemical Type	C (%)	Si (%)	Mn (%)	P (%)	S (%)	N (%)	Cr (%)	Ni (%)
		0.03	1	2	0.045	0.015	0.11	17.5 19.5	8 10
22RE002101	RAW MATERIAL	.027	.370	1.720	.0310	.0010	.0750	18.100	8.060
22RE002108	RAW MATERIAL	.026	.350	1.740	.0300	.0010	.0720	18.060	8.090

Identification Nr	Type of mechanical test	Rp 0.2 [MPa]	Rp 1.0 [MPa]	Rm [MPa]	A5 (%)
		180	215	470 670	40
22RE002101	TUBE	371	411	600	49.9
22RE002108	TUBE	371	410	600	49.6

MARCEGAGLIA SPECIALTIES FORLIMPOPOLI PLANT SYSTEM CERTIFICATIONS QUALITY SYSTEM CERTIFIED ACCORDING TO EN 9001:2015 AND IATF 16949:2016 AND ISO 3834-2:2005 AND A SAFETY SYSTEM CERTIFIED ACCORDING TO ISO 45001:2018 AND AN ENVIRONMENTAL SYSTEM CERTIFIED ACCORDING TO ISO 14001:2015 AND ENERGY SYSTEM CERTIFIED ACCORDING TO ISO 50001:2018
MARCEGAGLIA SPECIALTIES FORLIMPOPOLI PRODUCT CERTIFICATIONS DVGW ACCORDING TO GW541 LASER AND TIG WELDED TUBES STAINLESS STEEL GRADE 1.4404 DIA FROM 15.00 TO 108.00MM AND GRADE 1.4521 FROM 15.00 TO 54.00MM.
TUV AD2000 W2/W10 AND PED ANNEX I, PARAGRAPH 4.3 LASER AND TIG WELDED TUBES STAINLESS STEEL GRADE 1.4301, 1.4306, 1.4307, 1.4401, 1.4404, 1.4511, 1.4435, 1.4436 THICKNESS FROM 0.80 TO 4.00MM AND DIAMETERS FROM 8.00 TO 283.00 MM. EHEDG FOR DAIRY TUBES TXT015. EUROPEAN DIRECTIVE 1935:2004 FOR DAIRY TUBES TXT003, TXT014, TXT015.

NON DESTRUCTIVE TESTS
EDDY CURRENT TEST FOR THE VERIFICATION OF HYDRAULIC LEAKTIGHTNESS ACCORDING TO EN ISO 10893-1:2011: CONFORM
EDDY CURRENT TEST FOR THE DETECTION OF IMPERFECTIONS ACCORDING TO EN ISO 10893-2:2011: CONFORM
ANTIMIXING TEST: CONFORM
VISUAL INSPECTION AND DIMENSIONAL CONTROLS: CONFORM

DESTRUCTIVE TESTS
DRIFT EXPANDING TEST ACCORDING TO EN ISO 8493:2005: CONFORM
FLATTENING TEST ACCORDING TO EN ISO 8492:2004: CONFORM
RING EXPANDING TEST ACCORDING TO EN ISO 8495:2004: CONFORM
TENSILE TEST ACCORDING TO EN ISO 6892-1:2009
INTERGRANULAR CORROSION TEST ACCORDING TO EN ISO 3651-2:1998: CONFORM

Marking
(LGO:MARCEGAGLIA) \$Diametro\$ X \$Spessore_Nom\$ Heat n°\$Colata\$ EN 1.4301 / EN 1.4307 - TP 304 / TP 304L EN 10217-7 TC1 \$Stato di Fornitura\$ \$Sigla\$ \$Data\$ \$Ora\$

Remarks:
CHEMICAL COMPOSITION ACCORDING TO EN 10028-7 TUBE TO EN 10217-7 TC1 AND DIRECTIVE 2014/68/EU (PED), WELDING FACTOR V=1