

0341392	Project: Oseberg project_OGP			Client: AIBEL AS		
Order no.	Item no.	Client Art. code	LOT No	Heat code	QTY	Description
4500304867	00280	Q-STB00040M4L330		RF0350-A156	344,00	BOLT-STUD C/W 2 NUTS M42 330.0MM /ASTM F467/F468 NI625 (UNS N06625)



CERTIFICATE OF TEST

EN 10204 3.1

SO No : SN20220929010

CUSTOMER : SCANDINAVIAN FITTINGS AND FLANGES

P/O No. : 11994

POR No. : N/A

PJT.NAME(No.): N/A

DATE : 2022-12-30

HULL No. : N/A

CERT. No. : QI20221230005-1

0028	STUD B/2HEX N M42X330L	344 ST			
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SR No.	DESCRIPTION		Q'ty	Material	Heat No	Lot No	Heat Treatment(*C/Hr)	
							Quenching	Tempering
0028	1	STUD BOLT		344EA ASTM F468-NI625	RF0350	PD202209290145-1		
0028	2	HEX NUT		688EA ASTM F467-NI625	RF0133	PD202209290145-2		

SR No.				C X 100	Mn X 100	Si X 100	P X 1000	S X 1000	Ni X 10	Cr X 10	Mo X 10	Al X 100	Ti X 100	Nb X 10	Co X 100	Fe X 10
S T D	0028	1	1	0 - 10	0 - 50	0 - 50	0 - 15	0 - 15	580 MIN	200 - 230	80 - 100	0 - 40	0 - 40	32 - 42	0 - 100	0 - 50
	0028	2	1	0 - 10	0 - 50	0 - 50	0 - 15	0 - 15	580 MIN	200 - 230	80 - 100	0 - 40	0 - 40	32 - 42	0 - 100	0 - 50
A C T	0028	1	1	1.9	1.7	4.9	2.0	0.6	665.2	209.4	81.9	14.3	11.4	33.3	1.2	3.9
	0028	2	1	2.5	14.4	17.8	1.0	5.6	619.5	214.8	82.0	24.7	30.7	35.1	28.0	39.0

SR No.			TENSILE TEST			EL(%)	R/A(%)	HARDNESS		IMPACT TEST CONDITION			
			Y/S	T/S	UNIT								
S T D	0028	1	1	415 MIN	825 MIN	MPa	30 MIN	HRC	35 MAX				
	0028	2	1					HRC	35 MAX				
A C T	0028	1	1	484.61	883.12	MPa	54.34	HRC	16.0	TENSILE SPECIMEN			
	0028	2	1					HRC	18.0	IMPACT TEST RESULT			

SR No.			PROOF LOAD		FULL SIZE TEST		T.COEF	REMARKS
S T D	0028	2	1	465,215	N			
A C T	0028	2	1	ACCEPTED				
	A	B	C	★ SR No. A: Item No., B: Traveler No., C: Specimen No.				

* Melting Method: VIM+ESR

 * Solution annealed
 - Bolt : 1000°Cx0.5HxO.C
 - Nut : 900°Cx0.5HxO.C

* ID No.: RF0350(BOLT), A156(NUT)

* Hardness Spec.: HRB 85-HRC 35

 * PMI TEST(100%) : Satisfactory
 * Liquid Penetrant Examination (10%) : No Recordable Indication.
 * NACE MR0175/ISO 15156 : Satisfactory
 * Dimension & Visual Inspection : GOOD
 * App. Code
 - ASTM F468M-06/F467M-06a
 - TR2000 MDS VN708/VN707+DIN976/ISO4032

We hereby certify that the material described herein has been satisfactorily tested as above in accordance with the specification.
 The result of Test & Examination were reported in accordance with EN 10204 3.1

☐ WITNESSED BY:

☐ REVIEWED BY:

 MANAGER OF QUALITY:
 CONTROL DEPT.

Our quality system is certified in accordance with ISO 9001-2015 by LRQA.

Chung Sung Gun