



靖江特殊钢有限公司

JINGJIANG SPECIAL STEEL CO.,LTD.

Contract-Item No. 11010913002

Sheet No. : 21GC003199-1

Customer: WINSTEEL GROUP LIMITED

Product : SEAMLESS STEEL PIPES

Original: Made in China

Number: R08-328/5-10

Add: No.21 Xingang Road Jingjiang Economic Development Zone, Taizhou City, Jiangsu Province, PRC.

Tel: 008652380708043, Fax: 008652380708619

https://jjtg.citicsteel.com/

CERTIFICATE OF CONFORMANCE

ACC.TO EN 10204 3.1

Spec. No.		API SPEC 5L 46th-2018+Errata 1 PSL2					Steel Grade X60QS		Process of manufacture		HR SMLS	Type of heat treatment		Q&T	PO.NO.	Date	2021/2/10		
NO.	Size (mm)	Length (m)	Heat No.	Lot No.	PCS	WT (t)	Total length (m)	Bundles	Tensile Test			% Shear area	Grain Size (Gras-4e)	Impact Test		Hardness Test		Hydrostatic Test (MPa)	Duration of Time (s) ≥
									Sample Type / Orientation / Dimension / GL (mm)	T.S (Rm) (MPa)	Y.S (Cl) (MPa)			E.L % (A)	Impact Sample Type / Dimension (mm)	KV ₂ Impact Value (J) (-29°C)	Hardness Value NACE MR0175 (HV10)		
1	114.3*18.5	9.5-10.5	0077839F	T220177280	32	14.498	333.84	7	C/L8.9/50	606/603	540/543	23.5/23.5	/	/	T/10	263/281/268	197/199/200/199/206/198/202/204/195/198/196/200	20.5	6
2																			
3																			

NO.	Composition Type	Chemical Composition %																							
		C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	V	Nb	Ti	Pb	C/Mn	Sb	Bi	Ca	N	H	CE _{PCM}	CE _{ITW}	B	AlN
1	R	0.14	0.22	1.09	0.011	0.002	0.14	0.04	0.05	0.016	0.020	0.055	0.030	0.016	/	0.13	/	/	0.0010	0.0060	/		0.37	0.0002	
	C	0.15	0.22	1.12	0.011	0.002	0.13	0.04	0.05	0.014	0.020	0.050	0.031	0.018	/	0.13	/	/	0.0010	0.0061	/		0.38	0.0003	
	C	0.15	0.23	1.14	0.011	0.002	0.14	0.04	0.05	0.014	0.020	0.051	0.032	0.019	/	0.13	/	/	0.0010	0.0058	/		0.39	0.0003	
2	R																								
	C																								
	C																								
3	R																								
	C																								
	C																								



Total Bundles	Total Pieces	Total Length (m)	Total Weight (t)	Cold Bending Test	Surface & Dimension	Pipe End (PE, BE)	Flatten	Flaring	Non-destructive Inspection						
									NDT Type	NDT Method	NDT Standard	NDT Area/Coverage	NDT Orientation	Level/Defect size	Result
7	32	333.84	14.498	/	Qualified	BE	/	/	NDT Type: Defect(Body) UT, Defect(End) UT, WT(Body) UT, Lamination(Body) UT, Lamination(End) UT	NDT Method: UT, UT, UT, UT, UT	NDT Standard: ASTM E213-20, ASTM E213-20, ASTM E114-15, ISO 10893-8-2011, ISO 10893-8-2011	NDT Area/Coverage: IN+EX, IN+EX, Thickness coverage ≥ 25%, Thickness coverage ≥ 20%, Pipe End 50mm	NDT Orientation: L+T, L+T, /, /	Level/Defect size: U2/C, U2/C, /, /, 15*8mm*30%WT, 15*6mm*30%WT	Result: Qualified, Qualified, Qualified, Qualified, Qualified

Notes: Tensile Test: Sample Orientation: T= Transverse, L= Longitudinal. Tensile Sample Type: S= Strip, C= Chubbled, F= Full-section, GL= Gauge Length. Yield Strength Selection: C1= R0.5, C2= Rel, C3= ReH, C4= Rp0.2. Impact Test: T= Transverse, L= Longitudinal. Impact Sample Dimension: 10*10*55mm, 7.5*10*7.5*55mm, 5*10*5*55mm. Composition Type: R- Heat Analysis, C- Product Analysis. CE_{ITW}= C+Mn/6+(Cr+Mo+V)/5+(Cu+Ni)/15. CE_{PCM}= C+Si/39+(Mn+Cr+Cu)/20+Ni/60+Mn/15+V/10+5*B. N= Normalizing, Q= Quenching, HR= Hot Rolled, Q&T= Quenching and Tempering, N&T= Normalizing and Tempering. PE= plain end, BE= bevel end. IN: Internal Surface, EX: External Surface, L: Longitudinally, T: Transversely.

Remarks: 1. We here certify that the products here in described has been manufactured. 2. Sampled tested and inspected in accordance with the specification and purchase order, and meet with the requirement. 3. All pipes be made free of radiation contamination. P7512-TS-2000-P-0009 Rev B4

Remarks: No duplicate will be accepted

Certification Maker: 甄娜

甄娜

Auditors: 王艳红

王艳红

Quality Manager: 胡双凯

胡双凯



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NO.	Size (mm)	Length m	Heat No.	Lot No.	PCS	WT (t)	Total length m	Bundles	Tensile Test			% Shear area	Grain Size (Gra-de)	Impact Test		Hardness Test		Hydrostatic Test	Duration of Time (s)
									Sample Type /Orientation /Dimension/GL (mm)	T.S (Rm) MPa	Y.S (CI) MPa			E.L.%(A)	Impact Sample Type/Dimension (mm)	KV ₁ Impact Value(J) -29℃	Hardness Value NACE MR0175 HV10		
1	168.3*26	8.0-9.0	1070381Z	T221007970	46	37.106	403.07	16	C/L12.7/50	575/566	474/472	34/31.5	/	/	T/10	290/297/292	185/186/186/189/199/189/188/189/183/185/188/191	20.5	6
2	168.3*26	8.0-9.0	1070381E	T221007960	24	19.106	206.37	8	C/L12.7/50	581/572	497/463	29/33.0	/	/	T/10	281/284/266	192/190/189/184/192/194/187/186/186/187/189/190	20.5	6
3																			

NO.	Composition Type	Chemical Composition %																							
		C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	V	Nb	Ti	Pb	C/Mn	Sb	Bi	Ca	N	H	CE _{PCM}	CE _{PM}	B	Al/N
1	R	0.13	0.25	1.10	0.006	0.002	0.11	0.04	0.06	0.032	0.020	0.058	0.033	0.020	/	0.12	/	/	0.0017	0.0065	/	0.36	0.0003		
	C	0.14	0.25	1.11	0.008	0.002	0.09	0.04	0.05	0.030	0.020	0.059	0.035	0.019	/	0.13	/	/	0.0016	0.0070	/	0.37	0.0003		
	C	0.14	0.25	1.10	0.007	0.002	0.09	0.04	0.05	0.032	0.020	0.059	0.033	0.019	/	0.13	/	/	0.0016	0.0068	/	0.36	0.0003		
2	R	0.13	0.25	1.10	0.006	0.002	0.11	0.04	0.06	0.032	0.020	0.058	0.033	0.020	/	0.12	/	/	0.0017	0.0065	/	0.36	0.0003		
	C	0.14	0.25	1.10	0.007	0.002	0.09	0.04	0.05	0.032	0.020	0.059	0.033	0.019	/	0.13	/	/	0.0015	0.0068	/	0.36	0.0003		
	C	0.14	0.25	1.11	0.008	0.002	0.09	0.04	0.05	0.030	0.020	0.059	0.035	0.019	/	0.13	/	/	0.0015	0.0070	/	0.37	0.0003		
3	R																								
	C																								
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Total Bundles	Total Pieces	Total Length	Total Weight (t)	Cold Bending Test	Surface & Dimension	Pipe End (PE,BE)	Flatten	Flaring	Non-destructive Inspection						
		m							NDT Type	NDT Method	NDT Standard	NDT Area/Coverage	NDT Orientation	Level/Defect size	Result
24	70	609.44	56.212	/	Qualified	BE	/	/	Defect(Body)	UT	ASTM E213-20	IN+EX	L+T	U2/C	Qualified
									Defect(End)	UT	ASTM E213-20	IN+EX	L+T	U2/C	Qualified
									WT(Body)	UT	ASTM E114-15	Thickness coverage ≥25%	/	/	Qualified
									Lamination(Body)	UT	ISO 10893-8-2011	Thickness coverage ≥20%	/	15*8mm*30%WT	Qualified
									Lamination(End)	UT	ISO 10893-8-2011	Pipe End 50mm	/	15*6mm*30%WT	Qualified

Notes: Tensile Test: Sample Orientation: T= Transverse, L= Longitudinal. Tensile Sample Type: S= Strip, C= Clubbed, F= Full-section, GL= Gauge Length. Yield Strength Selection: C1= R_{0.5}, C2= R_{0.1}, C3= R_{0.1}, C4= R_{p0.2}. Impact Test: T= Transverse, L= Longitudinal. Impact Sample Dimension: 10*10*55mm, 7.5*10*75*55mm, 5*10*55*55mm. Composition Type: R= Heat Analysis, C= Product Analysis. CE_{PM}=C+Mn/6+(Cr+Mo+V)/5+(Cu+Ni)/15 CE_{PCM}=C+Si/30+(Mn+Cr+Cu)/20+Ni/60+Mo/15+V/10*5*B N= Normalizing Q= Quenching HR= Hot Rolled Q&T= Quenching and Tempering N&T= Normalizing and Tempering PE= plain end BE= bevel end. IN: Internal Surface; EX: External Surface; L: Longitudinally; T: Transversely

Remarks: 1. We here certify that the products here in described has been manufactured. 2. Sampled tested and inspected in accordance with the specification and purchase order, and meet with the requirement. 3. All pipes be made free of radiation contamination. P7512-TS-2000-P-0009 Rev B4

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