

I.C.I. di Meroni Michele

IMPIANTI CHIMICI INDUSTRIALI

Via Don Minzoni, 14 - Tel. (039) 6040239

Telefax (039) 6049943

20049 CONCOREZZO (Milano)

Date : 20-07-2012

INSPECTION BOOK

CUSTOMER : DESMET BALLESTRA SpA

JOB : 2F11A

ORDER N°. : 121256

ITEM : 63AB1

ITEM IN OBJECT : PULSATION DAMPENER

TABLE OF CONTENT:

I.C.I. GI MERONI MICHELE
Via Don Minzoni, 14
20049 CONCOREZZO (MI)
Inspector
Lauro Gulinai
Level II ISNT-TC-IA
Level II UNI-EN 473 AS PER PED

- | | |
|-----|-------------------------------|
| 1 - | CERTIFICATE OF COMPLIANCE |
| 2 - | VISUAL AND DIMENSIONAL REPORT |
| 3 - | PAINTING REPORT |
| 4 - | QUALITY CONTROL PLAN |
| 5 - | MATERIAL MAP |
| 6 - | MATERIAL CERTIFICATE |
| 7 - | MATERIAL SUMMARY |

I.C.I. di Meroni Michele IMPIANTI CHIMICI INDUSTRIALI Via Don Minzoni, 14 - Tel. (039) 6040239 Telefax (039) 6049943 20049 CONCOREZZO (Milano)		CERTIFICATO DI CONFORMITA' <i>CERTIFICATE OF COMPLIANCE</i> CUSTOMER : BALLESTRA S.p.A. JOB N° 2F11A Purchase Order N°. : 121256	
ITEM :	63AB1		
Description :	PULSATION DAMPENER		
DATA SHEET N°.	2F11A-35-121 Rev. 1		
Constructive Dwg. N°.	ST. 24527 Rev. 6		
<p style="text-align: center;">SI CERTIFICA CHE IL MATERIALE RISULTA CONFORME A QUANTO RICHIESTO DAI DISEGNI, DALL' ORDINE ED ALLE SPECIFICHE IN ESSI RICHIAMATI.</p> <p style="text-align: center;">WE HEREBY CERTIFY THAT THE MATERIAL IS IN COMPLETELY ACCORDANCE WITH THE DRAWINGS, THE ORDER AND THE SPECIFICATIONS NOTED IN ABOVE MENTIONED DOCUMENTS.</p>			
<i>ICl di MERONI MICHELE</i> I.C.I. di MERONI MICHELE Via Don Minzoni, 14 20049 CONCOREZZO (MI) Inspector Lauro Gulmini Level II SNT-TC-IA Level II UNI-EN-473 AS PER PED		CUSTOMER INSPECTOR	

0	I.C.I.	20/07/2012	G.Meroni		L.Gulmini	20/07/2012
Rev.	Issued by	Date	Checked by	Date	Approved by	Date
REV.	Emesso da	Data	Controllato da	Data	Approvato da	Data

I.C.I. di Meroni Michele

IMPIANTI CHIMICI INDUSTRIALI

Via Don Minzoni, 14 - Tel. (039) 6040239
 Telefax (039) 6049943
 20049 CONCOREZZO (Milano)
 N. Codice fiscale MRN MHL 23L26C952B
 N. Partita I.V.A. 00385930961

DATA : 20-07-2012

VISUAL AND DIMENSIONAL REPORT

Customer	<i>DESMET BALLESTRA S.p.A.</i>
Customer Order No.	121256
Job	2F11A
Item	63AB1
Description	PULSATION DAMPENER
Data sheet	2F11-35-121 Rev.1
Constructive Dwg.	ST. 24527 Rev. 6

Si dichiara che il controllo visivo e dimensionale eseguito in accordo ai disegni ed alle specifiche BALLESTRA ha avuto esito positivo.

We certify that the visual and dimensional control has been performed according to the drawings and BALLESTRA's specification with positive result.

I.C.I di Meroni Michele

I.C.I. di MERONI MICHELE
 Via Don Minzoni, 14
 20049 CONCOREZZO (MI)
 Inspector
 Lauro Gulmini
 Level II STT-TC-IA
 Level II UNI-EN 473 AS PER PED

CUSTOMER INSPECTOR

0	ICI	20/07/2012	G.Meroni	20/07/2012	L.Gulmini	20/07/2012
Rev. REV.	Issued by Emesso da	Date Data	Checked by Controllato da	Date Data	Approved by Approvato da	Date Data

I.C.I. di Meroni Michele

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20049 CONCOREZZO (Milano)

N. Codice fiscale MRN MHL 23L26C952B

N. Partita I.V.A. 00385930961

Date : 20 - 07 - 2012

PAINTING REPORT
(For apparatus in Carbon steel)

Customer	<i>DESMET BALLESTRA S.p.A</i>
Customer Order No.	121256
Job	2F11A
Item	63AB1
Description	PULSATION DAMPENER
Data sheet	2F11-35-121 Rev. 1
Constructive Dwg.	ST. 24527 Rev. 6

Il ciclo di verniciatura su superfici esterne è stato eseguito in accordo alla specifica Ballestra SB-ATI-SP002/4 utilizzando zincante inorganico.

The external painting cycle has been performed, according to the Ballestra's specification SB-ATI-SP002/4 with inorganic zinc.

Dichiariamo che il risultato finale è soddisfacente.
We certify that the final result is satisfactory.

I.C.I. di MERONI MICHELE

CUSTOMER INSPECTOR

I.C.I. di MERONI MICHELE
Via Don Minzoni, 14
20049 CONCOREZZO (MI)
Inspector
Ladro Gulmini
Level II SNT-TC-IA
Level II UNI EN 473 AS PER PED

I.C.I. di Meroni Michele

IMPIANTI CHIMICI INDUSTRIALI

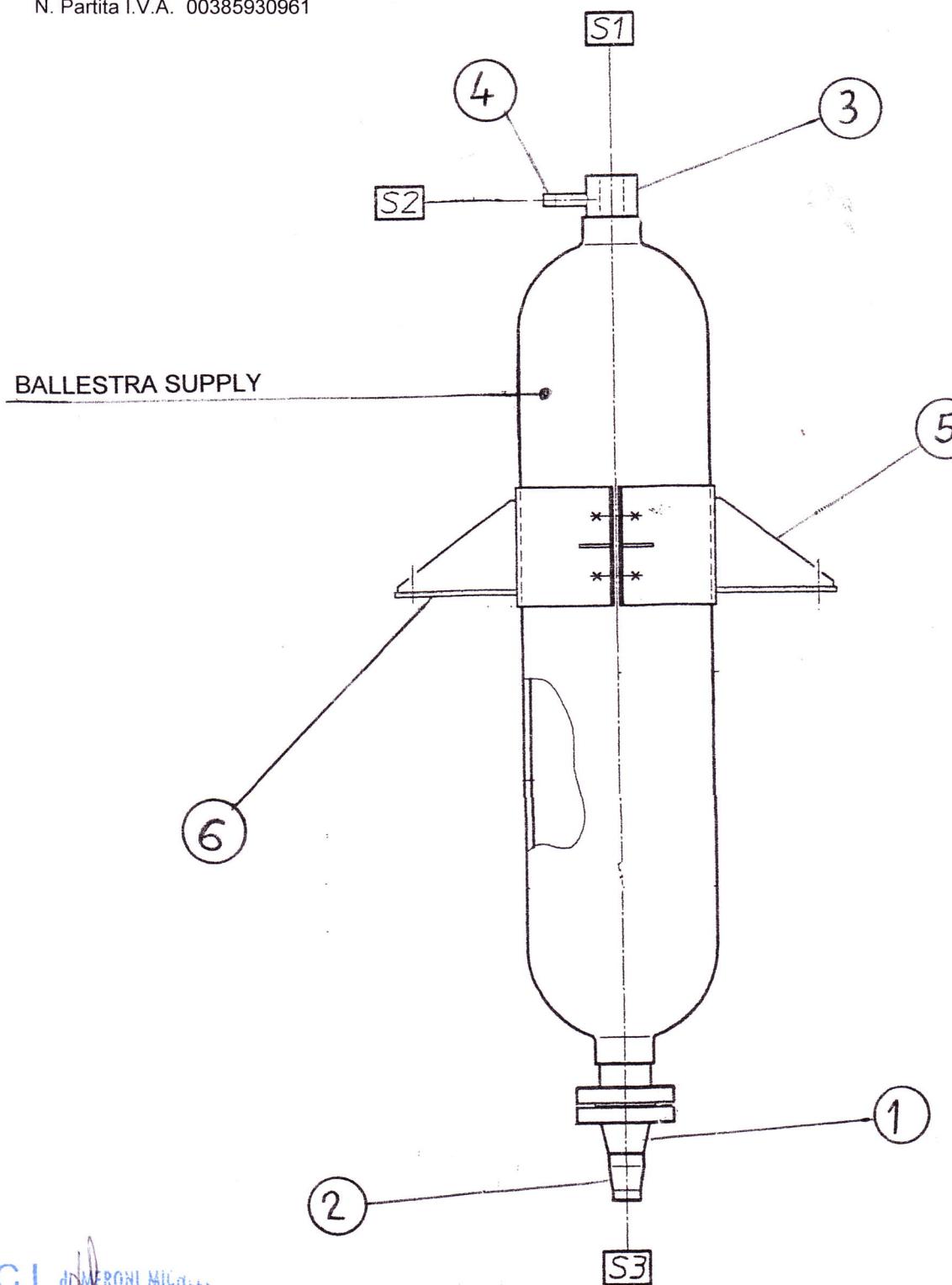
Via Don Minzoni, 14 - Tel. (039) 6040239

Telefax (039) 6049943

20049 CONCOREZZO (Milano)

N. Codice fiscale MRN MHL 23L26C952B

N. Partita I.V.A. 00385930961



I.C.I. di MERONI MICHELE

Via Don Minzoni, 14

20049 CONCOREZZO (MI)

ITEM 63AB1

Job. 2F11A- Dwg 2F11-35-121 Rev.1 Ord.121256

MATERIAL MAP

PULSATION DAMPENER

I.C.I. di Meroni Michele
IMPIANTI CHIMICI INDUSTRIALI
Via Don Minzoni, 14 - Tel. (039) 6040239
Telefax (039) 6049943
20049 CONCOREZZO (Milano)
N. Codice fiscale MRN MHL 23L26C952B
N. Partita I.V.A. 00385930961

MATERIAL SUMMARY

DESMET BALLESTRA

Job : 2F11A

ITEM : 63AB1 - ACCESSORIES FOR PULSATION DAMPENER

* ASTM or equivalent material

Pos.	Description	Type	Thk.	N°	Material	Trade Mark	Cert. N°.	Heat N°.
1	Flange	ASA 600# WN DN 2"	-----	1	A 105	Duevi	001742	74611
2	Reducer	2" x 1.1/2"	-----	1	A234 WPB	Duevi	001742	6F3163
3	Superior clutch	Round Dia 115	-----	1	A105	Acciai Brianza	006696	AB/8438
4	Nozzle "S2"	Dia 21,3	3,73	1	A106B	Zeleziane Podbrezova	27506/1/2008	81432
5	Rib saddle	Sheet	5	4	S235JR	Siderurgica Astico	200603910	C623283
6	Base saddle	Sheet	8	2	S235JR	Siderurgica Astico	2005/077465/02	592969

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 20049 CONCOREZZO (MI)

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N. Codice fiscale MRN MHL 23L26C952B

N. Partita I.V.A. 00385930961

Material Certificate



(1) (2)

CERTIFICATO DI COLLAUDO EN 10204-3.1
 EN 10204-3.1 TEST CERTIFICATE
 MOD. CP_REV.2 DEL 12.03.2012

Numero 001742	Data 18/06/2012	Pagina 2
Ns. DDT nr. 1812	Data 18/06/2012	Vs. ordine nr. Data

Spett.le/Messrs.

I.C.I.

di Meroni Michele

VIA DON MINZONI, 14

20863 CONCOREZZO - MB

IT

COLATA/HEAT NR. COD. INT. MAT./MAT. INT. CODE ACCIAIERIA /STEEL PLANT										Q.TA/Q.TY	DESCRIZIONE/DESCRIPTION						
74611 A105 EUROPE										1	FL. A105 WNLM A600 2" STD						
ANALISI CHIMICA/ CHEMICAL ANALYSIS																	
%C	%Mn	%Si	%P	%S	%Cr	%Ni	%Mo	%Ti	%V	%Cu	%Al	%Sn	%Nb	%N	%Fe	%W	%Co
0,185	0,980	0,220	0,013	0,014	0,120	0,050	0,010	0,006	0,001	0,190	0,023						
%Ca	%B	%Sb	%As	%Pb	%Ta		CE										
							0,391										
According to nace MR01.75 Last Edition <input type="checkbox"/>																	
PROVE MECCANICHE/MECHANICAL TESTS																	
RS-YIELD (N/mm ²)	R-TENSILE (N/mm ²)	ELONGATION (%)	REDUCTION (%)	RESILIANZA/IMPACT TEST (J)			MATERIALE IN ACCORDO A MATERIAL IN ACCORDANCE TO			TEMPER (°C)	HARDNESS (HB)	(1)	(2)	(3)	(4)		
329,0	532,0	33,0	58,0	MAX	MED.	MIN.	ASTM/ASME A/SA105			20	163-165	A	A	X	X		
After tests forgins are in according with normes CONTROLLI IN PRODUZIONE / PRODUCTION TESTS VISIVO/VISUAL DIMENSIONALE/DIMENSIONAL																	
<input checked="" type="checkbox"/> SATISFACTORY <input type="checkbox"/> SATISFACTORY																	

COLATA/HEAT NR. COD. INT. MAT./MAT. INT. CODE ACCIAIERIA /STEEL PLANT										Q.TA/Q.TY	DESCRIZIONE/DESCRIPTION						
6F3163 WPB										1	RIDUZ. CONCENTRICA WPB 2" X 1.1/2" STD						
ANALISI CHIMICA/ CHEMICAL ANALYSIS																	
%C	%Mn	%Si	%P	%S	%Cr	%Ni	%Mo	%Ti	%V	%Cu	%Al	%Sn	%Nb	%N	%Fe	%W	%Co
0,220	0,450	0,180	0,016	0,003	0,030	0,010	0,010	0,004	0,004	0,040							
%Ca	%B	%Sb	%As	%Pb	%Ta		CE										
							0,307										
According to nace MR01.75 Last Edition <input type="checkbox"/>																	
PROVE MECCANICHE/MECHANICAL TESTS																	
RS-YIELD (N/mm ²)	R-TENSILE (N/mm ²)	ELONGATION (%)	REDUCTION (%)	RESILIANZA/IMPACT TEST (J)			MATERIALE IN ACCORDO A MATERIAL IN ACCORDANCE TO			TEMPER (°C)	HARDNESS (HB)	(1)	(2)	(3)	(4)		
290,0	440,0	29,0		MAX	MED.	MIN.	ASTM/ASME A/SA234 WPB			134	A	A	X	X			
After tests forgins are in according with normes CONTROLLI IN PRODUZIONE / PRODUCTION TESTS VISIVO/VISUAL DIMENSIONALE/DIMENSIONAL																	
<input checked="" type="checkbox"/> SATISFACTORY <input type="checkbox"/> SATISFACTORY																	

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I.C.I. di MERONI MICHELE

Via Don Minzoni, 14
 20049 CONCOREZZO (MI)

- (1) PRODUZIONE ACCIAIO
Steel Production A - CAIMATO ELABORATO AL FORNO ELETTRICO
Killed steel made by electric furnace
- B - ELABORATO AL FORNO ELETTRICO
Made by electric furnace
- (2) TRATTAMENTO TERMICO
Heat treatment A - NORMALIZZATO B - NORMALIZZATO E RINVENTATO
Normalized Normalized and tempered
- C - BONIFICATO D - SOLUBILIZZATO
Quenched and tempered Solution treatment and quenched
- (3) X - CERTIFICATO SECONDO EN 10204/3.1
Certificate according to EN 10204/3.1
- (4) X - CONTROLLO VISIVO E DIMENSIONALE SODDISFALENTE
Satisfactory visual and dimensional test

(CE) C + Mn/6 + (Cr + Mo + V)/5 + (Ni Cu)/15

Conforme al certificato originale rilasciato dall'acciaieria o forgiato e relativo laboratorio di analisi e prove.
 According to original certification issued by steel plant and relative analysis and tests laboratory.

TRADEMARK	REDATTO E APPROVATO DA DUEVI s.r.l. FORNITURE IND.	ISPETTORE
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Acciai Brianza S.r.l.

Sede : Desio (MI) - Via Filippo Da Besta, 3

tel. 036231135 fax 0362301451

Per la lavorazione e la lavorazione degli acciai

LAMINATI, TRAFILATI, LEGNAMI, RIFERIMENTI

IN ACCIAIO COMUNE E INOX, ALTA E MIGLIOSSIMA

ACCIAI SPECIALI, COSTRUZIONI E DATTENSIBILI

Cliente VIMEFER SNC

Kundie

VIA MILANO 44

Customer

20059 VIMERCATE (MI)

Client

Misura / material/materiali/materici

Norme di prodotto / nome / nome / nome

Fe 360 TRAFILATO PIATTO 220 x 20
UNI 10233/5-93

C 45 LAMINATO PIATTO 200 x 40
UNI EN 10083/93

ASTM A 105 LAMINATO Tondo 115,
ASTM A 105M/96c

Fe 360 TRAFILATO PIATTO 100 x 15
UNI 10233/5-93

Fe 360 TRAFILATO Quadro 10 x 10
UNI 10233/5-93

Fe 360 TRAFILATO PIATTO 40 x 20
UNI 10233/5-93

Fe 360 TRAFILATO PIATTO 25 x 4
UNI 10233/5-93

Fe 360 TRAFILATO PIATTO 10 x 2
UNI 10233/5-93

Fe 360 TRAFILATO Esag. 17
UNI 10233/5-93

Fe 360 TRAFILATO Tondo 60
UNI 10233/5-93

Colata

Chiodatura/confezione

AB/17060

C

0,430

Si

0,270

Pb

0,016

Sn

0,730

B

0,014

Cr

0,014

Co

0,009

Ca

0,012

S

0,039

Cr

0,120

Mo

0,010

Cu

0,020

W

Si

0,010

Cu

0,020

W

Si

0,010

W

Si

0,140

Cu

0,033

Mo

0,116

Co

0,007

Ca

0,003

Cr

0,008

Cr

0,015

Si

0,008

Cr

0,010

W

Si

0,010

Cr

0,022

Cr

0,009

Co

0,012

Cr

0,009

Cr

0,012

Cr

0,008

Cr

0,007

Sn

0,540

B

0,021

Cr

0,024

Cr

0,012

Ca

0,008

Cr

0,008

Cr

0,007

Sn

0,450

B

0,021

Cr

0,011

Sn

0,005

Cr

0,010

Mo

0,010

Co

0,008

Cr

0,007

Sn

0,400

Pb

0,070

Sn

0,300

B

0,011

Ca

0,001

Cr

0,010

Co

0,008

Cr

0,007

Sn

0,400

Pb

0,070

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Sn

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B

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Ca

(4)



Inšpekčný certifikát
Inspection certificate
EN 10204:2004/3.1

Číslo
Number

27506/1/2008

List č. - Sheet No.: 1 / 2

Čext.obj. - External order No.:
080953

Číslo položky - Item number:
3

Č.obj prij. - Consignee order No.:
52/08

Číslo základky výrobcu - Manufacturer's works order number:
Dv 88576/1/ 3823050

Číslo dopravného prostriedku - Wagon No.:
BR794BC BR915YC

Číslo ložného listu - Loading Bill No.:
333454

Číslo aviza - Dispatch note:
3824483

Výrobok - Product:

Rúry oceľové bezošvé, valcované za tepla - rúry pre potrubia pre horúcu hmotnosť
Seamless hot finished steel tubes - pipelines for combustible fluids

IL PRESENTE CERTIFICATO E VALIDO PER		
CLIENTE VIMONT SNC.		
ORDINE NR. DEL		
N°	Mt.	kg. 50
HOT 20/07/2012		

Vonkajší priemer - Outside diameter: **21.300 mm**

Hrubka steny - Wall thickness: **3.730 mm**

Dĺžka - Length: **6000.000 mm [-0 +100] mm**

Počet kusov - Number of pieces: **526**

Celková dĺžka - Total length: **3156.00 m**

Celková hmotnosť - Total mass: **5208.00 kg**

Materiál - Material:

B/PSL 1 API Spec. 5L/2004/, Grade B ASTM A 106/2006/, Grade B ASTM A 53 / A 53M/2004/

Technické predpisy - Technical requirements/Demand:

ASTM A 53/A 53M-07, ASTM A106/A106M-06a, API Spec.5L/2004, API Spec.5L/2004

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I.C.I. di MERONI MICHELE

Via Don Milzoni, 14
20049 CONIGLIAGO (MI)

Číslo tavby Cast number	Počet kusov Number of pieces	Dĺžka Length [m]	Hmotnosť Mass [kg]	Druh tavenia Steelmaking process
81432	526	3156	5208	E

Druh ocele - Steel grade:

úplne uklúdená ocel - fully killed steel

Chemické zloženie - Chemical composition:

Číslo tavby Cast number		C [%]	Mn [%]	Si [%]	P [%]	S [%]	Cu [%]	Cr [%]	Ni [%]	Mo [%]	V [%]
	Predpis - Requirements	min.	0.29	0.10	0.030	0.030	0.40	0.40	0.40	0.15	0.080
81432		max.	0.28	1.06			0.013	0.012	0.06	0.01	0.003
			0.16	0.57	0.24	0.013	0.012	0.13	0.04	0.01	0.003

Miesto v Podbrezovej
Location ko

Dátum 23.06.2008
Date

Vedúci kontrolného a atestačného oddelenia
Engineering inspection official

Ing. Vojtás Miroslav



ŽELEZIARNE PODBREZOVA, a.s., 976 81 Podbrezová, SLOVAKIA

Telefón/Phone: +421 48 645 40 70, 645 40 71, Fax: +421 48 645 40 72, www.oceloverury.sk, www.steeltube.sk

IČO 31 562 141, IČ DPH/VAT N°: SK2020458704, Bankové spojenie/Bank account: Čitibank (Slovakia) a.s. N° 2001940001/8130

Spoločnosť je zapísaná v Obchodnom registri Okresného súdu Banská Bystrica, oddiel Sa, vložka číslo 69/S



Inšpekčný certifikát
Inspection certificate
EN 10204:2004/3.1

Číslo
Number

27506/1/2008

(4)

List č. - Sheet No.: 2 / 2

Skúška ľahom - Tensile test : 20 °C

C. Nr	Predpis - Requirements:	min.	Medza klzu Yield point - Proof stress	Pevnosť v ľahu Tensile strength	Ťažnosť Elongation
			ReH [MPa]	Rm [MPa]	Lo = 2" [%]
1	81432	241	413	528	30.0 40.6
2	81432	—	407	521	42.4

Skúška vodným tlakom vyhovela.
Hydraulic pressure test without objections.

17.2 MPa

Skúška ohybom vyhovela.
Bend test without objections.

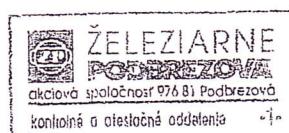
Výrobky splňajú základné požiadavky na materiály pre tlakové zariadenia uvedené v Prílohe I Smernice pre tlakové zariadenia (PED) 97/23 EC.
The products are in compliance with the material basic requirements according to the Pressure Equipment Directive (PED) 97/23 EC, Annex I.

Všetky výrobky vyhovujú vyššie uvedeným normám a požiadavkám v objednávke.
All products meet requirements of above mentioned standards and requirements specified in order.

Vizuálna kontrola a rozmery vyhoveli (100 %).
Visual inspection and dimensional check without objections (100 %).

Poznámky - Remarks

CHEMICAL PROPERTIES CONFORM TO GRADE B ACCORDING TO ASTM A795.



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I.C.I. di MECONI MICHELE
Via Don Minzoni, 14
20049 CONCOREZZO (MI)

DISPERSI di Vimercati Luigi e C. snc
via Milano, 44 - VIMERGATE
tel. 039-663403 - Fax 039-6080657
Partita Iva 01676790966

Miesto v Podbrezovej
Location ko

Dátum 23.06.2008
Date

Vedúci kontrolného a atestačného oddelenia
Engineering inspection official

Ing. Vojtěška Miroslav

10

SIDERURGICA ASTICO S.p.A. 36030 FARA VICENTINO (VI) - Via Astico, 44 Telefono 039-045-869800 r.a. - Telefax 039-045-869599		Marchio del produttore - Brand of the manufacturer 																																																																									
N.PAG.	Aff-1	Committente/Purchaser:	I.C.I. VIA DON MINZONI 14 20049 CONCOREZZO MI																																																																								
B01	Prodotto / Product	B11 Spessore/Thickness 5,000	B12 Lunghezza-Width 2000,00																																																																								
B03	B10	B14																																																																									
B07	Identificazione colata Cast. n.	Pezzi n. Piezas n.	Massa Kg. Massa Kg.																																																																								
62857169	C623283	1	29270																																																																								
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Questo certificato è stato rilasciato da un sistema di elaborazione dati in conformità alla EN 10 204, articolo 5, e validato senza firma.
This certificate was generated by a suitable data processing system and is valid without signature according to EN 10 204, section 5.

TRUE COPY
I.C.I. di NEONI MICHELE
Via Don Minzoni, 14
20049 MONCOPETTO (MI)