



Tecnimont S.p.A.

REPSOL POLIMEROS
SA

4274_CONST

ALBA PROJECT-PP AND PEL PLANTS



MOD-ITP-XL_220		RELEASE OF SPOOLS FROM WORKSHOP	Report n° IP-WSR-P-310-000317_RFI4464_MOD-ITP-XL_220
Rev.1			RFI Nr.: Date :
Unit	-		
Plant Area	-		
Isometric Number			
Inspection Package Number	IP-WSR-P-310-000317_RFI4464 - IP Spool Release From Workshop		

Sheet 01/01

The Present Inspection Package contains the following Elements:

7111-IA91F18-1-SP02-00046;1127-PN52020-1-SP04-00819;2121-IA91F63-1-SP12-00482;1127-PN52022-2-SP02-01045;1121-LS50002-4-SP15-00166;2211-PCW71A01-3-SP11-00423;2211-PCW70A01-2-SP09-00399;2211-PCW70A01-2-SP07-00397;2211-PCW70B04-1-SP01-00986;2121-IA91F63-1-SP13-00483;1121-LS50002-1-SP03-00154;2211-PE62A03-1-SP01-00425;2211-PCW71A01-3-SP09-00421;2211-PCW71A01-3-SP08-00420;2121-IA91F62-3-SP06-00468;1127-LS50009-3-SP04-00800;2211-PCW70A01-2-SP06-00395;2121-LO40B02-5-SP15-00510;1121-LS50002-4-SP14-00165;7111-IA91F18-1-SP01-00045;1127-PN52020-1-SP03-00818;1127-PN52022-2-SP04-01046;1127-PN52022-2-SP01-01044;2211-PCW70A01-2-SP08-00398;2211-PCW70B04-1-SP02-00987;2211-PCW71A01-3-SP10-00422;1127-PN52027-2-SP02-00831;1121-LS50002-1-SP04-00155;2211-PCW71A01-3-SP07-00419;2121-IA91F62-3-SP07-00469

Spool No.	Ready for destination to: P: Painting (1) W: Wrapping F: Field	NDE Class	Check List					
			Visual Inspect	Traceability OK (2)	Pending NDE / PMI (Yes/No/NA)	PWHT / HARDNESS (Yes/No/NA)	Inside Cleaning (3) (Yes/No/NA)	Spool Identified (Yes/No/NA)

On behalf of Tecnímont / R
Piping Supervisor
Cristi Sandu
06.09.2024 *C. Sandu*

LEGEND OF CHECK RESULT	<input checked="" type="checkbox"/> Checked & NOT Accepted	<input checked="" type="checkbox"/> Checked & Accepted	N.A.	Not Applicable	Y / N	Punch List Produced
SUBCONTRACTOR	Date [DD-MMM-YYYY]	Name	Signature 			
CONTRACTOR	06-09-2024	Sergio Morales Collantes				
COMPANY						
(Free)						



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NOTES (*) : 4274-XH-PQ-00000001

- 1) Painting cycle to be indicated.
- 2) Refer to: **4274-LZ-PC-00000214** (COMPANY 4001008GEN-PC-214) "Management of Site Metallic Welding Activities" and **4274-LZ-PC-00000215** (COMPANY 4001008GEN-PC-215) "Procedure for Traceability of Piping Material"
- 3) Refer to: **4274-XH-SG-00000003** (COMPANY 45-L-45-000-2-00-80005) "Specification for Piping Fabrication & Erection Amendment to EC-L-51.01 and EC-L-51.02" and **4274-XH-PQ-00000001** (COMPANY 45-L-45-000-2-00-80081) "Inspection and Test Plan for Steel Piping Works"

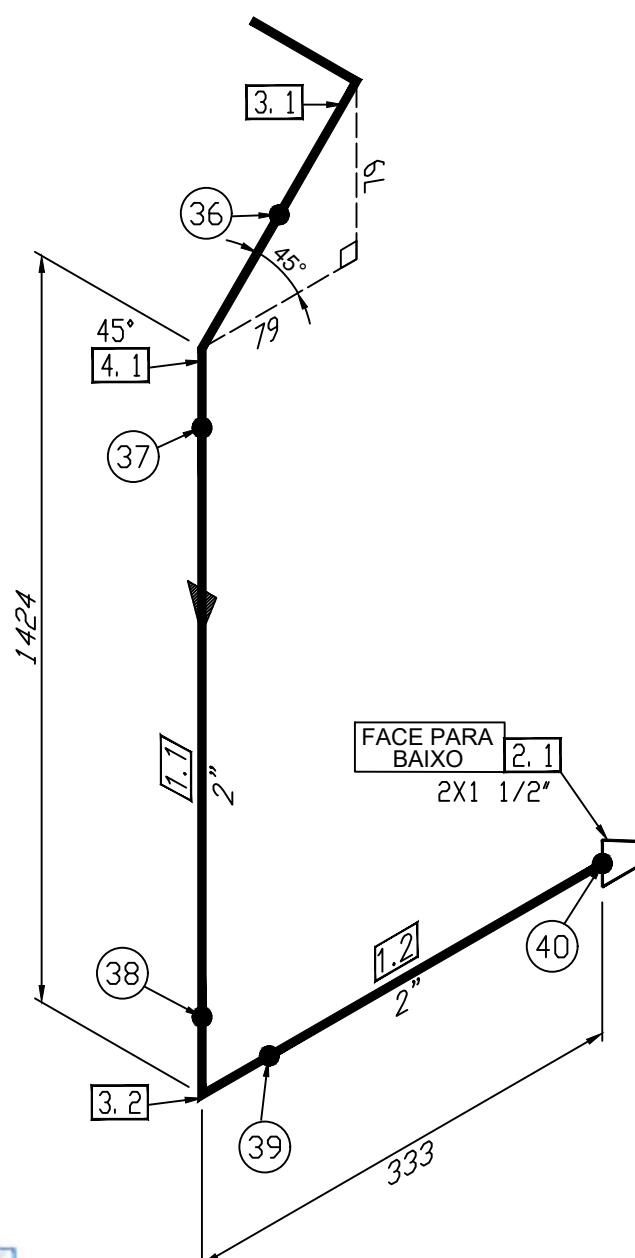
On behalf of Tecnímont / R
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Cristi Sandu
06.09.2024 C. Sandu

LEGEND OF CHECK RESULT	<input checked="" type="checkbox"/> Checked & NOT Accepted	<input checked="" type="checkbox"/> Checked & Accepted	N.A.	Not Applicable	Y/N	Punch List Produced
SUBCONTRACTOR	Date [DD-MMM-YYYY]	Name	Signature			
CONTRACTOR	06-09-2024	Sergio Morales Collantes				
COMPANY						
(Free)						

 Tecnimont	<p style="text-align: center;">Punch List</p> <p style="text-align: center;">PUNCH LIST</p>	<p style="text-align: center;">IDENTIFICATION CODE</p>			
		<table border="1" style="width: 100%; text-align: center;"> <tr> <td>SHEET 1 / 1</td> <td>DOC.CLASS 1</td> <td>ISSUE 01</td> </tr> </table>	SHEET 1 / 1	DOC.CLASS 1	ISSUE 01
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 MECWIDE <small>Engineering Consultancy</small>	<p>ISO ID: 2121-LO40B02-5</p>				

	DATE (dd-Mmm-YYYY)	NAME	SIGNATURE
SUBCONTRACTOR			
CONTRACTOR			
COMPANY			
(Free)			

 REPSOL LINES 1 1/2" AND SMALLER SHALL BE SUPPORTED IN FIELD IF NOT OTHERWISE INDICATED FOR THE COMPONENT MARKED AS FIELD WELDED ONE WELDED FOR ADJUSTMENT OF IN-LINE COMPONENT WHERE MARKED FIELD WELD SYMBOL FOR ADJUSTMENT OF IN-LINE COMPONENT WHERE MARKED	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="4"></td> <td colspan="4">LINE DATA</td> <td colspan="2"></td> </tr> <tr> <td colspan="4"></td> <td colspan="2">LUID CODE: LO</td> <td colspan="2">LINE NO. 2"-LO-40B02- XB-55</td> <td colspan="2"></td> </tr> <tr> <td colspan="2">00</td> <td colspan="2">25-09-2023</td> <td colspan="2">ISSUED OR CONSTRUCTION</td> <td>TG</td> <td>M</td> <td>TM</td> <td colspan="2"></td> </tr> <tr> <td colspan="2">REV</td> <td colspan="2">DATE</td> <td colspan="2">REVISION DESCRIPTION</td> <td>DRA N UP</td> <td>CHKD UP</td> <td>APP D</td> <td colspan="2">XB-55</td> <td>N / O</td> <td>M</td> <td>N</td> <td>NR</td> <td colspan="2">P&ID No. 19-A-19-000-1-01-00001 sheet 29B</td> </tr> </table>														LINE DATA										LUID CODE: LO		LINE NO. 2"-LO-40B02- XB-55				00		25-09-2023		ISSUED OR CONSTRUCTION		TG	M	TM			REV		DATE		REVISION DESCRIPTION		DRA N UP	CHKD UP	APP D	XB-55		N / O	M	N	NR	P&ID No. 19-A-19-000-1-01-00001 sheet 29B																																									
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ISOMETRIC NO. 4274-SP-XH-DL-2121-LO40B02-5-IS00 SPOILING REV NO. 00																																																																																																		
Notes: 1 DENOTES PARTS LIST NO PIPE A = RESTING SUPPORT G = GUIDE F = AXIAL RESTRAINT B = GUIDE + STOP M = SPRING SUPPORT WHERE A WITHOUT NUMBERING IS INDICATED THIS MEANS THAT THERE IS A REST DIRECTLY ON STEEL STRUCTURE																																																																																																		

  <p>Sergio Morales</p> <p>Date: 02-09-24</p> <p></p> <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 10px;"> <tr> <th>Rev.</th> <th>Date</th> <th>DRW</th> <th>Check 1</th> <th>Check 2</th> <th>Marking Color:</th> <th>GREEN</th> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td>Weld Class:</td> <td>QXB-55-M</td> </tr> <tr> <td>00</td> <td>04/03/2024</td> <td>AOM</td> <td>LRG</td> <td>PCO</td> <td>Paint System:</td> <td>NA</td> </tr> </table> <p>On behalf of Tecnimont / R Piping Supervisor Cristi Sandu <i>C. Sandu</i> 02.09.2024</p>	Rev.	Date	DRW	Check 1	Check 2	Marking Color:	GREEN						Weld Class:	QXB-55-M	00	04/03/2024	AOM	LRG	PCO	Paint System:	NA	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="6">BILL OF MATERIAL</th> </tr> <tr> <th colspan="6">PIPE</th> </tr> <tr> <th>ITEM</th> <th>LONGUEUR</th> <th>DIAMÉTRE</th> <th>SCH/mm</th> <th>DESCRIPTION / MATERIEL</th> <th>ITEM CODE</th> </tr> </thead> <tbody> <tr> <td>1.1</td> <td>1,309</td> <td>2"</td> <td>S-10s</td> <td>PIPE - A312-TP304/304L DUAL GR SMLS, BExBE</td> <td>I3364302</td> </tr> <tr> <td>1.2</td> <td>0,253</td> <td>2"</td> <td>S-10s</td> <td>PIPE - A312-TP304/304L DUAL GR SMLS, BExBE</td> <td>I3364302</td> </tr> </tbody> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="6">WELD FITTINGS</th> </tr> <tr> <th>ITEM</th> <th>QT</th> <th>DIAMÉTRE</th> <th>SCH/PRESS.</th> <th>DESCRIPTION / MATERIEL</th> <th>ITEM CODE</th> </tr> </thead> <tbody> <tr> <td>2.1</td> <td>1</td> <td>2" x 1 1/2"</td> <td>S-10s x S-40s</td> <td>ECCENTRIC REDUCER ASME B16.9 A403-WP304/304L DG BE SMLS</td> <td>I2373875</td> </tr> <tr> <td>3.1</td> <td>1</td> <td>2"</td> <td>S-10s</td> <td>90 LR ELBOW ASME B16.9 A403-WP304/304L DG BE SMLS</td> <td>I2259133</td> </tr> <tr> <td>3.2</td> <td>1</td> <td>2"</td> <td>S-10s</td> <td>90 LR ELBOW ASME B16.9 A403-WP304/304L DG BE SMLS</td> <td>I2259133</td> </tr> <tr> <td>4.1</td> <td>1</td> <td>2"</td> <td>S-10s</td> <td>45 LR ELBOW ASME B16.9 A403-WP304/304L DG BE SMLS</td> <td>I2259145</td> </tr> </tbody> </table> <div style="text-align: center; margin-top: 10px;"> <p>P2308S 00510</p>  <p>2121-LO40B02-5-SP15-00510</p> <p>boccard Alliance for success Boccard Portugal, Lda.</p> </div> <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 10px;"> <thead> <tr> <th>Ref. Drawing</th> <th>Job #</th> <th>Spool #</th> <th>Project</th> </tr> </thead> <tbody> <tr> <td>2121-LO40B02-5</td> <td>P2308S</td> <td>00510</td> <td>REPSOL PROJETO ALBA NERVION</td> </tr> </tbody> </table>	BILL OF MATERIAL						PIPE						ITEM	LONGUEUR	DIAMÉTRE	SCH/mm	DESCRIPTION / MATERIEL	ITEM CODE	1.1	1,309	2"	S-10s	PIPE - A312-TP304/304L DUAL GR SMLS, BExBE	I3364302	1.2	0,253	2"	S-10s	PIPE - A312-TP304/304L DUAL GR SMLS, BExBE	I3364302	WELD FITTINGS						ITEM	QT	DIAMÉTRE	SCH/PRESS.	DESCRIPTION / MATERIEL	ITEM CODE	2.1	1	2" x 1 1/2"	S-10s x S-40s	ECCENTRIC REDUCER ASME B16.9 A403-WP304/304L DG BE SMLS	I2373875	3.1	1	2"	S-10s	90 LR ELBOW ASME B16.9 A403-WP304/304L DG BE SMLS	I2259133	3.2	1	2"	S-10s	90 LR ELBOW ASME B16.9 A403-WP304/304L DG BE SMLS	I2259133	4.1	1	2"	S-10s	45 LR ELBOW ASME B16.9 A403-WP304/304L DG BE SMLS	I2259145	Ref. Drawing	Job #	Spool #	Project	2121-LO40B02-5	P2308S	00510	REPSOL PROJETO ALBA NERVION
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2121-LO40B02-5	P2308S	00510	REPSOL PROJETO ALBA NERVION																																																																																													

Spool Material List

Contract : P2308

Client NERVION

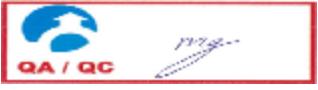
Job : P2308S

Project ALBA

Job	Spool	Piece Mark	Drawing	Rev			
Item No Tag No ID No	Qty	Size1 Sch1	Size2 Sch2	Description	Heat No MTR No Folder No	Unit Weight Kgs	Weight Kgs
P2308S 00510	2121-LO40B02-5-SP15-00510			2121-LO40B02-5			00
1.1	1,309	2.0000 S10S	0.0000 NA	PIPE, SEAMLESS, A312-TP304L	S-23594 0357	3,93	5,14
40391							
1.2	,253	2.0000 S10S	0.0000 NA	PIPE, SEAMLESS, A312-TP304L	S-23594 0357	3,93	0,99
40391							
4.1	1	2.0000 S10S	0.0000 NA	45 ELL, SEAMLESS, A403-WP304L	2K113-E002 0408	0,24	0,24
42790							
3.2	1	2.0000 S10S	0.0000 NA	90 LR ELL, SEAMLESS, A403-WP304L	M220696 0410	0,49	0,49
42965							
3.1	1	2.0000 S10S	0.0000 NA	90 LR ELL, SEAMLESS, A403-WP304L	M220696 0410	0,49	0,49
42965							
2.1	1	2.0000 S10S	1.5000 S40S	ECCENTRIC RED, SEAMLESS, A403-WP304L	2K113-E002 0421	0,41	0,41
83718							

On behalf of Tecnimont / R
 Piping Supervisor
 Cristi Sandu
 02.09.2024 

Number of Items : **6** Total Weight : **7,77**

Signature	QA 	Client Sergio Morales Date: 02-09-24
	Date 2024-08-26 16:03:47	

CTA Group	Kg 1138	Mt 305,57	Pz No.: 49
This document is reproduced by a computerized system and is conform to the original	Heat No.: S-23594	Cta's job: OC0000319	Date: 29/02/2024
Customer : TECNIMONT SPA AFC	P.O. No.: PO:		Item: I3364302

12

7500118753 N.PRO: 4274 - PP+PE SINES (PORTUGAL) EPC

**SURAJ** LIMITED(AN ISO 9001 : 2015 COMPANY)
(AN ISO 14001 : 2015 COMPANY)

(AN ISO 45001 : 2018 COMPANY)

(AN PED 2014/68/EU APPROVED COMPANY)

WORKS :Survey No. 779/A, Thol, Kadi - Sanand Highway,
Tal.-Kadi, Dist. Mehsana, Gujarat (India)
Tel. : (02764) 274216 / 27417 Fax : (02764) 274419
Email : quality@surajgroup.com
Visit us at www.surajgroup.com**F / QA / 24****REV. NO. 10**

REGD. OFFICE :
'Suraj House',
Opp. Usmanpura Garden, Ashram Road,
Ahmedabad - 380 014, Gujarat (INDIA)
Tel. : 0091-79-2754 0720 / 2754 0721
Fax : 0091-79-2754 0722
Email : suraj@surajgroup.com

INSPECTION CERTIFICATE**In Accordance with EN 10204/3.1**

Customer: Commerciale Tubi Acciaio S.P.A.	T.C No : 680	Date: 26.03.2022
Product : Austenitic S.S Seamless Cold Finish,Solution Annealed,Pickled & Passivated Pipes.	P.O.No : OS-0000175	Date: 14.10.2021
	W.O.No : 2122/OEP400035	Date: 16.10.2021

Sr. No	Specification	Grade	Heat No.	Dimensions		Quantity			Hydro Test Pressure (Psi)
				NPS	SCH	Length Mtr	Pcs	Total Meter	
27	ASTM A-312 Ed.2019 SA-312 of ASME Sec.II Part "A" Ed.2019 ASME B36.19, EN 10216-5 TC1 NACE MR 0175/ISO 15156, NACE MR 0103	TP 304/304L 1.4301/ 1.4307	S-23594	2	10S	RL	171	1075.220	1400

Chemical Analysis %

Heat No.	Required	C	Mn	P	S	Si	Cr	Ni	Mo	N	Ti
	Min	--	--	--	--	--	18.00	8.00	--	--	--
	Max	0.030	2.00	0.040	0.015	1.00	19.50	10.00	--	0.100	--
S-23594	Heat Analysis	0.025	1.72	0.038	0.008	0.41	18.20	8.08	--	0.079	--

Mechanical Test

Heat No.	Required			Gauge Width	Flattening Test	Hardness Test	Impact Test		IGC Test					
	Tensile strength Mpa	Yield strength					Max-90 HRB	100 Joule Min.(AVG)	ASTM A-262 Practice"E" & ISO 3651-2 Method "A"					
		Rp0.2% Mpa	Rp1 % Mpa						N/A	Satisfactory				
MAX	690	--	--	--										
MIN	515	205	230	40										
S-23594	624.31	316.22	322.57	55.21	25.40	Satisfactory	76-78							
	623.05	315.91	320.42	54.89			73-75							

Heat Treatment : Solution annealing conducted at 1045-1060°C temperature and rapid water quenching after final cold process.

Marking on pipes: **SURAJ LTD SPECIFICATION GRADE SIZE**CFD EN 10216-5 TC1 **EN GRADE SL NO. _____ HEAT NO. _____ P O NO. _____****Remarks:**

- * 100% Hydro test done at required pressure for 10 second holding time found satisfactory without any leakage.
- * 100% Visual, Dimensions(OD/THK/LENGTH) & Product Marking checked-satisfy the requirement of specification.
- * 100% Positive Material Identification (PMI) done by SL & conforming to grade as per specification.
- * Intergranular Corrosion Test (IGC) Conducted as per ASTM A262 Pr"E" & ISO 3651-2 method-A-No crack observed on bend portion at 20X.
- * Pickling and Passivation Conducted as per ASTM A-380.
- * "Approved acc.to AD 2000-MERKBLATT W0 and certified acc.to PED (2014/68/EU) by certification body for pressure equipment of TUV NORD SYSTEMS (NOTIFIED BODY,REG NO.;0045)"
- * Tensile test piece taken from the same lot as certified and tested in longitudinal direction.
- * Melting process:EIF+AOD & Material is free of mercury & radioactive contamination.

Prepared by

COMMERCIALE TUBI ACCIAIO S.P.A.**QUALITY CONTROL DEPARTMENT**

For, Suraj Limited.
C.I.Nayak
Dept,Head Quality

Page no. 01 of 12

We hereby certify that the material described herein are in accordance with the specification and results comply with the requirements of the purchase order.

APPLUS OBO TCM
28 03 24



Zhejiang Yuli Pipeline Industry Co Ltd

Mill Test Certificate

BAJA INDUSTRIAL ZONE SHACHEN TOWN, LONGWAN DISTRICT, WENZHOU, ZHEJIANG, CHINA

Certificate: EN10204/3.1

Certificate-No: MC-TYF-S-20080627003

Page 3 of 200

L/C NO.:32390CI003798/08

Customer: [REDACTED]	Marking:
Order No.: YL006	• Manufacture's Mark
Description: Seamless stainless steel BW fittings	• Dimension & Schedule
Specification: ANSI/ASTM B16.9, B16.25	• Material S(Seamless)orW(Welded)
Material: ASTM A403/ASME SA403-WPS-3041/304L(2005)	• Heat Number & Standard
Workmanship: Cold forming	
Heat Treatment: Solution annealing and quenched	

Extend of material delivery:

Item No.	Description	Dimension	Quantity	Heat No.	Base Cert.No.	Remarks
1	ELB 45L/R	2" SCH10S	70	2K113-E002	200805087276014	
2						
3						
4						
5						

Inspection Results (The requirements are fulfilled as listed in Annex):

A. Chemical Analysis:

Heat No.	C%	Mn%	Si%	S%	P%	Cr%	Ni%	Mo%	Cu%	Ti%
	0.020	1.26	0.45	0.003	0.023	18.51	8.21			
1	2K113-E002									
2										
3										
4										
5										

B. Mechanical Properties & Tensile Inspection :

Heat No.	Yield Strength		Tensile Strength	Elongation	Hardness	Charpy Impact			
	0.2%	1%							
1	280		620	57	76				
2									
3									
4									
5									

C. Inspection and Related Data Verify:

Dimensional check	OK	Hydrostatic pressure test	/
Surface quality inspection	OK	Radiography Examination	/
Pencuntion examination	OK	IC to ASTM A262 "E"	OK
PMI	OK	HT to NACE MR-0175	OK

D. Remarks:

Work inspector:	
Date: 2008-04-27	

Customer:

TECNIMONT S.p.A.

Order: 7500118979 - 26.01.24 - Item n.: 67 - Project: 4274 - PP+PE Sines (Portugal) EPC - Our ref.: OCVEIT202400000474

Description:

CURVE 45° LR 2" SCH.10/S SEAMLESS

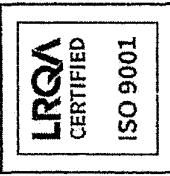
I2259145



Heat num. or Pcs. marking: 2K113-E002 - Qty:22,00

Protocol: CTCERC202400003104 * CERTIFIED TRUE COPY

* Issued 03-04-2024



Approve No:1509001-00400
RCO Cert No:0343/P/2014/UW/101007/3

INSPECTION CERTIFICATE



RACCORDIUBIS P.A.

Order No.: 22TEC003
(注文番号)

P.O. No. : 000000150 S

Chemical Composition of Pipe (Raw Material) %

* Raw Pipe Heat No.	(鉄素質試験) (ASTM)						(機械的性能) (JIS Z 2201)								
	C x 100	Si x 100	Mn x 100	P x 1000	S x 1000	Ni x 100	Cr x 100	Mo x 100	Type of Specimen (試験片)	YS Mpa (屈力)	TS Mpa (引張強さ)	EL% (δ_{UT}) (GL-50mm)	Standard (規格値)	Flattening Test ($\sim \sqrt{A}$ 平試験)	IFT Mpa (水圧試験)
1 L220330	2.3	35.8	138	38	1	804	1817			230	540	56	GOOD	GOOD	79
Specification	MAX 3.0	MAX 100	MAX 200	MAX 45	MAX 30	MAX 1100	MAX 2000						MIN 205	MIN 515	MIN 28

RÉGLEMENTATION DE LA NAGE EN EAU DOUCE / ISO 16156-2:2015 MRB0103-2015

* Partnership acc to ACC MR01/3 / ISU 13138-3-12013; MR01032013

INTERGRANULAR CORROSION TEST (ASTM A262/E) - OK. PMI CHECK GOOD. ISO 9001 / EN 10204-3.1 PED 2014/68/EU ANNEX I SECTION 4.3

HEAT TREATMENT 1050 DEGREE CELSIUS SO ENCHED IN WATER WITHIN 1 MINUTES TO

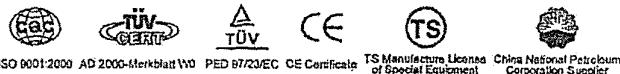
MANITA WAS A MEMBER OF THE STYLERS, A GROUP THAT WAS INVOLVED IN ACCORDANCE WITH THE GANG.

WE HEREBY CERTIFY THAT THE ABOVE PRODUCTS MEET THE REQUIREMENTS OF THE STANDARDS AND OF THE CUSTOMER ORDER.
MATERIAL WAS MANUFACTURED, ASSEMBLED, TESTED AND INSPECTED IN ACCORDANCE WITH INDICATED SPECIFICATIONS AND WAS FOUND TO MEET THE REQUIREMENTS. NO WELD REPAIR WAS PERFORMED AND ALL ITEMS SUPPLIED ARE FREE OF WELD REPAIR.
MATERIAL IS FREE OF MERCURY CONTAMINATION AND RADIOACTIVITY.

卷之三

Head of QAV UC Dept

Head of QA/QC Dept
质量监督科科长



Zhejiang Yuli Pipeline Industry Co Ltd

Mill Test Certificate

BAJA INDUSTRIAL ZONE SHACHEN TOWN, LONGWAN DISTRICT, WENZHOU, ZHEJIANG, CHINA

Certificate: EN10204/3.1

Certificate-NO: MC-TYF-6-20080627059

Page 59 of 200

L/C NO.:32390CI003798/08

Customer:		Marking:
Order No.:	YL 006	• Manufacturer's Mark
Description:	Seamless stainless steel BW fittings	• Dimension & Schedule
Specification:	ANSI/ASTM B16.9, B16.25	• Material S(Seamless)orW(Welded)
Material:	ASTM A403/ASME SA403-WPS-304/304L(2005)	• Heat Number & Standard
Workmanship	Cold forming	
Heat Treatment:	Solution annealing and quenched	

Extend of material delivery:

Item No.	Description	Dimension	Quantity	Heat No.	Base Cert.No.	Remarks
1	RED ECC	2" *11/2" SCH40S	30	2K113-E002	200805087276014	
2						
3						
4						
5						

Inspection Results (The requirements are fulfilled as listed in Annex):

A. Chemical Analysis:

	Heat No.	C%	Mn%	Si%	S%	P%	Cr%	Ni%	Mo%	Cu%	Ti%
1	2K113-E002	0.020	1.26	0.45	0.003	0.023	18.51	8.21			
2											
3											
4											
5											

B. Mechanical Properties & Tensile Inspection :

Heat No.	Yield Strength		Tensile Strength	Elongation	Hardness	Charpy Impact		
	0.2%	1%						
1 2K113-E002	280		620	57	76			
2								
3								
4								
5								

C. Inspection and Related Data Verify:

Dimensional check	OK	Hydrostatic pressure test	/
Surface quality inspection	OK	Radiography Examination	/
Penetration examination	OK	IC to ASTM A262 "E"	OK
PMI	OK	HT to NACE MR-0175	OK

D. Remarks:

--

Work inspector: 梅森
ED.S.



Customer: TECNIMONT S.p.A. Order: 7500118979 - 26.01.24 - Item n.: 87 - Project: 4274 - PP+PE Sines (Portugal) EPC - Our ref.: OCVEIT202400000474

Description: RID. ECC. 2"x1.1/2" SCH.10S/40S SEAMLESS T.B. FROM SCH.40S
I2373875



Heat num. or Pcs. marking: 2K113-E002 - Qty:2,00

Protocol: CTCERC202400003104 * CERTIFIED TRUE COPY

* Issued 03-04-2024



Contract : P2300

Drawing : 2121-LO40B02-5

Welding and QC Report Per Spool

Job : P2300S

Material : Stainless Steel 304, 316, 317

Client : NERVION

Revision : 00

Spool : 00510

Spec : QXB-55-M

Project : ALBA

Piece Mark : 2121-LO40B02-5-SP15-00510

Weld data

Welding

Control

Weld No.	Type	Dia	Sch	Weld Proc.	1st Pass	1st MTR	Final Pass	Final MTR	Dim	Date DIM	Visual	Date Visual	PT	Date PT	MT	Date MT	PMI	Date PMI	Ferite	Date Ferrite	PWHT	Date PWHT	BHN	Date BHN	Ultra	Date UT	Xray	Date Xray
0036	BW	2	S10S	MW.26_BW	AY	15/07/2024	4712055	AY	15/07/2024	4712055			000792	12/08/2024			000795	22/08/2024										
0037	BW	2	S10S	MW.26_BW	AY	15/07/2024	4712055	AY	15/07/2024	4712055			000792	12/08/2024			000795	22/08/2024										
0038	BW	2	S10S	MW.26_BW	AY	15/07/2024	4712055	AY	15/07/2024	4712055			000792	12/08/2024			000795	22/08/2024										
0039	BW	2	S10S	MW.26_BW	AY	15/07/2024	4712055	AY	15/07/2024	4712055			000792	12/08/2024			000795	22/08/2024										
0040	BW	2	S10S	MW.26_BW	AY	15/07/2024	4712055	AY	15/07/2024	4712055			000792	12/08/2024			000795	22/08/2024							000257	17/08/2024		

On behalf of Tecnimont / R
Piping Supervisor
Cristi Sandu
05.09.2024 C. Sandu

Notes:

Boccard Portugal QC	Client
 	Sergio Morales Date: 02-09-24
26/08/2024 16:03:47	



Shop QC Inspection Report

P2308-000816

Client : NERVION
Contract : P2308 / Project : ALBA
Material: Stainless Steel 304, 316, 317

Job number: P2308S
Spool N°: 00510
Piece Mark: 2121-LO40B02-5-SP15-00510

Procedure / Instruction reference: 20.2 IT 011 MF 324 - Rev: A

Control Date: 12/08/2024

Remarks: The results refer to the controlled items

Actions / Tasks List	Required		Done/ Identified
	Yes	No	
Welder / weld list labels printed and pasted on the spool sheet	X	<input type="checkbox"/>	X
Spool Barcode label printed	X	<input type="checkbox"/>	X
Spool is identified with the metal tag	X	<input type="checkbox"/>	X
Spool stencil required (hard stamp low stress)	<input type="checkbox"/>	X	<input type="checkbox"/>
Joint preparation & cleanliness / spool dimensions checked	X	<input type="checkbox"/>	X
Level, plumb, Two holes, flanges and internal alignment, Squareness	X	<input type="checkbox"/>	X
Material checked (type of material, rate, heat numbers, filler material, etc.)	X	<input type="checkbox"/>	X
Welders list match with actual welder stencil / Id. on pipe	X	<input type="checkbox"/>	X
PWHT- Spool identified as per Procedure / Instruction for PWHT	<input type="checkbox"/>	X	<input type="checkbox"/>
HT (Hardness Test)- Welds identified as per Procedure / Instruction	<input type="checkbox"/>	X	<input type="checkbox"/>
MT - Welds identified as per Procedure / Instruction	<input type="checkbox"/>	X	<input type="checkbox"/>
PT - Welds identified as per Procedure / Instruction	<input type="checkbox"/>	X	<input type="checkbox"/>
PMI - Welds identified as per Procedure / Instruction	X	<input type="checkbox"/>	X
FE (Ferrite test) - Welds identified as per Procedure / Instruction	<input type="checkbox"/>	X	<input type="checkbox"/>
RT - Welds identified as per Procedure / Instruction	X	<input type="checkbox"/>	X
UT - Welds identified as per Procedure / Instruction	<input type="checkbox"/>	X	<input type="checkbox"/>
Spool identified (by marker) as per Procedure / Instruction (Job number, sheet number and Paint type if required)	X	<input type="checkbox"/>	X
Hydro - Spool identified as per Procedure / Instruction	<input type="checkbox"/>	X	<input type="checkbox"/>
Cleanliness - Cleaned inside free of slag, scale, sand, weld spatter, cutting chips, etc. and blow out by compressed air	X	<input type="checkbox"/>	X

Comments:

Performed by: MATOS, MARCO (N2 VT/PT) Date: 12/08/2024 Signature 	QA/QC Inspection: GIL, MIGUEL Date: 26/08/2024 16:03:47 Signature 	Customer Inspection: Sergio Morales Date: 02-09-24 
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On behalf of Tecnimont / R
Piping Supervisor
Cristi Sandu
05.09.2024 

Visual Examination Report (Welds)

P2308-000792

Contract : P2308

Job number: P2308S

Material: Stainless Steel 304, 316, 317

Client : NERVION

Spool Nº: 00510

Procedure & Instructions: 4274-LZ-VF-W31010370QAC04 - Rev: 1

Project : ALBA

Piece Mark: 2121-LO40B02-5-SP15-00510

Testing Date: 12/08/2024

Remarks: The results refer to the controlled items

Unacceptable indications for welding

ACCEPTANCE CRITERIA : ASME B31.3	Weld reinforcement greater than specified in project procedure
The illumination of the surface must be at least 500 lux. However, a value of 1000lux is recommended	Any linear indications greater than specified in project procedure, surface porosity with rounded indications having a dimension greater than specified project procedure
Indications of lack of fusion open to the surface / Cracks located on external surfaces	Surface finish that could interfere with other testing required
Incomplete penetration of welds / Indications of undercut on surfaces which are greater than specified in project procedure	Misalignment greater than specified in applicable code or poor fit up of weld joints

Weld No.	Weld Desc.	Identification		Welder	Temp. (°F/°C)	Accepted	Rejected	Defect	Technique Used	Comments
		AY	26							
0036	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	AY	26	X					Direct	
0037	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	AY	26	X					Direct	
0038	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	AY	26	X					Direct	
0039	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	AY	26	X					Direct	
0040	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	AY	26	X					Direct	

Sketch / Photo:

Defects										
Clustered Porosity	CP	Porosity	P	Cap	C	Lack of Cleanup	LC	Hollow in Cap	W	
Unibmly Porosity	UP	Slag	S	Undercut	UC	Crack	CR	Surface	SU	

Test Performed by: MATOS, MARCO (N2 VT/PT)

QA/QC Inspection: GIL, MIGUEL

Customer Inspection:

Date: 12/08/2024

Date: 26/08/2024 16:03:47

Sergio Morales

Signature



Signature



Date: 02-09-24



On behalf of Tecnimont / R
Piping Supervisor
Cristi Sandu
05.09.2024 C. Sandu



Positive Material Identification Report (PMI)

P2308-000795

Client : NERVION

Contract : P2308 / Project : ALBA

Remarks: The results refer to the controlled items

Job number: P2308S

Spool N°: 00510

Piece Mark: 2121-LO40B02-5-SP15-00510

Material: Stainless Steel 304, 316, 317

Procedure / Instruction reference: 4274-LZ-VF-FW31010370QAC11 - Rev: 1

PMI Equipment : Niton XL3t800 Serial N° 32735 (FP01)

Equipment Deviation : + - 5%

Testing Date: 22/08/2024

Weld / Item No	Description	Reading Number	Chemical Elements										Accepted	Rejected	Comments
			%Ti	%Mo	%Cu	%Ni	%Fe	%Mn	%Cr	%Nb	%Al	%V			
0036	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	79	0	0	0	9	69	1	19	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
0037	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	78	0	0	0	8	69	1	19	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
0038	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	77	0	0	0	8	69	1	19	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
0039	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	76	0	0	0	8	69	1	18	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
0040	2.0000 S10S BW-Buttweld Straight (MW.26_BW)	75	0	0	0	8	69	1	19	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
1.1	2.0000 S10S PIPE, SEAMLESS, A312-TP304L (S-23594)	71	0	0	0	7	71	1	18	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
1.2	2.0000 S10S PIPE, SEAMLESS, A312-TP304L (S-23594)	73	0	0	0	8	71	1	17	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
2.1	2.0000 S10S 1.5000 S40S ECCENTRIC RED, SEAMLESS, A403-WP304L (2K113-E002)	74	0	0	0	8	70	1	18	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
3.1	2.0000 S10S 90 LR ELL, SEAMLESS, A403-WP304L (M220696)	69	0	0	0	7	71	1	17	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
3.2	2.0000 S10S 90 LR ELL, SEAMLESS, A403-WP304L (M220696)	72	0	0	0	8	71	1	18	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
4.1	2.0000 S10S 45 ELL, SEAMLESS, A403-WP304L (2K113-E002)	70	0	0	0	8	71	1	18	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

On behalf of Tecnimont / R
 Piping Supervisor
 Cristi Sandu
 05.09.2024 C. Sandu

Test Performed by: GONCALVES(QA), J. (N2 PT/RT) QA/QC Inspection: GIL, MIGUEL

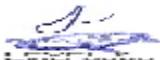
Customer Inspection:

Sergio Morales

Date: 22/08/2024

Date:

Signature



Date: 26/08/2024 16:03:47

Signature



Signature

Date: 02-09-24



Boccard Portugal, Lda
Zona Industrial de Montalvo, Lote 3
Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	79
Mode	ALLOY
Time	2024-08-22 14:27
Duration	10.01
Sequence	Final
Alloy1	304SS : 0.00
Alloy2	No Match : *2.10
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.041
Sn	< LOD	:	0.049
Pd	< LOD	:	0.037
Ag	< LOD	:	0.152
Al	< LOD	:	80.000
Mo	0.055	±	0.008
Nb	< LOD	:	0.008
Zr	< LOD	:	0.004
Bi	< LOD	:	0.002
Pb	< LOD	:	0.018
Se	< LOD	:	0.007
W	< LOD	:	0.085
Zn	< LOD	:	0.028
Cu	< LOD	:	0.157
Ni	9.096	±	0.300
Co	< LOD	:	0.478
Fe	69.985	±	0.447
Mn	1.560	±	0.201
Cr	19.005	±	0.261
V	< LOD	:	0.117
Ti	< LOD	:	0.142

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Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	78
Mode	ALLOY
Time	2024-08-22 14:27
Duration	10.80
Sequence	Final
Alloy1	304SS : 0.02
Alloy2	No Match : *2.10
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.034
Sn	< LOD	:	0.047
Pd	< LOD	:	0.032
Ag	< LOD	:	0.206
Al	< LOD	:	80.000
Mo	0.060	±	0.008
Nb	0.010	±	0.004
Zr	< LOD	:	0.003
Bi	< LOD	:	0.017
Pb	< LOD	:	0.028
Se	< LOD	:	0.009
W	< LOD	:	0.065
Zn	< LOD	:	0.035
Cu	0.228	±	0.079
Ni	8.823	±	0.283
Co	< LOD	:	0.458
Fe	69.758	±	0.426
Mn	1.604	±	0.193
Cr	19.161	±	0.250
V	< LOD	:	0.123
Ti	< LOD	:	0.146

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Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	77
Mode	ALLOY
Time	2024-08-22 14:27
Duration	7.70
Sequence	Final
Alloy1	304SS : 0.35
Alloy2	No Match : *2.12
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.048
Sn	< LOD	:	0.058
Pd	< LOD	:	0.045
Ag	< LOD	:	0.133
Al	< LOD	:	80.000
Mo	0.034	±	0.008
Nb	< LOD	:	0.009
Zr	< LOD	:	0.004
Bi	< LOD	:	0.007
Pb	< LOD	:	0.034
Se	< LOD	:	0.008
W	< LOD	:	0.122
Zn	< LOD	:	0.036
Cu	< LOD	:	0.174
Ni	8.957	±	0.348
Co	< LOD	:	0.569
Fe	69.289	±	0.522
Mn	1.680	±	0.237
Cr	19.218	±	0.306
V	< LOD	:	0.150
Ti	< LOD	:	0.178

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Certificate of PMI Reading

XL3t-32735

Reading No	76
Mode	ALLOY
Time	2024-08-22 14:26
Duration	8.66
Sequence	Final
Alloy1	304SS : 0.69
Alloy2	No Match : 1.68
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.044
Sn	< LOD	:	0.056
Pd	< LOD	:	0.039
Ag	< LOD	:	0.147
Al	< LOD	:	80.000
Mo	0.039	±	0.008
Nb	< LOD	:	0.009
Zr	< LOD	:	0.003
Bi	< LOD	:	0.002
Pb	< LOD	:	0.028
Se	< LOD	:	0.006
W	< LOD	:	0.099
Zn	< LOD	:	0.034
Cu	< LOD	:	0.171
Ni	8.723	±	0.325
Co	< LOD	:	0.536
Fe	69.614	±	0.492
Mn	1.848	±	0.226
Cr	18.912	±	0.288
V	< LOD	:	0.152
Ti	< LOD	:	0.180

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Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	75
Mode	ALLOY
Time	2024-08-22 14:26
Duration	8.94
Sequence	Final
Alloy1	304SS : 0.02
Alloy2	No Match : *2.10
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.042
Sn	< LOD	:	0.049
Pd	< LOD	:	0.039
Ag	< LOD	:	0.108
Al	< LOD	:	80.000
Mo	0.058	±	0.009
Nb	< LOD	:	0.008
Zr	< LOD	:	0.004
Bi	< LOD	:	0.009
Pb	< LOD	:	0.027
Se	< LOD	:	0.006
W	< LOD	:	0.074
Zn	< LOD	:	0.033
Cu	< LOD	:	0.156
Ni	8.799	±	0.309
Co	< LOD	:	0.509
Fe	69.726	±	0.466
Mn	1.649	±	0.212
Cr	19.203	±	0.274
V	< LOD	:	0.131
Ti	< LOD	:	0.136

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Zona Industrial de Montalvo, Lote 3
Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	71
Mode	ALLOY
Time	2024-08-22 14:25
Duration	8.70
Sequence	Final
Alloy1	304SS : 1.23
Alloy2	No Match : 2.17
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.047
Sn	< LOD	:	0.057
Pd	< LOD	:	0.039
Ag	< LOD	:	0.148
Al	< LOD	:	80.000
Mo	0.047	±	0.009
Nb	< LOD	:	0.008
Zr	< LOD	:	0.003
Bi	< LOD	:	0.014
Pb	< LOD	:	0.020
Se	< LOD	:	0.013
W	< LOD	:	0.113
Zn	< LOD	:	0.036
Cu	< LOD	:	0.172
Ni	7.945	±	0.316
Co	< LOD	:	0.539
Fe	71.532	±	0.491
Mn	1.424	±	0.218
Cr	18.132	±	0.282
V	< LOD	:	0.150
Ti	< LOD	:	0.153

Boccard Portugal, Lda
Zona Industrial de Montalvo, Lote 3
Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	73
Mode	ALLOY
Time	2024-08-22 14:26
Duration	8.07
Sequence	Final
Alloy1	304SS : 1.28
Alloy2	No Match : *2.03
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.045
Sn	< LOD	:	0.056
Pd	< LOD	:	0.044
Ag	< LOD	:	0.143
Al	< LOD	:	80.000
Mo	0.037	±	0.009
Nb	< LOD	:	0.006
Zr	< LOD	:	0.003
Bi	< LOD	:	0.013
Pb	< LOD	:	0.022
Se	< LOD	:	0.010
W	< LOD	:	0.104
Zn	< LOD	:	0.031
Cu	0.311	±	0.101
Ni	8.162	±	0.338
Co	< LOD	:	0.569
Fe	71.459	±	0.519
Mn	1.359	±	0.228
Cr	17.947	±	0.297
V	< LOD	:	0.156
Ti	< LOD	:	0.183

Boccard Portugal, Lda
Zona Industrial de Montalvo, Lote 3
Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	74
Mode	ALLOY
Time	2024-08-22 14:26
Duration	8.92
Sequence	Final
Alloy1	304SS : 0.87
Alloy2	No Match : *2.29
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.044
Sn	< LOD	:	0.056
Pd	< LOD	:	0.039
Ag	< LOD	:	0.128
Al	< LOD	:	80.000
Mo	0.176	±	0.015
Nb	< LOD	:	0.008
Zr	< LOD	:	0.004
Bi	< LOD	:	0.019
Pb	< LOD	:	0.029
Se	< LOD	:	0.012
W	< LOD	:	0.084
Zn	< LOD	:	0.048
Cu	0.442	±	0.101
Ni	8.313	±	0.316
Co	< LOD	:	0.526
Fe	70.801	±	0.483
Mn	1.188	±	0.212
Cr	18.566	±	0.281
V	< LOD	:	0.138
Ti	< LOD	:	0.154

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Zona Industrial de Montalvo, Lote 3
Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	69
Mode	ALLOY
Time	2024-08-22 14:25
Duration	10.21
Sequence	Final
Alloy1	301SS : 1.67
Alloy2	304SS : 1.98
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.042
Sn	< LOD	:	0.050
Pd	< LOD	:	0.039
Ag	< LOD	:	0.111
Al	< LOD	:	80.000
Mo	< LOD	:	0.008
Nb	< LOD	:	0.005
Zr	< LOD	:	0.006
Bi	< LOD	:	0.013
Pb	< LOD	:	0.019
Se	< LOD	:	0.007
W	< LOD	:	0.095
Zn	< LOD	:	0.044
Cu	< LOD	:	0.143
Ni	7.944	±	0.297
Co	< LOD	:	0.504
Fe	71.951	±	0.463
Mn	1.423	±	0.203
Cr	17.949	±	0.264
V	< LOD	:	0.130
Ti	< LOD	:	0.171

Boccard Portugal, Lda
Zona Industrial de Montalvo, Lote 3
Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	72
Mode	ALLOY
Time	2024-08-22 14:26
Duration	7.63
Sequence	Final
Alloy1	304SS : 0.75
Alloy2	No Match : 2.50
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.052
Sn	< LOD	:	0.055
Pd	< LOD	:	0.043
Ag	< LOD	:	0.171
Al	< LOD	:	80.000
Mo	< LOD	:	0.009
Nb	< LOD	:	0.007
Zr	< LOD	:	0.005
Bi	< LOD	:	0.015
Pb	< LOD	:	0.011
Se	< LOD	:	0.010
W	< LOD	:	0.091
Zn	< LOD	:	0.043
Cu	< LOD	:	0.169
Ni	8.097	±	0.345
Co	< LOD	:	0.585
Fe	71.505	±	0.533
Mn	1.416	±	0.236
Cr	18.264	±	0.307
V	< LOD	:	0.155
Ti	< LOD	:	0.183

Boccard Portugal, Lda
Zona Industrial de Montalvo, Lote 3
Constância, Portugal 2250-999

Certificate of PMI Reading

XL3t-32735

Reading No	70
Mode	ALLOY
Time	2024-08-22 14:25
Duration	9.54
Sequence	Final
Alloy1	304SS : 0.54
Alloy2	No Match : *2.11
Flags	
SAMPLE	
HEAT	
LOT	
BATCH	
MISC	
NOTE	

	%	±	Error
Sb	< LOD	:	0.040
Sn	0.065	±	0.028
Pd	< LOD	:	0.036
Ag	< LOD	:	0.210
Al	< LOD	:	80.000
Mo	0.118	±	0.012
Nb	< LOD	:	0.005
Zr	< LOD	:	0.005
Bi	< LOD	:	0.013
Pb	< LOD	:	0.017
Se	< LOD	:	0.008
W	< LOD	:	0.093
Zn	< LOD	:	0.051
Cu	0.542	±	0.100
Ni	8.140	±	0.296
Co	< LOD	:	0.495
Fe	71.156	±	0.455
Mn	1.360	±	0.202
Cr	18.197	±	0.262
V	< LOD	:	0.126
Ti	< LOD	:	0.138

Contract : P2308
Client : NERVION
Project : ALBA

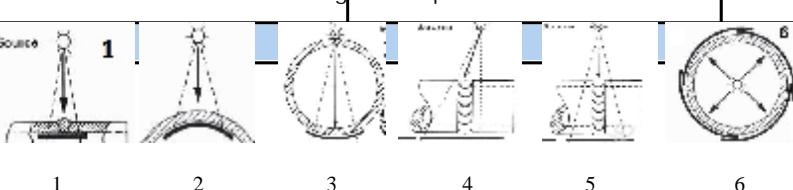
Spool N°: P2308S-00510
Isometric N°: 2121-LO40B02-5
Piece Mark: 2121-LO40B02-5-SP15-00510

Procedure/ Instruction:

Acceptance Criteria:

Testing Date:

Material:

4274-LZ-VD-FW31010370QAC02 - RevA\$ME B.31.3 – Table 341.3.2		17/08/2024		Stainless Steel 304, 316, 317																															
Equipment		Normal Fluid Film		IQI																															
Type: G-RAY		Brand: FUJI		Type: ASTM-1A																															
Source Equip: Ir192		Type: IX50		Position: Film Side																															
Source Dim: 2x1.4		Class: C3		Sensitivity: 4																															
Activity (Ci): 35		Lead Sheets: 0,5		Ø of visible wire/hole 0,0063(0,16)																															
Films/Casette:Single		Testing Technique		Indication Codes (ISO 6520)																															
		<table border="1"> <tr> <td>BB-Back Bevel</td> <td>EP-Excess Penetration (504)</td> <td>SB-Suck Back</td> </tr> <tr> <td>FA-Film Artifact</td> <td>ST-Sugared Tack</td> <td></td> </tr> <tr> <td>BW-Back Weld</td> <td>GR-Grind Repair</td> <td>SU-Surface</td> </tr> <tr> <td>BT-Burn Through (510)</td> <td>HL-Hi-Lo</td> <td>T-Tungsten</td> </tr> <tr> <td>C-Cap</td> <td>LC-Lack of Cleanup</td> <td>UC-Undercut (5011)</td> </tr> <tr> <td>CP-Clustered Porosity (2012)</td> <td>LF-Lack of Fusion (401)</td> <td>UP-Unformity Porosity (2013)</td> </tr> <tr> <td>CL-Cold Lap</td> <td>LP-Lack of Penetration (402)</td> <td>V-Valley in Cap</td> </tr> <tr> <td>CR-Crack</td> <td>P-Porosity (2011)</td> <td>W-Wire</td> </tr> <tr> <td>CC-Crater Crack (104)</td> <td>R-Root</td> <td>WH-Worm Hole (2016)</td> </tr> <tr> <td>DI-Dimensional</td> <td>S-Slag (301)</td> <td>XN-Xray Film Non-Conform</td> </tr> </table>		BB-Back Bevel	EP-Excess Penetration (504)	SB-Suck Back	FA-Film Artifact	ST-Sugared Tack		BW-Back Weld	GR-Grind Repair	SU-Surface	BT-Burn Through (510)	HL-Hi-Lo	T-Tungsten	C-Cap	LC-Lack of Cleanup	UC-Undercut (5011)	CP-Clustered Porosity (2012)	LF-Lack of Fusion (401)	UP-Unformity Porosity (2013)	CL-Cold Lap	LP-Lack of Penetration (402)	V-Valley in Cap	CR-Crack	P-Porosity (2011)	W-Wire	CC-Crater Crack (104)	R-Root	WH-Worm Hole (2016)	DI-Dimensional	S-Slag (301)	XN-Xray Film Non-Conform		
BB-Back Bevel	EP-Excess Penetration (504)	SB-Suck Back																																	
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BT-Burn Through (510)	HL-Hi-Lo	T-Tungsten																																	
C-Cap	LC-Lack of Cleanup	UC-Undercut (5011)																																	
CP-Clustered Porosity (2012)	LF-Lack of Fusion (401)	UP-Unformity Porosity (2013)																																	
CL-Cold Lap	LP-Lack of Penetration (402)	V-Valley in Cap																																	
CR-Crack	P-Porosity (2011)	W-Wire																																	
CC-Crater Crack (104)	R-Root	WH-Worm Hole (2016)																																	
DI-Dimensional	S-Slag (301)	XN-Xray Film Non-Conform																																	
General Remarks		Notations / Symbology																																	
The results refer to the controlled items		- Good / Acceptable + Repair = Good after Repair																																	
		x Acceptable after Repair SFD = Source Film Distance SOD = Source Object Distance																																	

Weld No.	Weld Desc. (WPS)	Welder	Position	SFD	SOD	Weld Reinf	Testing Technique	Exposure Time	Density	IQI	Indication Code	Decision Remarks
0040	2.0000 S10S BW (MW.26_BW)	AY	A	500	460	NA	4	360	3.9	W4		- RX344
0040	2.0000 S10S BW (MW.26_BW)	AY	B	500	460	NA	4	360	3.8	W4		- RX344

Contract : P2308 Spool N°: P2308S-00510
Client : NERVION Isometric N°: 2121-LO40B02-5
Project : ALBA Piece Mark: 2121-LO40B02-5-SP15-00510

Procedure/ Instruction: Acceptance Criteria: Testing Date: Material:

4274-LZ-VD-FW31010370QAC02 - RevA\$ME B.31.3 – Table 341.3.2		17/08/2024	Stainless Steel 304, 316, 317	
Equipment		Normal Fluid Film	IQI	
Type: G-RAY	Brand: FUJI	Type: ASTM-1A	Equipment: GE M ECO	
Source Equip: Ir192	Type: IX50	Position: Film Side	Type: Auto	
Source Dim: 2x1.4	Class: C3	Sensitivity: 4	Temperature: 29	
Activity (Ci): 35	Lead Sheets: 0,5	Ø of visible wire/hole 0,0063(0,16)	Developer: G135	Fixer: G335
Films/Casette:Single		Indication Codes (ISO 6520)		
Testing Technique				
1	2	3	4	5
6				
General Remarks		Notations / Symbology		
The results refer to the controlled items		x Acceptable after Repair SFD = Source Film Distance SOD = Source Object Distance		

Weld No.	Weld Desc. (WPS)	Welder	Position	SFD	SOD	Weld Reinf	Testing Technique	Exposure Time	Density	IQI	Indication	Decision	Remarks Code
	Performed by:	Examined by:			OA/QC Inspection:			Customer Inspection:					
Name:	GONCALVES(QA), J. (N2 PT/RT)	FIGUEIRAS(QA), RUI (N2 PT/RT)			GIL, MIGUEL								
Date:	17/08/2024	17/08/2024			26/08/2024 16:03:47								
Signature:								Sergio Morales Date: 02-09-24					

On behalf of Tecnimont / R
Piping Supervisor
Cristi Sandu
05.09.2024 

Client : NERVION
Contract : P2308 / Project : ALBA
Material: Stainless Steel 304, 316, 317

Job number: P2308S
Spool N°: 00510
Piece Mark: 2121-LO40B02-5-SP15-00510

Procedure/Instruction: 23A008/010 Rev.0

Pick Tape	Clean Spray	Clean Wipes
Brand: Nitty Gritty Pick&Clean	Brand: Nitty Gritty Pick&Clean	Brand: Nitty Gritty Pick&Clean
Batch: N/A	Batch: N/A	Batch: N/A
Opening Date: 24/06/2024	Opening Date: 24/06/2024	Opening Date: 24/06/2024
Expiration Date: 24/10/2024	Expiration Date: 24/10/2024	Expiration Date: 24/10/2024

Weld No.	Pickling and Cleaning			Accepted	Rejected
	Pick tape duration (at least 10/15 min)	Cleaning (with spray) and drying (with blotting paper)	OR		
0036	15 min	OK		<input checked="" type="checkbox"/> X	<input type="checkbox"/>
0037	15 min	OK		<input checked="" type="checkbox"/> X	<input type="checkbox"/>
0038	15 min	OK		<input checked="" type="checkbox"/> X	<input type="checkbox"/>
0039	15 min	OK		<input checked="" type="checkbox"/> X	<input type="checkbox"/>
0040	15 min	OK		<input checked="" type="checkbox"/> X	<input type="checkbox"/>

Performed by: BRAZ, RODRIGO Date: 17/07/2024 Signature 	QA/QC Inspection: GIL, MIGUEL Date: 26/08/2024 16:09:05 Signature 	Customer Inspection: Sergio Morales Date: 02-09-24 
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On behalf of Tecnimont / R
Piping Supervisor
Cristi Sandu
05.09.2024 