

Wieland-Werke AG D-89079 Ulm

Roba Metals Genk
Slingerweg 31
3600 GENK
BELGIEN

Loading area/ No. : **31/20679027**
Lot No. : 85206147*
Please contact : Mrs Pöchacker
Telephone : 0731 944- 311
Fax No. : 0731

Your order No. : PO-0039464-1
Date : 21.09.2021
Your fax No. :

Order confirmation No. : 12260892 006
Inspection lot No. : 890001621902
Our delivery note No. : 83117229 010
Quantity delivered : 900,000 M
Date : 05.10.2022

Inspection certificate 3.1 as per EN 10204 : 2004

Product.		Dimensions:
472 Tubes drawn (str. I.)	K65®	Dim A: 28,570 mm
Material:		Dim B:
Wieland K65 CUFE2P		Dim C: 1,780 mm
Specification:	Revision/Date of issue:	Dim D: 5.000,00 mm
WW R-H-1603 120 bar K65	Rev. 0.1 17.11.2020	Temper: 200 soft
EN 12735-1	:2020-06	R300
R-H-1603		

Remarks:

Lot no. 85206147 85206150 85207674

Chemical composition as per 3.1 EN 10204 : 2004

Test method		Unit	Measured	Specified / Reference (R)		Spec
				Min.	Max.	
The sum of the other elements corresponds to what is specified in the chemical standard.						
CU	Cu Copper	%		97,00		
	85206147		97,50			
	85206150		97,53			
	85207674		97,52			
FE	Fe Iron	%		2,1	2,6	
	85206147		2,3			
	85206150		2,3			
	85207674		2,3			
PB	Pb Lead	%			0,03	
	85206147		< 0,03			



Hersteller-
kenn-
zeichen:



Vorstand:
Dr. Erwin Mayr, Vorsitzender
Gregor Tschernjavski

Vorsitzender des Aufsichtsrates:
Fritz-Jürgen Heckmann
Sitz der Gesellschaft: Ulm
Registergericht Ulm, HRB 1256
St.-Nr. 88004/76900
USt-IdNr.: DE811147730

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	85206150		< 0,03		
	85207674		< 0,03		
P	P Phosphorus	%		0,015	0,15
	85206147		0,017		
	85206150		0,019		
	85207674		0,022		
ZN	Zn Zinc	%		0,05	0,2
	85206147		0,13		
	85206150		0,11		
	85207674		0,12		

Mechanical testing

	Parameter tested	Unit	Measured		Specified / Reference (R)		Spec (No.)
			Min.	Max.	Min.	Max.	
RP0,2	Rp 0.2 % yield strength	MPa			140		
	85206147		142	143			(2)
	85206150		142	142			(1)
	85207674		151	156			(4)
RP1,0	Rp 1.0 % proof strength	MPa			140		
	85206147		178	180			(2)
	85206150		179	179			(1)
	85207674		187	192			(4)
RM	Tensile strength Rm	MPa			300		
	85206147		328	329			(2)
	85206150		335	335			(1)
	85207674		327	330			(4)
A5	Elongation A5	%			30,0		
	85206147		35,0	35,0			(2)
	85206150		34,0	34,0			(1)
	85207674		34,0	36,0			(4)

Further inspections

	Parameter tested	Unit	Measured		Specified / Reference (R)		Spec (No.)
			Min.	Max.	Min.	Max.	
WS	Eddy current test 100%						
	85206147		Result good				(1)
	85206150		Result good				(1)
	85207674		Result good				(1)
IC	Carbon content test	mg/dm ²				0,38	
	85206147		0,28	0,30			(2)
	85206150		0,12	0,12			(1)
	85207674		0,07	0,09			(4)
SICHT	Visual check						



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Further inspections (continued)

Parameter tested	Unit	Measured		Specified / Reference (R)		Spec (No.)
		Min.	Max.	Min.	Max.	
85206147		Result good				(1)
85206150		Result good				(1)
85207674		Result good				(1)

Method of control of dimensions

Parameter tested	Unit	Measured		Specified / Reference (R)		Spec (No.)
		Min.	Max.	Min.	Max.	
DRMAMW Mean outside diameter	mm			28,510	28,630	
85206147		28,580	28,585			(2)
85206150		28,585	28,585			(1)
85207674		28,570	28,585			(4)
DRMAUR Outside diameter incl out-of-roundness	mm			28,460	28,680	
85206147		28,570	28,590			(2)
85206150		28,580	28,590			(1)
85207674		28,560	28,600			(4)
WDIMU Wall thickness incl. eccentricity	mm			1,513	2,047	
85206147		1,640	1,780			(2)
85206150		1,600	1,700			(1)
85207674		1,620	1,710			(4)
LG Length	mm			5000,00	5005,00	
85206147		5003,00	5003,00			(2)
85206150		5003,00	5003,00			(1)
85207674		5002,00	5002,00			(4)

Attestation of conformity

As manufacturer we declare that the products described herein comply with the specifications agreed with the purchaser, with the above-mentioned standards, descriptions, quantity and the data indicated in this certificate.

These products have been manufactured to our certified quality system. Our quality system is subjected to regular inspection by SGS (reg.no. DE21/819945125 and DE21/819945126).

The results of the chemical analysis and of the mechanical-technological and physical tests have been determined by our test laboratory which has been certified and / or accredited.

P.Eisen (Supervisor)

Telephon: +49-731-944-3137 Fax: +49-731-944-4915

e-mail: peter.eisen@wieland.com

Computer-generated inspection certificate



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