

(A01) ERNE Fittings GmbH Hauptstraße 48 6824 Schlins Austria  ernefittings the safe connection	 ernefittings the safe connection	INSPECTION CERTIFICATE (A02) 3.1 EN10204:2004 No.: 2020-002637-PD (A03) Rev.: 1 Date: 2020-01-28 Page: 1 / 4
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(A06)

Customer Erne Fittings USA, Inc. 9725 Kirkton TX 77095 Houston United States
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(A07, A08)

Order	
Erne order no.	211966KB
Erne order pos.	0030
Customer order no.	91/2087
Order date	2019-06-26

(B01, B02, B03, B04)

Requirements of the order cap MSS SP-75-14 + CSA Z245.11-13 material . . . : WPHY 60/WPHY 65/Gr. 448 Cat-II TR-fitting . . : MSS SP-75-2014 : CSA Z245.11-13 TR-addit. fitting : NACE MR0175/ISO15156-2:2015A.2 : NACE MR0103/ISO17945:2015 : 13.1 & 15 : For WPHY65: ASTM A860-18 certificate . . : EN 10204/3.1 rust protection. : Millstandard

(B01)

Item specification	
Manufacturer item no.	171206
Product form	cap
Article designation	CAP-S-WPHY60/65/448CatII-24"-XS
Steel grade	WPHY_60/WPHY_65/Gr_448_Cat-II

(B09, B10, B11)

Product dimensions (nominal)	
Diameter	609.60 mm
Wall thickness	12.70 mm

(B04, B07, B08)

Product	
Code No.	J2W4X
Quantity	8 pcs
Manufacturing process	Hot formed

Marking, Identification

 AUSTRIA Z245.11-17 448 M46C SS A860 WPHY60/WPHY65 QT J2W4X 24" XS 

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Pre material

(C70)

Heat no.	Starting material
22400	Seamless tubes

Heat analysis

(C71)

Heat no.	C	Si	Mn	P	S	Cr	Mo	Ni	Cu	V
22400	0.160 %	0.34 %	1.12 %	0.010 %	0.001 %	0.03 %	0.00 %	0.17 %	0.02 %	0.00 %

Heat no.	Nb	Al	B	Ti	N	CE _{IIW}
22400	0.02 %	0.053 %	0.0001 %	0.00 %	0.003 %	0.37

Product analysis

(C81)

Heat no.	C	Si	Mn	P	S	Cr	Mo	Ni	Cu	V
22400	0.142 %	0.34 %	1.03 %	0.011 %	< 0.001 %	0.02 %	0.00 %	0.15 %	0.02 %	0.00 %

Heat no.	Nb	Al	B	Ti	N	CE _{IIW}	CE _N
22400	0.01 %	0.054 %	0.0003 %	0.00 %	< 0.003 %	0.33	0.32

Formula legend

(C71)

Code	Name	Formula
CE _{IIW}	Carbon Equivalent (IIW)	$C + Mn/6 + (Cr+Mo+V)/5 + (Ni+Cu)/15$
CE _N	Carbon Equivalent (N)	$C + (0.75 + 0.25 \cdot \tanh(20 \cdot (C - 0.12))) \cdot (Si/24 + Mn/6 + Cu/15 + Ni/20 + (Cr+Mo+Nb+V)/5 + 5B)$

Heat treatment

(B04)

Process	Temperature	Cooling
Normalized	920 °C	Cooling in still air

Hardness test

(C30, C31)

Test report no.	Method	Min	Max
12019/2	HB	-	145

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Tensile test

(C01, C02, C03, C10, C11, C12, C13)

Sample no.	Sample orientation	Sample size	Temperature	Yield Strength	Tensile strength	Elongation
				R _{p0.2}		
204_634	Transversal	Round specimen Ø 8.94 mm L: 35.60 mm 4D	+22 °C	79000 PSI	92500 PSI	26 %

Notched bar impact test

(C40, C41, C42, C43, C44)

Sample no.	Sample orientation	Temperature	Dimension of test sample			Work	Lat. width	Shear fracture
			bo	So	Notch shape			
204_634	Longitudinal	-46 °C	10.0 mm	80.0 mm ²	V-Notch	275.0 J 313.0 J 231.0 J Ø 273.0 J	2.47 mm 2.54 mm 2.38 mm	- - -
204_635	Transversal	-46 °C	10.0 mm	80.0 mm ²	V-Notch	285.0 J 302.0 J 307.0 J Ø 298.0 J	- - -	100.0 % 100.0 % 100.0 %

Additional tests

(D02, D51)

Test name	Test report no.	Test standard	Conditions	Rate	Result
Visual inspection and dimensional check					Without objection

Statement of Compliance

(Z01)

The products were manufactured, sampled, tested and inspected in accordance with the specifications and were found to meet the requirements.

Inspection representative

(A05, Z02, Z03)

Date	2020-01-28
Validated by	Inspection Representative
Name / Signature / Stamp	Ender Matthias
Telephone	+43 5524 501 322
Mail	matthias.ender@ernefittings.com

The certificate is issued by the computerized system and is valid without signature.

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Indication in parentheses correspond to attributes according to EN 10168

Official approvals

(Z05)

Approved by	Name	Certificate No.
TUEV Management Service GmbH	EN ISO 9001:2015	12 100 3054 TMS
TUEV Industrie Service GmbH	AD 2000 - Merkblatt W0; Pressure Equipment Directive (PED) 2014/68/EU Annex I, Paragraph 4.3 ; EN 764-5, Para. 4.2	DGR - 0036 - QS - W 129 / 2002 / MUC

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