

Lal Baba Seamless Tubes Pvt. Ltd.

[AN IATF16949:2016, ISO 9001:2015,
ISO 14001:2015, ISO 45001:2018 Certified Company]
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CIN No. U27310WB2006PTC110060



LAL BABA SEAMLESS TUBES

DOC. No: LBST/QAR/15 Rev.05 Dt: 06.01.2021

MILL TEST CERTIFICATE

CERTIFICATE ACCORDING TO EN 10204 : 3.2

PURCHASER NAME :		OPTIMA STEEL INTERNATIONAL LLC.				TEST CERTIFICATE No.:		0266/2022					
PURCHASER ORDER No. :		PO-40434 (PO NO. 10P36607) rev.3		Date :		23-12-2021		TEST CERTIFICATE Date :					
WORK ORDER No. :		LBST / WO / EXP / 5488 rev.3		Date :		14-01-2022		INVOICE NO:					
NAME OF STEEL SUPPLIER :		RASHTRIYA ISPAT NIGAM LIMITED - INDIA - Melt & Pour				INVOICE Date :		-					
STEEL MAKING METHOD :		BOF-LF/IRUT-CCM-ROUND METHOD, Fully Killed											
PROCESS OF PIPE MANUFACTURE :		CDS / CS / PIPES											
MANUFACTURE PROCESS ROUTE :		PM-HI-STP-CD-HT-Finishing-NDT-P&F-Dispatch.				CUSTOMER UID NO		ITEM NO. 5					
SPECIFICATION & GRADE :		ASTM A106 GR.B(Ed.2015)/ASME SA106 GR.B(Ed.2019) // ASTM A53 GR.B(Ed.2012)/ASME SA53 GR.B(Ed.2019), NACE MR0175 / NACE MR0103											
Sr. No.	LBST HEAT NO	SUPPLIER HEAT NO	SIZE				Quantity			General			
			OD (Inch)	ID (Inch)	WT(Inch)	Length (Feet)	Nos.	FEET.	MT.	End Condition	Coating		
1	18R073	21E05921	OD 1/2" x WT 0.1470" x 21 FEET				2061	43281.00	-	Plain End	Black paint		
CHEMICAL COMPOSITION (%)													
Sr. No.	HEAT NO	REQUIRED	%C	%MN	%SI	%S	%P	%Cr	%Ni	%Cu	%Mo	%V	%C.E
		Min	-	0.29	0.10	-	-	-	-	-	-	-	-
		Max	0.30	1.08	-	0.035	0.035	0.40	0.40	0.40	0.15	0.08	-
1	21E05921	L/A	0.20	0.65	0.24	0.011	0.018	0.009	0.000	0.000	0.000	0.000	0.310
	18R073	P1/A	0.20	0.64	0.25	0.012	0.019	0.010	0.002	0.004	0.001	0.002	0.306
		P2/A	0.20	0.65	0.24	0.012	0.019	0.010	0.002	0.004	0.001	0.002	0.308
MECHANICAL PROPERTIES													
Sr. No.	HEAT NO	REQUIRED	YIELD STRENGTH (Pa)	TENSILE STRENGTH (Pa)	ELONGATION (%)	HARDNESS (BHN)	IMPACT TEST	BEND TEST	FLARING TEST	GRAIN SIZE			
			G.L = 50.00 mm, Pipes tested on full section										
		Min	35000	60000	30	-	-	-	-	-			
		Max	-	-	-	237	-	-	-	-			
1	18R073		41017	70520	47.60	123 - 125	NA	OK	NA	NA			
NON-DESTRUCTIVE TEST													
Sr. No.	HEAT NO	STRAIGHTNESS	HYDRO-STATIC TEST as per AS30 & holding time 5 sec min(100%)	E.C.T. as Per ASTM E-309 (100%)	U.T. AS PER ASTM E-213 (100%)	VDI	SURFACE QUALITY						
							IN SIDE / OUT SIDE	RA VALUE	PMI				
1	18R073	Satisfactory	2500 PSI, OK	OK	NA	Satisfactory	Satisfactory	NA	NA				
Heat Treatment : Heat Treated Above 650°C (1200°F)													
MARKING: LBST / / CDS / ASTM A53 B/ASME SA53-B/106B/SA 106B/NACE MR0175/MR0103 / 1/2", /XH x WT 0.1470" x 21.000 FEET / HEAT NO. 18R073/ HYD. 2500 PSI / NDE / PO NO. 10P36607 / WEIGHT 10.34 KG													
REMARKS: 1. Hardness as per NACE. 2. We hereby certify that the material herein described has been Manufactured, Sample tested & Inspected in accordance with above standard, specification & P.O requirement & result found satisfactory.													
Legends : 1. L/A - Ladle Analysis, 2. P1/A - Product Analysis One, 3. P2/A - Product Analysis Two, 4. CDS= Cold Drawn Seamless, 5. CS = Carbon Steel, 6. PM - Piercing Mill, 7. HI - Hollow Inspection, 8. STP - Surface Treatment Plant, 9. CD= Cold Drawn, 10. HT - Heat Treatment, 11. NDT - Non Destructive Testing, 12. VDI= Visual Dimension Inspection, 13. P&F - Packing & Forwarding.													
For, LAL BABA SEAMLESS TUBES PVT. LTD.													
ISSUED BY:													
Kalyada Samanta ENGINEER (QA/QC)								Sanjay Bhair Asst. General Manager (QA/QC)					



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