

R EMPRESAS RIGA, S.A de C.V.

CONEXIÓN SOLDABLE

CARR. MTY-LAREDO KM. 24.2

APARTADO POSTAL 43 C.P. 65550 CIÉNEGA DE FLORES, N.L., MÉXICO

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CERTIFICADO DE CALIDAD No.: 9378 LISTA DE EMPAQUE : 5551 CERTIFIED TEST REPORT: PACKING LIST:	FECHA: OCTUBRE 18 de 2002 DATE:
VENDIDO A: TUBOS CONEXIONES Y TANQUES, S.A. DE C.V. VALLE DE LAS ALAMEDAS 66-C COL., SAN FCO SOLD TO: CHILPAN TULTITLAN, EDO. DE MEXICO	PEDIDO DEL CLIENTE No. CUSTOMERS ORDER No. EMBARCADO A: SHIP TO: LOS MISMOS
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PRUEBAS MECANICAS/MECHANICAL TEST

CANTIDAD QUANTITY	COLADA HEAT CODE	DESCRIPCION DESCRIPTION	PRODUCTO FINAL/FINISHED PRODUCT				
			ESF. DE CEDENCIA YIELD STRENGTH (PSI)	ESF. RUPTURA TENSILE STRENGTH (PSI)	ELONGACION ELONGATION % 2"	DUREZA HARDNESS HB	IMPACTO 0°C IMPACT TEST 0°C X (JOULES)
			17	BG4	CODO 1 1/4 X 45 CED STD	47800	71120
98	JX5	CODO 1 1/4 X 45 CED STD	56581	77818	54	128	N/A
35	TH4	CODO 1 1/4 X 45 CED STD	48894	72822	50	127	N/A
153	JX5	CODO R.L. 1 1/4 X 90 CED STD	56581	77818	54	128	N/A
171	TH4	CODO R.L. 1 1/4 X 90 CED STD	48894	72822	50	127	N/A
40	GP5	CODO R.L. 10 X 90 CED STD	47955	69322	41	140	N/A
40	LF5	CODO R.L. 10 X 90 CED STD	44484	71498	37	137	N/A
44	KL5	CODO 12 X 45 CED STD	48979	74258	40	143	N/A
24	KL5	CODO R.L. 12 X 90 CED STD	48979	74258	40	143	N/A
15	KQ5	CODO R.L. 12 X 90 CED STD	50757	73134	45	143	N/A
1	BH5	CODO 14 X 45 CED STD	45838	66968	31	144	N/A

ANALISIS QUIMICO/CHEMICAL ANALYSIS

COLADA HEAT CODE	COLADA/HEAT M.P./MOTHER PIPE	C.E.	C	Mn	P	S	Si	Cr	Cu	Mo	Ni	V	Nb
	BG4	0.292	0.160	0.700	0.003	0.013	0.220	0.030	0.040	0.010	0.060	0.001	0.000
	JX5	0.334	0.180	0.810	0.010	0.001	0.290	0.040	0.040	0.030	0.030	0.001	0.001
	TH4	0.333	0.190	0.770	0.010	0.001	0.290	0.030	0.051	0.020	0.020	0.001	0.001
	JX5	0.334	0.180	0.810	0.010	0.001	0.290	0.040	0.040	0.030	0.030	0.001	0.001
	TH4	0.333	0.190	0.770	0.010	0.001	0.290	0.030	0.051	0.020	0.020	0.001	0.001
	GP5	0.310	0.180	0.660	0.009	0.003	0.280	0.050	0.064	0.017	0.030	0.000	0.000
	LF5	0.319	0.180	0.680	0.009	0.003	0.280	0.070	0.077	0.021	0.040	0.000	0.000
	KL5	0.353	0.190	0.850	0.008	0.003	0.300	0.050	0.072	0.021	0.040	0.000	0.000
	KL5	0.353	0.190	0.850	0.008	0.003	0.300	0.050	0.072	0.021	0.040	0.000	0.000
	KQ5	0.322	0.190	0.650	0.007	0.003	0.270	0.050	0.080	0.030	0.040	0.000	0.000
	BH5	0.311	0.180	0.660	0.006	0.002	0.250	0.040	0.066	0.029	0.040	0.000	0.000

LOS PRODUCTOS MANUFACTURADOS POR EMPRESAS RIGA, S.A. de C.V. ESTAN CONFORME A LAS SIGUIENTES ESPECIFICACIONES:
 PRODUCTS MANUFACTURED BY EMPRESAS RIGA, S.A. de C.V. ARE CONFORMING TO FOLLOWING SPECIFICATIONS:
 MATERIA PRIMA T S/C / STARTING MATERIAL SEAMLESS PIPE: ASTM A 106 GRADE B ACCORDING TO DIN 50049/3.1. B/EN 10204/3.1. B.
 MATERIAL CONFORME A:
 MATERIAL CONFORM TO: ASTM A 234 WPB, ASME SA 234 WPB, ASME II PART A ED. 2001, ASME B16.9, ASME B16.28 AND TO NACE MR 01.75 ED 2001.
 CONEXIONES SIN COSTURA, FORJADO EN CALIENTE (ENFRIADO AL AIRE) O NORMALIZADO (TEMPERATURA 920°C MAX PERMANENCIA 10').
 SEAMLESS FITTINGS, HOT FORMED (COOLED IN STILL AIR) OR NORMALIZED (TEMPERATURE IE 920°C MAX AND HOLDING TIME IE 10').
 INSPECCION VISUAL Y DIMENSIONAL CONFORME A STANDARDS APLICABLES.
 VISUAL AND DIMENSIONAL TEST CONFORM TO THE APPLICABLE STANDARDS.

CC-008

GERENTE DE ASEGURAMIENTO DE CALIDAD:
 QUALITY ASSURANCE MANAGER:

ING. JOSE MARTINEZ MACIAS.

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