

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

TELS.- (8) 344-84-83, 344-84-45, 344-88-60

FAX:(8) 344-88-01

CERTIFICADO DE CALIDAD No.: 9381 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: LOS MISMOS SHIP TO:	
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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)
			80	GX5	RED. CONC. 4 X 2 CED XS	45672	71563
50	CX5	RED. CONC. 6 X 4 CED STD	45463	69627	30	131	N/A
15	CN5	RED. CONC. 8 X 4 CED STD	45646	68352	34	141	N/A
15	CN5	RED. CONC. 8 X 5 CED STD	45646	68352	34	141	N/A
100	VD3	TEE 1 1/4 CED STD	50100	72600	42	134	N/A
54	GV5	TEE 12 CED STD	52393	70673	46	144	N/A
16	JR5	TEE 16 CED STD	50672	71257	44	144	N/A
200	KG5	TEE 2 1/2 CED STD	46690	70545	35	156	N/A
500	LY5	TEE 3 CED STD	49745	70109	31	135	N/A
25	ZZ4	TEE 5 CED XS	48079	70969	35	129	N/A
50	OK4	TEE RED. 3 X 2 CED STD	46900	70500	37	135	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
	GX5	0.334	0.190	0.760	0.012	0.001	0.310	0.030	0.050	0.020	0.050	0.001	0.001
	CX5	0.294	0.160	0.670	0.006	0.001	0.270	0.050	0.061	0.031	0.030	0.000	0.000
	CN5	0.294	0.160	0.660	0.004	0.003	0.270	0.050	0.062	0.038	0.040	0.000	0.000
	CN5	0.294	0.160	0.660	0.004	0.003	0.270	0.050	0.062	0.038	0.040	0.000	0.000
	VD3	0.294	0.190	0.570	0.014	0.012	0.230	0.020	0.020	0.010	0.030	0.000	0.000
	GV5	0.304	0.170	0.690	0.006	0.003	0.280	0.040	0.070	0.016	0.040	0.000	0.000
	JR5	0.323	0.190	0.670	0.011	0.003	0.260	0.040	0.066	0.025	0.060	0.000	0.000
	KG5	0.320	0.180	0.650	0.011	0.003	0.240	0.060	0.169	0.020	0.056	0.001	0.001
	LY5	0.322	0.190	0.630	0.010	0.002	0.230	0.050	0.090	0.030	0.072	0.001	0.001
	ZZ4	0.288	0.175	0.598	0.008	0.006	0.270	0.015	0.068	0.007	0.030	0.011	0.000
	OK4	0.312	0.180	0.740	0.009	0.007	0.220	0.010	0.010	0.020	0.020	0.002	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.ACORDING 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 STANDARD.

GERENTE DE ASEGURAMIENTO DE CALIDAD:
QUALITY ASSURANCE MANAGER:

ING. JOSE MARTINEZ MACIAS.

e-mail imartinez@empresasriga.com