



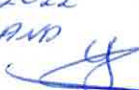
	QTR Qualification Test Record NORSOK M-650 EDITION 4				QTR. No.: 3	
					Rev. No.: 8	
Manufacturer name/address/ Web	TTI Tubacex Tubos Inoxidables SAU Tres Cruces, 8 01400 Llodio (Alava) Spain www.tubacex.com					
Reference standard	NORSOK M-650 EDITION 4 ASTM A312, A269					
Material designation and MDS No.:	SEAMLESS PIPES TUBES UNS S31254 NORSOK M-630: 2020: MDS R11-rev. 6 , MDS R18- rev6					
Manufacturing summary doc. No.:	1. MS S 31254 HF1 2. MS S 31254 HF2 3. MS S 31254 CF3				Rev. No.: 7 Rev. No.: 6 Rev. No.: 7	
Products and manufacturing process(es):	1. SEAMLESS PIPES AND TUBES HOT FINISHED DIRECT WATER QUENCHING 2. SEAMLESS PIPES AND TUBES HOT FINISHED, HEAT TREATMENT IN CONTINUOUS FURNACE 3. SEAMLESS PIPES AND TUBES COLD FINISHED, HEAT TREATMENT IN CONTINUOUS FURNACE					
Mandatory conditions and sub-contractors:	Acería de Alava, S.A.U. (Sister company to Tubacex Tubos Inoxidables, SAU) is the main supplier of the material. Extruded hollows from TTI Llodio, Schoeller Bleckmann or trepanned hollows from IBF can be used for cold rolling. Materials manufactured with processes HF2 and CF3 are to be mandatorily heat treated in Guinea furnace #3. TTI-ACERALAVA do have in house testing facilities to cover all the testing required by UNS S31254 reference standards. Laboratory is included in the ISO 9001 QA system and ISO 17025 accredited for tensile, impact and hardness testing.					
Other information:	Verification of heat treatment as per instruction TX-INOX-42 and TX-INOX-51, witnessed by qualifying company SFF: <ul style="list-style-type: none"> • TTI Llodio Direct water quenching (report VHT-003) Verification of heat treatment witnessed by Lloyd's register: <ul style="list-style-type: none"> • TTI Amurrio Guinea continuous Furnace #3 (report VHT-009) • TTI Guinea continuous furnace #3 (report VHT-007) 					
Expiry date	02.06.2027					
Tested and Qualified Thickness and Weight						
Process number	Test record No.	Test date	Tested Thickness (mm)	Qualified thickness (mm)	Test piece weight	Qualified weight (kg)
1	377487	8/3/2006	18,26	22,83	NA	NA
1	21603-4	16/3/2016	23,01	23,01	NA	NA
1	21603-3	18/3/2016	23,01	23,01	NA	NA
2	21603-5	18/3/2016	23,01	28,76	NA	NA
3	I009301_10	13/05/2022	6,35	7,94	NA	NA
Qualification/Acceptance signatures						
Manufacturer:	Prepared by/Date:  Iñigo Arriola May 2022			Checked by/Date:  Aitor González May 2022		
The manufacturer and this QTR are evaluated and found to be in compliance with the requirements of NORSOK M-650 for supply of the above listed products and materials. This acceptance does not exempt any purchaser from his responsibility to ensure that this qualification is valid for his products within the essential variables of NORSOK M-650.						
Qualified/Accepted by (company name/address):  				Signature/Date: 02.06.2022 INGVE STANGELAND 		

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