



	QTR Qualification Test Record NORSOK M-650 EDITION 4					QTR. No.: 4
						Rev. No.:9
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 A790, ASTM A789					
Material designation and MDS No.:	SEAMLESS PIPES TUBES UNS S32750 NORSOK M-630:2020: MDS D51-rev. 6 , MDS 58- rev6					
Manufacturing summary doc. No.:	1. MS 32750 HF1 2. MS 32750 HF2 3. MS 32750 CF3				Rev. No.: 6	Rev. No.: 6
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:	Aceria 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, except for tubes/pipes with WT max. 4 mm that can be heat treated in furnace #1. TTI-ACERALAVA do have in house testing facilities to cover all the testing required by UNS S32750 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 #1 (report VHT-010) • TTI Amurrio Guinea continuous Furnace #3 (report VHT-009) Verification of heat treatment for Umbilical tubing witnessed by Qualifying Company Nexans: <ul style="list-style-type: none"> • TTI Guinea continuous furnace #3 (report VHT-007) 					
Expiry date	07.03.2027					
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	ZID200-30	17/02/2022	25,80	27,44	NA	NA
2	ZID100-62	04/01/2022	27,40	27,40	NA	NA
3	606149	19/5/2014	12,70	15,88	NA	NA
3	641822 (UMBILICAL)	15/02/2016	4,91	6,14	NA	NA
3	641823 (UMBILICAL)	15/02/2016	7,01	8,76	NA	NA
3	21603-1 (LONG PIPE)	18/03/2016	15,88	19,85	NA	NA
3	5062018	07/06/2018	3,91	4,00	NA	NA
Qualification/Acceptance signatures						
Manufacturer:	Prepared by/Date:  Iñigo Arriola February 2022			Checked by/Date:  Aitor González February 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: 07.03.2022 INGVE STANGELAND 		

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