



HP Valves Oldenzaal BV

P.O. Box 151  
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## COVERPAGE TO INSPECTION / TEST CERTIFICATE

Customer : CMI (HRSG + Energy Services)  
Project : Yajva SBV  
Customer P/O no : 203/2010/900588  
Shop order no : 2010 0006  
Item no : 123 / 000  
Quantity : 2 pcs  
  
KKS No : 15LAF10AA118      15LAF10AA131

Medium & high-pressure valves in  
accordance with ASME, API, BS & DIN



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## INSPECTION / TEST CERTIFICATE

EN 10204:2004 - 3.1

Medium & high-pressure valves in  
accordance with ASME, API, BS & DIN

Customer : CMI (HRSG + Energy Services)					
Project : Yajva SBV					
Cust. P/O no : 203/2010/900588					
HP order reference : 20100006					
Item no : 123/000					
Qty	Nominal size	Description			
2 pcs	2" / DN 50	<p>Figure no : 66F01A3CBZ10H</p> <p>2500 lbs</p> <p>gate valve, short pattern, bonnetless, floating backseat, c/w position indicator and non-rotating stem.</p> <p>body: ASTM A105N, stem: 17Cr, wedge: stellite, seat: stellite, packing: graphite, bolting: A193 B7 / A194 2H, end-to-end: 192 mm.</p> <p>with SW-ends for pipe size 60,3 x 11,07mm acc. ASME B16.11</p> <p>Marking body : <b>NP</b></p>			
Tests performed in accordance with : <b>ASME B16.34 / API 598 / MSS SP 61</b>					
TEST DESCRIPTION	P bar	REMARKS	TESTED	RESULTS	
SHELL TEST	647		✓	Accepted	
BACKSEAT TIGHTNESS TEST	N.A				
HIGH PRESSURE CLOSURE TEST	474	In the appropriate direction only; except for gate valves	✓	Accepted	
LOW PRESSURE CLOSURE TEST (AIR)	N.A	In the appropriate direction only; except for gate valves			
FUNCTIONAL TEST <small>In case of actuating devices, closing and opening will be checked</small>	Closing or opening time at 50 Hz			N.A	
DIMENSIONAL CHECK	SATISFACTORY	FUNCTIONAL CHECK	SATISFACTORY	VISUAL CHECK	SATISFACTORY
✓ = Test results were acceptable considering the applicable procedures and requirements. General inspections have confirmed that workmanship and finish are in accordance with the acceptance criteria.					
Signed HP VALVES BV :		<div style="border: 1px solid black; padding: 5px; display: inline-block;">HP VALVES BV QUALITY CONTROL F. WOLBERS</div> Signed THIRD PARTY:			
OLDENZAAL 15-07-2010					

Bank: ABN-AMRO BIC: ABNANL2A  
EUR-account: 59.55.41.437 IBAN: NL88ABNA0595541437  
USD-account: 57.60.74.780  
Trade register Enschede: 060.567.50  
VAT no: NL 008671242 B 01

Member of Indutrade AB



# Abnahmeprüfzeugnis EN 10 204 / 3.1

Inspection certificate  
Certificat de Réception  
Certificato Collaudo materiali

## KB Schmiedetechnik GmbH

Postfach 60 02 03 - 58138 Hagen-Halden  
Gesensschmiede - Zerspanungstechnik  
Telefon: 02331/3508-0, Telefax: 3508-30

KB Schmiedetechnik GmbH, Postfach 60 02 03, 58138 Hagen

Prüf-Nr. - Inspection-no. -  
Certificat No.-No. di collaudo: 090466

H.P. Valves B.V.

Blatt-Nr. - Sheet-no. - Page-No. - Pag-No.: 1 / 2

Postfach 1 51

Bestell-Nr. - Order-no. - No. de la commande -  
No. dell'ordine: P091561

NL - 7570 AD Oldenzaal

vom - dated - date - In data: 10.06.09

Werks-Nr. - Works-no. -  
No. usine - Commesen No.: 090466

Hersteller - Manufacturer - Fabrikant - Produttore: KB Schmiedetechnik GmbH

Prüfgegenstand - Article - Produit - Prodotto: Gesensschmiedestücke/drop forgings

Prüfgrundlagen/Anforderungen-Technical requirements/Demand-Spécifications techniques/Exigences-Norma di controllo/requisi  
F 02.15-20 Rev. 2,  
F 02.15-00 Rev. 1

Werkstoff - Material - Matière - Material:

entsprechend - according to - suivant -  
accondo:

Ausgabe - Edition - Edizione:

P 250 GH (1.0460), A 105,  
SA 105

DIN EN 10222-2, ASTM A105  
ASME Code Sect. II Part A

04/2000, 2005  
Edition 2007 Addenda 2008

Lieferzustand - State of delivery - Etat de livraison - Stato di fornitura:

normalgeglüht/normalized

Erschmelzungsart - Steelmaking process - Procédé d'élaboration - Procedimento di elaborazione:

E

Kennzeichnung - Marking - Marquage - Punzonatura:

NP

Herstellerzeichen - Brand of Manufacturer -

0460

Marque du fabricant - Marchio del produttore:

Werkstoff - Material - Matière - Materiale:

SA 105

Stempel des Sachverständigen - Inspector's stamp -

H 17

Poinçon de l'expert - Marchio del collaudatore:

KB  
WKA

Pos.-Nr. Item-No. Poste-No No. pos.	Stückzahl Piece number Qty Numero pezzi	Gegenstand Article Désignation du produit Tipo di prodotto	Schmelze-Nr. Heat-no. No. de coulée No Colata	Probe-Nr. Test-no. No. d'éprouvette No. di prova
1	503	Gehäuse/bodies H 17.0100.000000 KB-Art.: 08760-A.2025.001 Gesenk-Nr./die-no.: 8760 Gewicht/weight: 21,5 kg	246912	971

HP VALVES Medium & high pressure valves  
acc. ANSI, API, BS & DIN

☒ Reviewed ☐ Witnessed

F. Wolters - G.C.  
Date: 20.06.09

Die gestellten Anforderungen sind lt. Anlage erfüllt. - the Requirements are  
fulfilled as per annex. - Les conditions imposées sont satisfaites suivant  
annexes. - I risultati sono conformi ai requisiti richiesti come da allegati.

58093 Hagen, Buschmühlenstr. 62

27.07.09

(Ort - Location - Lieu - Località)

(Datum - Date - data)

## KB Schmiedetechnik GmbH

Der Werksachverständige - Works-Surveyor  
L'expert d'usine - L'ispettore del commessa

Walter

Anlagen - Annex - Annexes - Allegati: Ergebnis der Prüfungen - Test results - Risultati des Essais - Risultati delle Prove

## Risultati delle Prove

**Telefon: 02331/3508-0, Telefax: 3508-30**

Anlage - Annex - Annexe - Allegato

No. di collaudo

Pag No.

Mechanische Prüfungen - Mechanical tests - Essais mecaniques - Prove meccaniche

Prüflart - Test type - Type d'essai - Tipo di prova: Probeart - Specimen type - Type de l'éprouvette - Tipo di provetta: Probenzustand - state of delivery of specimen - traitement de l'éprouvette - Stato delle			<b>ZUGVERSUCH</b> <b>RUNDPROBE</b> DIN EN 10 002					<b>KERBSCHLAGBIEGEVERS.</b> KV CharpyV DIN EN 10 045					
Probe-Nr. Test No. No. d'éprouvette No. di prova	Probenabmessung Dim. of specimen Dim. de l'éprouvette Dim. della provetta		Prüftemperatur Test temperature Température d'essai Temperature di prova	Streck/Dehngrenze Yield point Proof stress Limite d'élasticité Lim. di snervamento	Zugfestigkeit Tensile strength Résistance à la traction Carico di rottura	Bruchdehnung Elongation Allongement Allungamento	Bruchreduktion Reduction of area Striction/Strizione	X1 = Schlagarbeit - Energy of Impact Energie de rupture - Energia di rottura [J] 2 = Krist. Bruchanteil - Cryst. proportion Partie cristalline - Porporzione cristallina [%] 3 = Breitung - Expansion - Elargissement [mm]					
	Richtung Direction Senso	Breite ø Width ø Largeur, ø Largh, ø						A Lo= 5d 4d	Z	Werte - Values - Valeurs - Valori			Σ / n
										1	2	3	
<b>Anforderungen</b> <b>Requirements</b>	<b>Q</b> <b>L</b>			<b>250</b> <b>ReH</b>	<b>485-540</b>	<b>22</b> <b>25</b>	<b>30</b>	<b>31</b> <b>44</b>					
971	L	10,0	20	374	530	28/30	64	1)= 102-99-105					

Warmbehandlung/Heat treatment: 910° C normalisiert/normalized - 1 h - Abkühlung/cooling: Luft/air

$$C_{eq} = 0,37 \%$$

Härteprüfung/hardness test HBW 10/3000 = 146-152

Oberflächenriß-Prüfbericht/surface-crack test-report - siehe Anlage/see annex

**Besichtigung u. Ausmessung:**

Inspection and control of dimension:  
Examen et contrôle dimensionnel:

ohne Bearstandung/without objection

Schmelze-Nr.  
Heat-No.  
No. Coolea  
Cöleta No.

analyse nach Werkstoffherstellerangaben  
analysis acc. to the data of the material manufacturer

[illegible]

KB Schmiedetechnik GmbH

Der Werkssachverständige - Works-Surveyor  
L'expert d'usine - L'ispettore del commessa

(Ort - Location - Lieu - Località)

(Datum - Date - data)

Woller

## Abnahmeprüfzeugnis/Inspection certificate DIN EN 10204 / 3.1

KB Schmiedetechnik GmbH  
HAGEN-HALDEN

Hagen, den 27.07.2009

Oberflächenriß-Prüfbericht  
Surface-crack test-report

Nr./no. 090466

Pos./item 1

Kommission/Com.-no.: 090466      Besteller/purchaser: H.P. Valves BV, NL-OLDENZAAL  
 Bestell-Nr./order-no.: P091561 - 10.06.2009  
 Anforderungen/requirements: F 02.15-20 Rev. 2  
 ASTM A 275 / acc. ASME B16.34 appendix II + DIN EN 10228-1 QC 3

Prüfumfang/range of test:  % H       Stück geprüft/pieces tested  
 Oberfläche bearbeitet/surface machined: ☐ ja/yes      ☒ nein/no      ☒ gestrahlt/blasted  
 Warmbehandlung/heat treatment: ja/yes  
 Beurteilung/valuation: rißfrei/free of cracks


## MAGNETPULVERPRÜFUNG / magnetic particle test

Magnetisierungsart / magnetization kind: Jochmagnetisierung / yoke method  
 Selbstdurchflutung / prod method  
 Prüfgerät / test detector: UW 600 Fa. Deutsch  
 Prüfmittel / test medium: HRS 9306 - fluoreszierend / fluorescent  
 Feldstärke / field strenght: > 2,5 kA/m  
 Restmagnetismus/remainder-magnetism: < 800 A/m  
 Betrachtungsbedingungen/observing conditions: Hintergrundbeleuchtung/lighting-background < 20 lx  
 Bestrahlungsstärke auf der Oberfläche/ray-treatment-strength on the surface: > 10 W/qm

Pos./ item	Gegenstand/ Produkt	Gesenk-Nr./ die-no.	Werkstoff/ material	Schmelze/ heat-no.	Kennz./ marking:
1	Gehäuse/bodies H 17.0100.000000 KB-Art.: 08760-A.2050.001	8760	1.0460/ (S)A 105	246912	NP

Sachverständiger/inspector:

Prüfaufsicht/examination supervisor:

Hersteller/manufacture:  MPE

Unterschrift/signature

Unterschrift/signature  