



HP Valves Oldenzaal BV

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

## 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 : 131 / 000

Quantity : 2 pcs

KKS No : 15HAD10AA107      15HAD10AA108

Bank ABN-AMRO SWIFT-address ABNANL2A  
EUR-account 59.55.41.437 IBAN-code NL88ABNA0595541437  
USD-account 57.60.74.780  
Trade register Enschede 060.567.50  
VAT no NL 008671242B01

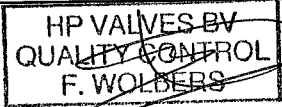
Member of Indutrade AB



**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 : 131/000  |   |   |                        |
| Qty  | Nominal size  | Description   |                        |
| 2 pcs  | 3/4" / DN 20  | Figure no : 21A01A3CBA05F<br><br>1500 lbs<br>throttle type globe valve, straight pattern, bonnetless, floating backseat,<br>body: ASTM A105N / P250GH,<br>stem/disc: 17Cr/stellited, seat: stellite,<br>packing: graphite, bolting: A193 B7 / A194 2H,<br>end-to-end: 230 mm.<br>with SW-ends for pipe size 26,7 x 5,56mm acc. ASME B16.11<br><br>Marking body : <b>XY678</b> |                        |
| Tests performed in accordance with : <b>ASME B16.34 / API 598 / MSS SP 61</b>  |   |   |                        |
| <b>TEST DESCRIPTION</b>  | <b>P bar</b>  | <b>REMARKS</b>  | <b>TESTED</b>          |
| SHELL TEST   | 389   |   | ✓                      |
| BACKSEAT TIGHTNESS TEST  | N.A   |   |                        |
| HIGH PRESSURE CLOSURE TEST   | 285   | In the appropriate direction only;<br>except for gate valves  | ✓                      |
| LOW PRESSURE CLOSURE TEST (AIR)  | N.A   | In the appropriate direction only;<br>except for gate valves  |                        |
| FUNCTIONAL TEST<br><small>In case of actuating devices, closing and opening will be checked</small>  | Closing or opening time<br>at 50 Hz   |   | N.A                    |
| DIMENSIONAL<br>CHECK   | SATISFACTORY  | FUNCTIONAL<br>CHECK   | SATISFACTORY           |
| VISUAL<br>CHECK  |   |   |                        |
| SATISFACTORY   |   |   |                        |
| ✓ = Test results were acceptable considering the applicable procedures and requirements.<br>General inspections have confirmed that workmanship and finish are in accordance with the acceptance criteria. |   |   |                        |
| Signed<br>HP VALVES BV :   | <br>OLDENZAAL 27-07-2010 |   | Signed<br>THIRD PARTY: |

# 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: 090467

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: P091559

NL - 7570 AD Oldenzaal

vom - dated - date - in data: 10.06.09

Werks-Nr. - Works-no. -  
No. usine - Commesse No.: 090467

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

Werkstoff - Material - Matière - Materiale:

entsprechend - according to - suivant -  
acconco:

Ausgabe - Edition - Edizione:

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

DIN EN 10222-2, ASTM A 105,  
ASME 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: XY 678  
0460

Herstellerzeichen - Brand of Manufacturer -  
Marche du fabricant - Marchio del produttore:

Werkstoff - Material - Matière - Materiale:

SA 105  
H 82

Stempel des Sachverständigen - Inspector's stamp -  
Policon de l'expert - Marchio del collaudatore:

KB  
WBA

| Pos.-Nr.<br>Item-No.<br>Poste-No.<br>No. pos.  | Stückzahl<br>Piece number<br>Qty<br>Numero pezzi | Gegenstand<br>Article<br>Désignation du produit<br>Tipo di prodotto   | Schmelze-Nr.<br>Heat-no.<br>No. de coulée<br>No Colata | Probe-Nr.<br>Test-no.<br>No. d'éprouvette<br>No. di prova |
|--|--|---|--|---|
| 3  | 600  | Gehäuse/bodies 20-25 MM PN 640<br>H 82.8600.000000<br>KB-Art.: 08647-A.2025.001<br>Gesens-Nr./die-no.: 8647<br>Gewicht/weight: 5,3 kg | 85651  | 906   |
| <div><div>HP VALVES Medium &amp; high pressure valves<br/>acc. ANSI, API, BS &amp; DIN</div><div><input checked="" type="checkbox"/> Reviewed<br/><input type="checkbox"/> Witnessed<br/><input type="checkbox"/></div><div>F. Wolters - Q.C.<br/>Date: 20.07.09</div></div> |  |   |  |   |

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

Wolter

**Ergebnis der Prüfungen**  
**Test Results**  
**Résultats des Essais**  
**Risultati delle Prove**

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

Anlage - Annex - Annexe - Allegato

Prüf-Nr. 090467  
Inspection No.  
Certificat No.  
No. di collaudo

Blatt-Nr. 2 / 2  
Sheet-No.  
Page No.  
Pag No.

**Mechanische Prüfungen - Mechanical tests - Essais mecaniques - Prove meccaniche**

| Prüfart - Test type - Type d'essai -<br>Tipo di prova:<br>Probestart - Specimen type -<br>Type de l'éprouvette - Tipo di provetta:<br>Probenzustand - state of delivery of specimen -<br>traitement de l'éprouvette - Stato delle |                                |   | <b>ZUGVERSUCH</b><br><b>RUNDPROBE</b><br><br>DIN EN 10 002                        |  |  |   | <b>KERBSCHLAGBIEGEVERS.</b><br><b>KV CharpyV</b><br><br>DIN EN 10 045 |   |   |       |
|---|--------------------------------|---|---|--|--|---|---|---|---|-------|
| Probe-Nr.<br>Test No.<br>No. d'éprouvette<br>No. di prova   | Richtung<br>Direction<br>Senso | Breite ø<br>Width ø<br>Largeur, ø<br>Largh, ø | Prüftemperatur<br>Test temperature<br>Temperature d'essai<br>Temperatura di prova | Streck-/Dehngrenze<br>Yield point Proof stress<br>Limite d'élasticité<br>Lim. di snervamento | Zugfestigkeit<br>Tensile strength<br>Resistance à la traction<br>Carico di rottura | Bruchdehnung<br>Elongation<br>Allongement<br>Allungamento | Bruchreduktion<br>Reduction of area<br>Striction/Stizione             | X1 = Schlagarbeit - Energy of Impact<br>Energie de rupture - Energia di rottura [J]<br><br>2 = Krist. Bruchanteil - Cryst proportion<br>Partie cristalline - Proporzione cristallina [%]<br><br>3 = Breitung - Expansion - Elargissement [mm] |   |       |
|   |                                | mm  | °C  | N/mm²  | N/mm²  | A<br>Lo= 4d<br>%  | Z   | Werte - Values - Valeurs - Valori   |   |       |
|   |                                |   |   |  |  |   |   | 1   | 2 | Σ / n |
| Anforderungen<br>Requirements   | Q<br>L                         |   |   | 250<br>ReH   | 485-540  | 22<br>25  | 30  | 31<br>44  |   |       |
| 906   | Q                              | 10,0  | 20  | 331  | 488  | 24/26   | 73  | 1)= 185-178-173   |   |       |

Warmbehandlung/Heat treatment: 910°C normalgeglüht/normalized - 1 h - Abkühlung/cooling: Luft/air  
Ceq = 0,3700 %  
Härteprüfung/hardness test HBW 10/3000 = 146-149  
Oberflächenriß-Prüfbericht/surface-crack test-report - siehe Anlage/see annex

Besichtigung u. Ausmessung:  
Inspection and control of dimension:  
Examen et contrôle dimensionnel: ohne Beanstandung/without objection

| Schmelze-Nr.<br>Heat-No.<br>No. Coolea<br>Colata No. | Analyse nach Werkstoffherstellerangaben<br>analysis acc. to the data of the material manufacturer |        |        |        |        |        |        |        |        |        |        |
|--|---|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
|  | C %   | Si %   | Mn %   | P %    | S %    | Al %   | Cu %   | Cr %   | Mo %   | Ni %   | V %    |
| 85651  | 0,1800  | 0,1900 | 0,9000 | 0,0110 | 0,0070 | 0,0290 | 0,2700 | 0,0700 | 0,0200 | 0,1100 | 0,0010 |
|  |   |        |        |        |        |        |        |        |        |        |        |
|  | Nb %  |        |        |        |        |        |        |        |        |        |        |
| 85651  | 0,0020  |        |        |        |        |        |        |        |        |        |        |
|  |   |        |        |        |        |        |        |        |        |        |        |

**KB Schmiedetechnik GmbH**  
Der Werkssachverständige - Works-Surveyor  
L'expert d'usine - L'ispettore del commessa

58093 Hagen, Buschmühlenstr. 62  
(Ort - Location - Lieu - Località)

27.07.09  
(Datum - Date - data)

Wolter

## 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. 090467

Pos./item 3

Kommission/Com.-no.: 090467      Besteller/purchaser: H.P. Valves BV, NL-OLDENZAAL  
 Bestell-Nr./order-no.: P091559 - 10.06.2009  
 Anforderungen/requirements: F 02.15-20 Rev. 2  
 ASTM A 275 acc, ANSI B16.34 annex C / 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  
 Prüfergerät / test detector: Selbstdurchflutung / prod method  
 Prüfmittel / test medium: UW 600 Fa. Deutsch  
 Feldstärke / field strenght: HRS 9306 - fluoreszierend / fluorescent  
 Restmagnetismus/remainder-magnetism: > 2,5 kA/m  
 Betrachtungsbedingungen/observing conditions: < 800 A/m  
 Bestrahlungsstärke auf der Oberfläche/ray-treatment-strength on the surface: Hintergrundbeleuchtung/lighting-background < 20 lx  
 > 10 W/qm

| Pos./<br>item | Gegenstand/<br>Produkt  | Gesenk-Nr./<br>die-no. | Werkstoff/<br>material | Schmelze/<br>heat-no.            | Kennz./<br>marking:                |
|---------------|---|------------------------|------------------------|----------------------------------|------------------------------------|
| 3             | Gehäuse/bodies 20-25 MM PN 640<br>H 82.8600.000000<br>KB-Art.: 08647-A.2025.001<br><br>108 Stück/pieces<br><br>600 Stück/pieces<br><br>901 Stück/pieces | 8647                   | 1.0460<br>(S)A 105     | 452278<br><br>85651<br><br>87216 | XY 67<br><br>XY 678<br><br>XY 6789 |

Sachverständiger/Inspector:

Prüfaufsicht/examination supervisor:

Hersteller/manufacture:  MPE

Unterschrift/signature

Unterschrift/signature

Level II 