

T E S T C E R T I F I C A T E

According to EN10204 3.1

This certificate has been issued by a department independent of the Manufacturing Department and is validated by an authorized representative of the staff independent of the Manufacturing Department. All data contained herewith been obtained similar sources.

- # We hereby certify that the Equipment described below was manufactured and Tested for the stated cold working pressure.
- # Surface NDE has been carried out by ASNT Level II operator in accordance With ASTM E709 MPI and UT By ASTM A388 for ferromagnetic materials forging. Acceptance criteria in accordance with procedure no. WI/QA/36 (UT) And WI/QA/25 (MPI).
- The equipment has been manufactured in accordance with requirements of NACE MR 0175 for H2S service.

We hereby conclude that the equipment is fit for service and pressure as Indicated below.

ABCO Dispatch Ref. No. 3048

T.C. No. 3048-11/ Date - 14.02.2022

P.O. No. 004049

Description	Heat No.	Batch No.	Part No.	Assembly Sr. No.	Qty. (Nos.)	Material Grade
2" Fig 1502 Hammer Union Threaded, 15000 PSI CWP Std. service.				1 TO 30	30	
a.) 2" Fig 1502 Male Thread.	19M4130	QB2	1502MT0200			AISI 4130
b.) 2" Fig 1502 Female Thread.	19M4130	QB4	1502FT0200			AISI 4130
c.) 2" Fig 1502 Wing Nut.	12-11-03	B1	1502WN0200			AISI 4130

C h e m i c a l A n a l y s i s

Heat No.	Batch No.	C %	Mn %	Si %	P %	S %	Cr %	Ni %	Mo %	V %
19M4130	QB2	0.285	0.503	0.225	0.018	0.011	0.946	0.120	0.156	0.004
19M4130	QB4	0.285	0.503	0.225	0.018	0.011	0.946	0.120	0.156	0.004
12-11-03	B1	0.32	0.54	0.30	0.015	0.015	0.85	0.11	0.17	0.007

P h y s i c a l P r o p e r t i e s

Heat No.	Batch No.	Yield Strength (PSI)	Tensile Strength (PSI)	Elongation %	Red. Area %	Charpy 'V' Notch - 50°C (10X10mm)	Hardness HBW
19M4130	QB2	90636	102450	29.28	63.46	50, 46, 48 AV 48.00 J	219
19M4130	QB4	90834	102910	29.48	64.04	48, 42, 48 AV 46.00 J	215
12-11-03	B1	94886	107324	27.16	61.56	38, 42, 42 AV 40.67 J	229

Note - Specimen size 10x10 mm² below the surface for thickness up to 50 mm while at T/4" for greater thickness.

Heat Treatment -

- 1) **19M4130 QB2** - Normalized at 900°C for 2:30 hrs. Then air cool. Quenching in water. Temperature of water before quenching 29°C after quenching 38°C. Tempering in 660°C for 4 hrs. Then allow cooling up to room temperature.
- 2) **19M4130 QB4** - Normalized at 900°C for 2:30 hrs. Then air cool. Quenching in water. Temperature of water before Quenching 28°C after Quenching 37°C. Tempering in 660°C for 4 hrs. Then allow cooling up to room temperature.
- 3) **12-11-03 B1** - Normalized at 880°C for 2:40 hrs. Then air cool. Quenching in water. Temperature of water before Quenching 36°C after Quenching 43°C. Tempering in 680°C for 4 hrs. Then allow cooling up to room temperature.

Remarks : Stamping -

- 1) Male - ABCO 2 1502 15K CWP 19M4130 QB2 6325M-25 22.5K INDIA
- 2) Female - ABCO 2 1502 15K CWP 19M4130 QB4 6325N-25 22.5K INDIA
- 3) Wing Nut - ABCO 2 FIG 1502 15000 CWP 12-11-03 B1 6325O-25

(Sr. No. 1 TO 30)

Compiled By



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Signed By



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