

Date: 06/08/20
Time: 15.35.50

QUALITY CONTROL TEST REPORT

Berg Pipe Panama City Corp.
a Company of the Europipe Group
P.O. Box 59209
Panama City, FL 32412
TEL: (850)769-2273 FAX: (850)763-5778



Order: B40613
Item: 10

SUMMARY OF TESTING

CUSTOMER:
Vass Pipe & Steel
158 Third Street
Mineola, NY 11501

CUSTOMER ORDER NUMBER: 10121
MILL ORDER NO: B40613
SPECIFICATION: API5L 45th Jul 2013 & API5L 46th Nov 2018
SHIPMENT DATE: 06/08/2020 - 06/08/2020

CUSTOMER SPECIFICATIONS:

ITEM NO	QUANTITY	OD	WALL	GRADE SPECIFICATIONS	FOOTAGE
10	1	36.000"	.562"	5L X65M PSL2	39.8 ft

DESTRUCTIVE TESTING

TRANSVERSE TENSILE SPECIMEN	1T180	DESIGNATOR
TRANSVERSE WELD TENSILE SPECIMEN	1W	Strip Type per ASTM A370 Fig A2.5 (1.5")
LONGITUDINAL BODY TENSILE SPECIMEN	1L90	Strip Type per ASTM A370 Fig A2.5 (1.5")
GUIDED BENDS	2W	Strip Type per ASTM A370 Fig A2.5 (1.5")
BEND SPECIMEN		Bends were accepted in accordance with the applicable specification
CHARPY SPECIMEN		Per API 5L Fig.8 and ASTM A370 Fig. A2.13
CHARPY CRITERIA		Per ASTM A370 Fig. 11
	3T90	54 Ft-Lbs Min Avg Per Heat @ +32F Pipe Body
	3W	25 Ft-Lbs Min Avg Per Heat @ +32F Weld Centerline
	3HAZ	25 Ft-Lbs Min Avg Per Heat @ +32F HAZ
CHARPY ORIENTATION		Transverse
DWTT SPECIMEN	2T90	Per API RP 5L3
DWTT NOTCH		PRESSED
HARDNESS SCALE		VICKERS 10
HARDNESS INDENTOR		136-Degree Diamond Pyramid
HARDNESS LOAD		10 KG

NON-DESTRUCTIVE TESTING

RADIOGRAPHIC IQI:	Per API 5L Table E.3
WELD SEAM UT REFERENCE:	1/16" (1.6 mm) drilled hole and API N5 notches
PIPE BODY UT REFERENCE:	3" Area 5% wall reduction - 1/4" flat bottom hole
HYDRO PRESSURE:	2230 PSI
	HYDRO HOLD TIME: 10 sec

ADDITIONAL NOTES:

Thermo-mechanically control rolled with a max CE(PCM) of 0.20
Process of manufacture SAWL
Continuous cast, fully killed, calcium treated and made to a fine grain practice.
Melted and Manufactured in USA
Steel Making: ArcelorMittal (AMBH) Burns Harbor, IN
Plate Rolling: ArcelorMittal (AMBH) Burns Harbor, IN

Melted and Manufactured in the USA

We Certify that this report is correct as contained in the company records. Pipe were manufactured, tested and inspected in compliance with the latest edition of the applicable specifications.

6-8-2020

Manager of Quality Control:

Date:

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BERG PIPE

BILL OF LADING SUMMARY

CUSTOMER:
Vass Pipe & Steel

CUSTOMER ORDER NUMBER: 10121
MILL ORDER NO: B40613 ITEM: 10

SHIPPER NO:

153548

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HEAT NUMBER	OD	WALL	GRADE SPECIFICATIONS	STEEL MANUFACTURER
803L68940	36.000"	.562 "	5L X65M PSL2	MIT

CHEMICAL ANALYSIS

Test	Pipe	Location	C	Mn	P	S	Cb	V	Ti	N	Al	Si	Cr	Mo	Cu	Ni	B	Ce	Pcm	Ca
Ladle Results			.04	1.41	.013	.003	.056	.031	.011	.005	.029	.24	.030	.134	.167	.110	.0002	.332	.14	.0037
Product Results 1			.04	1.39	.012	.002	.056	.029	.011	.004	.029	.25	.030	.135	.170	.110	.0003	.329	.14	.0028
Product Results 2			.04	1.38	.012	.002	.055	.028	.011	.004	.029	.24	.030	.134	.168	.110	.0003	.327	.14	.0030

TENSILE TEST RESULTS

Test	Pipe	Location	Yield (ksi)	Tensile (ksi)	Y/T	Elong.(%)	Break Loc
011662 -1		Transverse Weld Tensile Test		87.9			H
011662 -1		Transverse Body Tensile Test	72.3	89.5	.81	34.4	

CHARPY TEST RESULTS

(If Shear Value is ***, Specimen did not Break)

Test	Pipe	Location	Temp	Size	Energy (ft-lbs)	Avg	Shear	Avg
011662 -1		Transverse Body Charpy Test	32 -F	FULL	226/231/265	241	100 /100 /100	100
011662 -1		Weld Centerline CVN Test	32 -F	FULL	96/ 95/ 90	94	48 / 52 / 40	47
011662 -1		Heat Affected Zone CVN Test	32 -F	FULL	206/194/194	198	100 /100 /100	100

DROP WEIGHT TEAR TEST RESULTS (FULL SIZE)

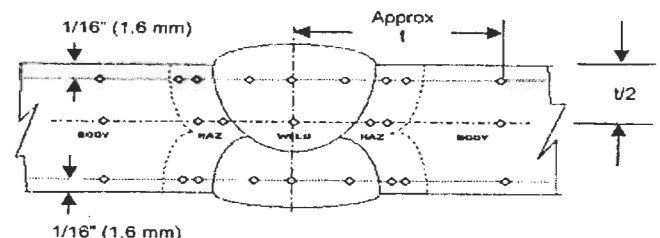
Test	Pipe	Location	Temp	Shear	Avg
011662 -1		Pipe Body DWT Tests	32 -F	100 /100	100

HARDNESS TEST RESULTS

Test Pipe: 011662 -1 Test# 1																	
1:	198	2:	222	3:	199	4:	211	5:	209	6:	214	7:	222	8:	210	9:	228
10:	197	11:	213	12:	224	13:	233	14:	193	15:	191	16:	223				

Readings 17 thru 25 continued on next page

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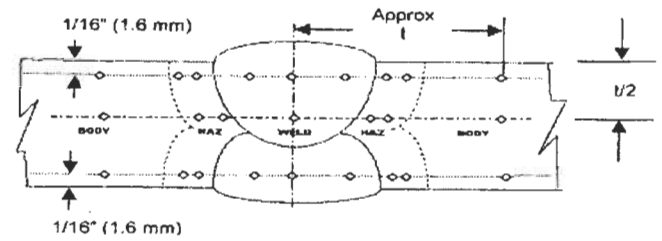
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HARDNESS TEST RESULTS

17: 200 18: 207 19: 208 20: 205 21: 201 22: 202 23: 198 24: 191 25: 214



PIPE CERTIFIED FOR HEAT: 803L68940

Pipe #	Weld Lot
011663 -5	W8297-0001