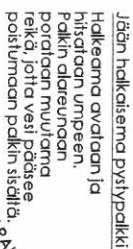




Reuna viistetään
tarvittaessa vastapuolen
saumojen väistämiseksi



Korjausrakentaja varmistaa korvauksen vapareijän mitoituksen ennen toiden aloittamista.



Notes	References
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INVESTING, TRADING, FINANCIAL

High School	Midlife
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Yleistöheränsä / General tolerances

SFS-EN 22700-1, SFS-EN ISO 13020

Massa / Mass

100

MILKROBYO / SCAL

A2 1:50

5

Libre

05

5

This Drawings including all the info he could modified detached etc

no copies, illustration, unaltered, with

6

9				10				11				12			
REVISIONS															
ZONE		DESCRIPTION				DATE				APPROVED					
02		PUMP&LIFT&T&B&T&B&T				2.10.2014				M. Johnson					

HITSAAJAN PÄTEVYYSTODISTUS

WELDER APPROVAL TEST CERTIFICATED, SFS-EN 287-1

Pöytäkirjan n:o/ Report n:o 103/13

KOKEEN MERKINTÄ/DESIGNATION:

EN 287-1 111 P FW 1.2 B t5 PD sl ml

HITSAAJA/ WELDER

Hitsaajan nimi: Welder name: Mikko Matias Kalliomäki	Työnantaja/ Employer Kimmometalli Oy
Tunnus Identification	Työnantajakokeen valvoja Juho Muhonen
Tunnistamistapa Method of identification: Ajokortti	Koekappaleen merkintä/ Mark of weld test Jmu
Syntymäaika ja -paikka Date and place of birth 12.03.1987 Seinäjoki	
Tietopuolinen koe/ Job knowledge: Hyväksytty/Acceptable Ei Testattu/ No tested	

VALMISTAJAN HITSAUSOHJE N:O/
MANUFACTURES WPS NO

OLEELLISET MUUTTUJAT/ ESSENTIAL VARIABLES	HITSAUSKOKEEN YKSITYSKOHDAT/ WELD TEST DETAILS	PÄTEVYYSAALUE/ RANGE OF APPROVAL
Hitsausprosessi Welding process	111	111
Levy tai putki Plate or pipe	P	P T : D≥150 mm
Liitosmuoto Joint type	BW	BW
Perusmetalliryhmä (t)/ Parent metal group (s)	1.2	1.1, 1.2, 1.4
Lisäainetyyppi ja merkintä/ Filler metal type/designation	B	kaikki paitis C
Suojakaasu/ Shieldin gases		
Apuaineet/ Auxiliary		
Aineen paksuus (mm)/ Test piece thickness (mm)	12	32
Putken ulkohalkaisija (mm)/ Pipe outside diameter (mm)		
Hitsausasento/ Welding position	PF	PA ja PF
Juuren avaus/juurituki/ Gouging/ backing	ss nb	ss nb, ss mb,bs

Lisätietoja lisälehdestä ja tai hitsausohjeesta nro/

Additional information is available on attached sheet and/or WPS No E2.1

Hitsauspaikka/ Welding site RAU Kimmo-Metalli	Päiväys/ Date 4.7.2013	Kokeen valvoja/ Examiner Juho Muhonen
TESTAUSMENETELMÄ/ TYPE OF TEST	SUORITETTU JA HYVÄKSYTTY/ PERFORMED AND ACCEPTABLE	Vaadittu/ Required
Silmämääräinen/ Visual	Hyväksytty Juho Muhonen	Kyllä
Radiografia/ Radiography	Hyväksytty 5.7.2013	Kyllä
Makrohe Macro		ei
Murtokoe/ Fracture		ei
Taivutuskoe/ Bend		Ei
Lisäkoeket ja standardit/ Additional tests and standards		

PÄTEVYYSKOKEEN HYVÄKSYNTÄ / APPROVAL OF QUALIFICATION Hyväksytty Hylätty

Todistuksen päiväys/ Date of issue 4.7.2013	Paikka/ Location Jyväskylä	Voimassa saakka/ Validity of approval until 4.7.2015
Kokeen valvojan nimi/ Examiner's name Juho Muhonen	Allekirjoitus/ Signature	Asema tai arvonimi Position or title IWT C15-345506

3.7.2014

28.6.2014

Timo Kautto

Timo Kautto

HITSAAJAN PÄTEVYYSTODISTUS

WELDER APPROVAL TEST CERTIFICATED, SFS-EN 287-1

Pöytäkirjan n:o/ Report n:o 102/13

Kokeen merkintä/DESIGNATION:

EN 287-1 111 P FW 1.2 B t5 PD sl ml

HITSAAJA/ WELDER

Hitsaajan nimi: Welder name: Esa Tapani Okker	Työnantaja/ Employer Kimmometalli Oy
Tunnus Identification	Työnantajakokeen valvoja Juho Muhonen
Tunnistamistapa Method of identification: Ajokortti	Koekappaleen merkintä/ Mark of weld test Jmu
Syntymäaika ja -paikka Date and place of birth 01.04.1984 Jyväskylä	
Tietopuolinen koe/ Job knowledge: Hyväksytty/Acceptable	Ei Testattu/ No tested

VALMISTAJAN HITSAUSOHJE N:O/
MANUFACTURES WPS NO

OLEELLISET MUUTTUJAT/ ESSENTIAL VARIABLES	HITSAUSKokeen YKSITYISKOHDAT/ WELD TEST DETAILS	Pätevyysalue/ RANGE OF APPROVAL
Hitsausprosessi Welding process	111	111
Levy tai putki Plate or pipe	P	P T :D≥150 mm
Liitosmuoto Joint type	FW	FW
Perusmetalliryhmä (t)/ Parent metal group (s)	1.2	1.1, 1.2, 1.4
Lisäainetyyppi ja merkintä/ Filler metal type/designation	B	kaikki paitis C
Suojakaasu/ Shieldin gases		
Apuaineet/ Auxiliary		
Aineen paksuus (mm)/ Test piece thickness (mm)	5	3-2
Putken ulkohalkaisija (mm)/ Pipe outside diameter (mm)		
Hitsausasento/ Welding position	PD	PA, PB, PC, PD, PE ja PF
Juuren avaus/juunituki/ Gouging/ backing	ml	sl ja ml

Lisätietoja lisälehdestä ja tai hitsausohjeesta nro/
Additional information is available on attached sheet and/or WPS No E2.1

Hitsauspaikka/ Welding site RAU Kimmo-Metalli	Päiväys/ Date 4.7.2013	Kokeen valvoja/ Examiner Juho Muhonen
TESTAUSMENETELMÄ/ TYPE OF TEST	SUORITETTU JA HYVÄKSYTTY/ PERFORMED AND ACCEPTABLE	Vaadittu/ Required
Silmämääräinen/ Visual	Hyväksytty Juho Muhonen	Kyllä
Radiografia/ Radiography		ei
Makrohe/ Macro		ei
Murtokoe/ Fracture	Hyväksytty Juho Muhonen	Kyllä
Taivutuskoe/ Bend		Ei
Lisäkoheet ja standardit/ Additional tests and standards		

PÄTEVYYSKokeen HYVÄKSYNTÄ / APPROVAL OF QUALIFICATION Hyväksytty Hylätty

Todistuksen päiväys/ Date of issue 4.7.2013	Paikka/ Location Jyväskylä	Voimassa saakka/ Validity of approval until 4.7.2015
Kokeen valvojan nimi/ Examiner's name Juho Muhonen	Allekirjoitus/ Signature	Asema tai arvonimi Position or title IWT C15-345506

3.7.2014

Timo Kautto

25.6.2014

Timo Kautto

EN 10204-3.1

Päivämäärä

16.01.2014

Sivu

1

Ostaja
ESKO LEPPINEN OY

8108200

Toimitusosoite
ESKO LEPPINEN OY

8108200

TERÄSTIE 2
61400 YLISTARO FINLAND

TERÄSTIE 2
61400 YLISTARO FINLAND

Tilausvahvistus

332340

Tilauksen

1/14

Viitteenne

Lähetys

332340-001 16.01.2014

MERKINTÄ

Valmistajan merkki

Tarkastajan leima

Teräslaji

Sulatus - koenro

Putkinumero

Muut leimat

RUUKKI



S355J2H

Tuote

KYLMÄMUOVATTUA HITSATTUA RAKENNEPUTKEA

Teräslaji

S355J2H, SI/B, -40 C

SEOSTAMATON RAKENNETERÄS EN 10219-1

Tekniset vaatimukset

EN 10219-1,2:2006 CFRHS

Ainettarikkomaton tarkastus

PYÖRREVIRTATARKASTETTU EN 10246-3

CE
0416

RUUKKI

Ruukki Metals Oy PL 138 FI-00811 Helsinki

0416-CPD-6566

EN 10219 - 1: 2006

Teräsrakentamisessa käytettävä
kylmämuovattu teräsrakenneputki

S355J2H

Vaarallinen aine X: pitoisuus alle 0,2 ppm
Pitkäaikaiskestävyys: NPD

Vaatimustenmukaisuus vakuutus
EN 10219-1 liitteen ZA mukaan,
katso: www.ruukki.com

TUOTE-ERITTELY

Sulatusnro	Näyttenro	Nippu nro	Kpl	m	kg	Nippua
Pos. 1	50 X 50	3.00 X 6000				
79208	9680940	40339336-40339340				
POSITIO YHTEENSÄ			200	1200	5100	5
Pos. 4	60 X 60	4.00 X 12000				
80384	9676090	40339936-40339939				
POSITIO YHTEENSÄ			120	1440	9664	4
Pos. 6	60 X 60	5.00 X 12000				
80386	9676010	40340000-40340002 40340004				
80386	9676020	40339996 40339998 40340000				
POSITIO YHTEENSÄ			180	2160	17562	6
POSITIOT YHTEENSÄ			500	4800	32326	15

Tuotteet on tarkastettu ja testattu ylläesitettyjen toimitusehtojen mukaisesti ja ne ovat asetettujen vaatimusten mukaisia.

RUUKKI METALS OY

Hämeenlinnan putkitehdas
Laadunohjaus

Teemu Toivanen
Teemu Toivanen

www.ruukki.com
Ruukki Metals Oy

Postiosoite

FI-13300 HÄMEENLINNA

Puhelin

+ 358 20 59 11

Telefax

+ 358 20 59 25546

Yhtiön nimi

Ruukki Metals Oy

Suolakivenkatu 1

FI-00811 HELSINKI

Kotipaikka

HELSINKI

Y-tunnus

2389445-7

EN 10204-3.1

Päivämäärä
16.01.2014

Sivu
2

Pos.	Sulatusnro	CEV	Sulatusanalyysi %														
			C	Si	Mn	P	S	Al	Nb	V	Cu	Cr	N	Ti	Mo	Ni	B
1	79208	,33	,08	,17	1,42	,013	,008	,037	,014	,009	,019	0,05	,006	,014	,00	,04	,0002
4	80384	,35	,08	,17	1,51	,012	,007	,032	,014	,012	,020	0,04	,004	,015	,01	,04	,0002
6	80386	,34	,08	,18	1,43	,011	,004	,033	,014	,009	,029	0,05	,005	,016	,01	,04	,0004

Pos.	Näytenumero	Vetokoe				Isukoe					
		P2	RP0.2	Rm	A5	P3	oC	1	2	3	AVG
			N/mm2	N/mm2	%			J	J	J	J
1	9680940	13	487	537	25						
4	9676090	13	500	548	20						
6	9676010	13	522	564	19						
6	9676020	13	520	558	19						

Visuaalinen tarkastus sekä mittatarkastus on suoritettu toimitusehtojen mukaisesti- Ei huomioita

RUUKKI METALS OY
Hämeenlinnan putkitehdas
Laadunohjaus

Teemu Toivanen
Teemu Toivanen

CEV: $C + Mn/6 + (Cr+Mo+V)/5 + (Ni+Cu)/15$
P2: 13=Putkisauva, pitkittäissuuntaan; Ra = pinnankarheus



TATA STEEL UK LIMITED
P.O. Box 1, Brigg Road,
Scunthorpe,
North Lincolnshire, DN16 1BP.
Telephone: 01724 404040
Fax: 402353 Telex: 52601

A01

INSPECTION CERTIFICATE

A02

In Accordance with EN10204 3.1
Product manufactured under a Management System approved to ISO 9001

Customer	A06		A08		A07		A08		A07	
	OY LEPPINEN STEEL LTD		TERASTIE 2 FIN-61400		YLISTARO		YLISTARO FINLAND		B01/B02	
	Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		B09-B12	
	CSI:2864053		Customers Order No.		60839/ 5		Works Order/Item No.		55/ 282/ 2	
Specification/Product		EN10025-2:2004 S355K2+N		TL-701/14		A07		A07		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
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Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
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Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
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Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
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Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		
Inspection		WORKS INSPECTION		All		"N"- Normalised Rolled.		B09-B12		
Inspection		WORKS INSPECTION		All		Plates 6000 X 2000 X 12.00mm		Piece Weight 1130.4Kg		

CE

B06/A10 SP OY LEPPINEN/TL-701/14/ PPU60839/VAASA/ EN10025-2:2004 S355K2+N

L=Longitudinal		T=Transverse		Z=Through Thickness		S=Sub-Surface		M=Mid-Thickness		Q=Quarter-Thickness		C40 Steelmaking Process:												ANALYSIS %												C70																																																																																																																																																																																																																																																																																																																																																																																																																																																																										
Quantity	Cast/Heat No.	B07	C02	C11	C12	C14	C13	C01	Yield Stress Re	Tensile Strength Rm	Elongation Re A5.65/ Lo = 5.65	C10	C09	C08	C07	C06	C05	C04	C03	C02	C01	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00	C00