






 COPROSIDER SRL COMPANY WITH QUALITY MANAGEMENT SYSTEM CERTIFIED BY ISO 9001:2015 = CERT NR. 220827 		NORSOK M-650 Qualification Test Record (QTR) ISO 17782:2018 Manufacturing procedure conformity record (MPCR)		QTR/MPCR No.: 17782-02/A Rev. No.: 1 Page #: 1 of 1
Manufacturer name / address / Plant Web page:	COPROSIDER SRL VIA CASSOLI 7, 29122 PIACENZA - ITALY CFF srl / COPROSIDER division, Via perotti 2/4/6/8 29015 Castel San Giovanni (PC) www.coprosider.it			
Reference standard	NORSOK M-650 ed 4 / ISO 17782:2018			
Material designation and MDS No.:	Wrought fittings ASTM A815 UNS S32750 NORSOK M630:2020 MDS D53 rev. 6			
Manufacturing procedure summary doc. No.:	<i>Route #</i>	<i>Manufacturing procedure summary #</i>	<i>Rev #</i>	
	01	MPS 17782-02-01	0	
	02	MPS 17782-02-02	0	
	03	MPS 17782-02-08	0	
	04	MPS 17782-02-09	0	
Products and manufacturing process(es):	<i>Route #</i>	<i>Description</i>		
	01	Cold formed seamless LR & SR elbows		
	02	Cold formed seamless equal and reducing tee		
	03	Hot formed seamless LR & SR elbows		
	04	Hot formed seamless equal and reducing tee		
Mandatory conditions and sub-contractors:	Furnace F2 (located in Coprosider, div CFF Srl) to be used for all routes, furnace details included in the heat treatment procedure PR 467 rev. 0 Soaking time is measured on the basis of mobile thermocouples Any revision of heat treatment procedure, raw material suppliers and sketches for testes shall be evaluated by the qualifying company whom accepted this QTR/MPCR for evaluation on possible new testing			
Other information:	External laboratories LPM Snc accredit ISO 17025:2005 nr 1598L For sampling sketches for regular production and qualification testing see attached sampling test report and MS/MPs sequence Audit for verification of satisfactory heat treatment procedure No. PR 467-V rev. 0 and 467-Q rev. 0 of Furnace F2 completed in December 2020 by qualifying company LLRR The Concentric and eccentric reducers and ellipsoidal caps are qualified through the qualification of tee piece. The elbows SR and R=3D/5D are qualified through the qualification of LR elbow			
Tested and Qualified Thickness				
Products and manufacturing process(es):	Test record No.	Tested thickness mm	Qualified thickness mm	Prototype - Test pieces description
Route 01	ELB-4-17782-2	17.12	21.40	90° LR Elbows 4" W.th. 17,12 mm
Route 02	TEE-6-17782-2	14.27	17.84	Equal Tee 6" W.Th. 14,27 mm
Route 03	ELB-6-17782-2	21.95	27.44	90° LR Elbows 6" W.th. 21,95 mm
Route 04	TEE-8-17782-2/B	23.01	28.76	Equal Tee 8" W.Th. 23,01 mm
Qualification / Acceptance signatures				
Manufacturer:	Prepared by / Date:	Checked by / Date:		
	A.SPERONI 18/03/2021	A.GROPPI 18/03/2021		
The manufacturer and this QTR/MPCR are evaluated and found to be in compliance with the requirements of NORSOK M-650 & ISO 17782 for supply of the above listed products and materials. This acceptance does not exempt any purchaser from his responsibility to ensure that this qualification is valid for his products within the essential variables of NORSOK M-650 & ISO 17782				
Qualified / Accepted by (company name / address):		Signature / Date:		
LR reference Number: 626/20 ByD-Address number: 580168 issuing LR office: Lloyd's register EMEA Milan office Viale Monza, 265 - 20126 Milano MI		22/12/2020 Rev. 0 18/03/2021 Rev. 1 		
		Lloyd's Register EMEA A member of the Lloyd's Register group <input type="checkbox"/> Witnessed <input type="checkbox"/> Monitored <input checked="" type="checkbox"/> Reviewed Mauro Franciosi Viareggio Office		

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Reference standard	NORSOK M-650 ed 4 / ISO 17782:2018			
Material designation and MDS No.:	Wrought welded fittings ASTM A815 UNS S32750 NORSOK M630:2020 MDS D53 rev. 6			
Manufacturing procedure summary doc. No.:	Route #	Manufacturing procedure summary #		Rev #
	05	MPS 17782-02-05		0
	06	MPS 17782-02-06		0
	07	MPS 17782-02-12		0
	08	MPS 17782-02-13		0
Products and manufacturing process(es):	Route #	Description		
	05	Cold formed welded LR & SR elbows		
	06	Cold formed welded equal and reducing tee		
	07	Hot formed welded LR & SR elbows		
	08	Hot formed welded equal and reducing tee		
Mandatory conditions and sub-contractors:	Furnace F2 (located in Coprosider, div CFF Srl) to be used for all routes, furnace details included in the heat treatment procedure PR 467 rev. 0 Soaking time is measured on the basis of mobile thermocouples Any revision of heat treatment procedure, raw material suppliers and sketches for testes shall be evaluated by the qualifying company whom accepted this QTR/MPCR for evaluation on possible new testing			
Other information:	External laboratories LPM Snc accredit ISO 17025:2005 nr 1598L For sampling sketches for regular production and qualification testing see attached sampling test report and MS/MPS sequence Audit for verification of satisfactory heat treatment procedure No. PR 467-V rev. 0 and 467-Q rev. 0 of Furnace F2 completed in December 2020 by qualifying company LLRR Sub contracted activities : X-Ray examination shall be performed by in EMILTEST Srl The Concentric and eccentric reducers are qualified through the qualification of tee piece. The elbows SR and R=3D/5D are qualified through the qualification of LR elbow			
Tested and Qualified Thickness				
Products and manufacturing process(es):	Test record No.	Tested thickness mm	Qualified thickness mm	Prototype - Test pieces description
Route 05	ELB-8-17782-2	12.70	15.88	90° LR Elbows 8" W.th. 12,70 mm
Route 06	TEE-8-17782-2	12.70	15.88	Equal Tee 8" W.Th. 12,70 mm
Route 07	ELB-14-17782-2	27.79	34.74	45° LR Elbows 14" W.th. 27,29 mm
Route 08	TEE-16-17782-2	28.58	35.73	Red Tee 16" x 6" W.Th. 28,58 x 14,27 mm
Qualification / Acceptance signatures				
Manufacturer:	Prepared by / Date:	Checked by / Date:		
	A.SPERONI 18/03/2021	A.GROPPI 18/03/2021		
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Qualified / Accepted by (company name / address):  Lloyd's Register LR reference Number: 626/20 ByD-Address number: 580168 issuing LR office: Lloyd's register EMEA Milan office Viale Monza, 265 - 20126 Milano MI	Signature / Date: 22/12/2020 Rev. 0 Lloyd's Register EMEA 18/03/2021 Rev. 1 A member of the Lloyd's Register group <input type="checkbox"/> Witnessed <input type="checkbox"/> Monitored <input checked="" type="checkbox"/> Reviewed Mauro Franciosi Viareggio Office			