



Ghatage Patil Industries Limited

Uchgaon, Tal -Karveer, Dist Kolhapur Maharashtra Pin - 416005

(EN 10204-3.1)

CERTIFICATE OF COMPLIANCE

VALVE SR.NO

:

132604

GHATAGE PATIL INDUSTRIES LTD. - VALVE DIVISION - UCHGAON,KOLHAPUR,MAHARASHTRA,INDIA - CERTIFIES THAT THE PRODUCT

VALVE TYPE : 3.1/8 5M THD 3.1/2EU DD GTV ASSLY
CUSTOMER PART NO. : 110032-L32144-AC0500-00000-A
SERIAL NO. : 132604
PURCHASE ORDER NO. : 0001462 - 1 TO 3 , Dated Jan .15, 2012
BUYER : OMNI VALVE

are manufactured and comply the technical specification

API 6A 20TH EDITION,OCTOBER 2010.

DRAWING NO. : 94531720

The Product Confirms to the following Requirements:

MATERIAL CLASS	DD-NL
MAX HARDNESS	235 HBW
PR	2
PSL	1
TEMP CLASS	L/U
BODY	ASTM A487-4C API 6A 60K
BONNET	AISI 4130 - 60K
STEM	AISI 4130 6A-75K (NITRIDED)
GATE MAJOR	AISI 4130 6A-75K (NITRIDED)
GATE MINOR	AISI 4130 6A-75K (NITRIDED)
SEAT	AISI 4130 6A-75K (NITRIDED)
FASTENER (STUD)	ASTM A320 GR.L7M IMPACT AT -72 DEG.C

MONTH OF MANUFACTURING : April 2012

DGM (QA)



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CERTIFICATE OF PRESSURE TEST		VALVE SR.NO. : 132604		
TYPE OF VALVE	6A GATE VALVE			
MATERIAL CLASS	MAX HARDNESS	PR	PSL	TEMP CLASS
DD-NL	235 HBW	2	1	L/U
BODY, BONNET, EXPANDING GATE, NON RISING STEM.				
TEST	PRESSURE HOLDING PERIOD	TEST PARAMETERS MINIMUM		TEST RESULTS
		PRESSURE (PSI)	DURATION (Min)	
HYDROSTATIC BODY TEST	Primary	7500	3	NO VISIBLE LEAKAGE UNDER TEST PRESSURE HOLD PERIOD
HYDROSTATIC BODY TEST.	Secondary	7500	3	NO VISIBLE LEAKAGE UNDER TEST PRESSURE HOLD PERIOD
HYDROSTATIC SEAT TEST..	Primary	5000	3	NO VISIBLE LEAKAGE UNDER TEST PRESSURE HOLD PERIOD
HYDROSTATIC SEAT TEST.	Secondary	5000	3	NO VISIBLE LEAKAGE UNDER TEST PRESSURE HOLD PERIOD
Pressure Test Methods	: AS PER ISO:10423:2009:MOD,& API 6A 20TH EDITION OCTOBER 2010			
Testing Fluid	: WATER WITH EMULSIFIED CUTTING OIL AS RUST PREVENTIVE.			
DRIFT TEST	The Drift mandrell pass through the valve bore .	Yes	No	
		X		



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HEAT CODE OF VALVE PARTS

BODY	BONNET	STEM	GATE MAJOR	GATE MINOR	SEAT	FASTENER (STUD)
D11J100	MN64	F134	E17AEC	E1LAEC	110B	DT-BS-2

CHEMICAL COMPOSITION (%)

HEATCD	MATERIAL	C %	Si %	Mn %	S %	P %	Cr %	Ni %	Mo %	Cu %	V %
D11J100	ASTM A487-4C API 6A 60K	0.210	0.400	0.810	0.010	0.025	0.640	0.580	0.190	0.037	0.011
MN64	AISI 4130 - 60K	0.330	0.200	0.530	0.018	0.025	0.920	0.150	0.150	-	-
F134	AISI 4130 6A-75K (NITRIDED)	0.310	0.200	0.450	0.005	0.014	0.960	0.040	0.170	-	-
E17AEC	AISI 4130 6A-75K (NITRIDED)	0.310	0.220	0.500	0.010	0.013	1.040	-	0.220	-	-
E1LAEC	AISI 4130 6A-75K (NITRIDED)	0.310	0.220	0.500	0.010	0.013	1.040	-	0.220	-	-
110B	AISI 4130 6A-75K (NITRIDED)	0.310	0.230	0.520	0.012	0.014	0.960	0.210	0.200	-	-
DT-BS-2	ASTM A320 GR.L7M IMPACT AT -72 DEG.C	0.410	0.210	0.820	0.039	0.027	0.900	-	0.150	-	-

MECHANICAL CHARACTERISTICS

HEATCD	MATERIAL	PART	YIELD PSI	TENSILE PSI	ELONG %	REDU %	QTC HARDNESS HBW	IMPACT (J) VALUE 1	IMPACT (J) VALUE 2	IMPACT (J) VALUE 3
D11J100	ASTM A487-4C API 6A 60K	BODY	75597.000	97695.000	22.600	55.560	213.000	45.000	55.000	48.000
MN64	AISI 4130 - 60K	BONNET	89763.000	102047.000	21.500	63.030	229.000	134.000	138.000	144.000
F134	AISI 4130 6A-75K (NITRIDED)	STEM	111099.000	122794.000	19.400	61.680	215.000	38.000	72.000	90.000
E17AEC	AISI 4130 6A-75K (NITRIDED)	GATE MAJOR	85136.000	106670.000	25.490	67.920	229.000	35.000	45.000	52.000
E1LAEC	AISI 4130 6A-75K (NITRIDED)	GATE MINOR	85136.000	106670.000	25.490	67.920	229.000	35.000	45.000	52.000
110B	AISI 4130 6A-75K (NITRIDED)	SEAT	98840.000	117803.000	20.460	63.620	230.000	78.000	75.000	70.000
DT-BS-2	ASTM A320 GR.L7M IMPACT AT -72 DEG.C	FASTENER (STUD)	91796.000	103416.000	20.800	64.650	222.000	60.000	78.000	72.000

The above values are conforming and complies with the terms of order and the specifications.

MATERIAL CERTIFICATE

VALVE SR.NO.

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H.T PERFORMED IN ACCORDING WITH ROUTING SHEET	HEATING TEMP. (DEG.C)		HOLDING PERIOD. (Min.)		TYPE	QUENCH BATH TEMP Deg.C		
	SET	EFFECTIVE	SET	EFFECTIVE		BEFORE	AFTER	
NORMALISING	925 +/-	5	920	3 Hrs.	3 Hrs.	Air	-	-
QUENCHING	875 +/-	5	880	3 Hrs.	3 Hrs.	Water	35	45
TEMPERING	675 +/-	5	680	3 Hrs.	3 Hrs.	Air	-	-

Shelf life of Elastomer is five years when stored properly