

Inspection Body:	Bureau Veritas	Regulation/Standards covered:	PED+EN12257 (2002)
Heat Treatment:	Quenched and tempered	Nominal outside diameter (mm):	139
Drawing No.:	HPC04100REV1	Guaranteed minimum thickness of cylindrical shell (mm):	2,1
Test Pressure (bar):	225	Guaranteed minimum base thickness (mm):	
		Shape of Base:	convexe

Remarks: -

Line	Orders covered
CP	Y4123910

Steel Analysis

Cast No (internal)	Steel makers heat no.	C	Si	Mn	P	S	Al	Cr	Cu	Mo	Ni	V+Nb+Ti+B+Zr	P+S
LT22	1023468976	0,3267	0,2534	0,7075	0,0063	0,0026	0,0283	0,9828	0,0136	0,23	0,2076	0,0079	0,0089

Tensile Test
Requirements

Min. Yield Strength - Reg (MPa): 990 Min. Tensile Strength - Rm (MPa): 1100 Max. Tensile Strength (MPa): 1220

Min. Elongation (%): 12,0

Max. Rea/Rma: -

Results of Tensile Test

Sample No	Cast No (internal)	Thickness (mm)	Width (mm)	Yield Strength, Rea (MPa)	Tensile Strength, Rma (MPa)	Rea/Rma	Lo (mm)	Lu (mm)	Elongation (%)	Reduction of Area (%)	Brinell Hardn
8045M	LT22	2,4	4,9	1155	1155	1,00	19,5	22,1	13,4	-	-

Bend Test (acc. to EURONORM 65-55/ISO 7438)
Requirements

Factor for Diameter of Mandrel: 8 Angle (°): 180

Results

Sample No	Cast No (internal)	Wall Thickness (mm)	Width of Sample (mm)	Diameter of Mandrel (mm)	Result	Remarks
8045M	LT22	2,4	25	16	Passed	-

Burst Test
Requirements

Min. Yieldpressure (bar): - Min. Burstpressure (bar): 382,5

Max. Sidebranching (mm): 145 Max. Pressure increase rate (bar/s): 5

Results

Sample No	Cast No (internal)	Yield Pressure (bar)	Burst Pressure (bar)	Pressure Increase (bar/s)	Side-branching left upper end (mm)	Side-branching right upper end (mm)	Side-branching left lower end (mm)	Side-branching right lower end (mm)	Width of burst fracture (mm)	Length of burst fracture (mm)	Distance of Lower end of fracture to ground (mm)	Min. wall thickness (mm)	Min. base thickness (mm)	No. of Pieces
8045B	LT22	412	464	3,74	0	0	0	0	-	-	-	2,6	9,8	1

Burst Test - Composite Cylinder

Requirements

Min Burstpressure (bar): 751,5

Results

Sample No/Cast No's	Burst Pressure (bar)	Min. Wrap. Thickn (mm)	Max Wrap. Thickn. (mm)	Remark
8046T2 BC CP255	892	1,5	1,6	-

Cycle Test - Composite Cylinder

Results

Sample No/Cast No's	Upper Pressure (bar)	Lower Pressure (bar)	Cycle Freq. (1/min)	Cyl. Temp (°C)	Min Wrap Thickn. (mm)	Max Wrap Thickn. (mm)	Vol before	Vol after	Required No of Cycles	Actual No of Cycles
8047T2 PC CP255	450	30	10	23	1,5	1,6	6,8	6,8	12000	12001