



	Qualification Test Record (QTR) NORSOK M-650				QTR. No.: QTR-OMBA-F53	
					Rev. No.: 4	
Manufacturer name/address/ Web page:	Ire-Omba S.p.A. Via C. Serassi, 14 – Bergamo Via Cà Bertoncina, 12 – Seriate		For forging and Heat treatment For forging			
Reference standard	NORSOK M-650, Edition 4					
Material designation and MDS No.:	ASTM A182 Gr. F53; MDS D54 Rev. 6					
Manufacturing Summary doc. No.:	MS-01 F53			Rev. No.: 2		
Products and manufacturing process(es):	Products: Rolled rings Manufacturing process: hot forging – press forging and final ring rolling					
Mandatory conditions and sub-contractors:	Heat treatment by: Ire-Omba S.p.A. - Bergamo plant – Furnace n° 1 and 5 Steelmakers: Cogne Acciai Speciali SpA – Italfond SpA - Outokumpu Stainless AB Test laboratory: AQM Srl, Cpm Apave Italia Srl or IRElab (internal Ire-Omba SpA lab.)					
Other information:	MOM 08.11.2021 (Pibiviesse – Ire-Omba) & MOM 19.11.2021 (Pibiviesse – Ire-Omba) Verification of heat treatment procedure using furnace n°1 performed on 11.04.2016 Verification of heat treatment procedure using furnace n°5 performed on 15.11.2016 PT and pickling to be performed by Equipment customer.					
Qualification expires:	November 2026					
Tested and qualified thickness and weight						
Products and manufacturing process(es):	Test record No.	Tested thickness mm	Qualified thickness mm	Test piece weight kg	Qualified weight kg	
Rolled rings	83771	110	110	235	470	
Qualification/acceptance signatures						
Manufacturer: IRE-OMBA S.p.A.	Prepared by/Date: Marco Zanetti (UT) 19.11.2021 		Checked by/Date: Alessandra Lissignoli (RCQ) 19.11.2021 			
The manufacturer and this QTR are evaluated and found to be in compliance with the requirements of NORSOK M-650 for supply of the above listed products and materials. <i>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.</i>						
Qualified/Accepted by (company name /address): 			Signature/Date:  Corrado Annovazzi Operations Director 19.11.2021			