

	Qualification Test Record (QTR) NORSOK M-650		QTR. No.: QTR-OMBA-55_DH54		
			Rev. No.: 0		
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 F55; MDS DH54 Rev.1				
Manufacturing Summary doc. No.:	MS-01 F55_DH54			Rev. No.: 0	
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: IRElab (internal Ire-Omba SpA laboratory), Cpm Apave Italia Srl or any 17025 accredited laboratory				
Other information:	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 15.11.2021 PT to be performed by Equipment customer.				
Qualification expires:	July 2027 (Five years from the date of QTR approval)				
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	145588	95	95	399	All
Qualification/acceptance signatures					
Manufacturer: IRE-OMBA S.p.A.	Prepared by/Date: Marco Zanetti (UT) 13.07.2022 <i>Zanetti Marco</i>		Checked by/Date: Alessandra Lissignoli (RCQ) 13.07.2022 <i>Alessandra Lissignoli</i>		
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: Castelli Davide (WME) 17/01/2023 <i>Castelli Davide</i>		

