









	QTR Qualification Test Record NORSOK M-650	QTR. No.: 6MO/2016
	Rev. No.:2	
Manufacturer name/address/ Web page:	ALLIED INTERNATIONAL Group Srl Loc. Vascellino, 29010 – Nibbiano Val Tidone (PC), Italy www.alliedfittings.com Plants: Tectubi Raccordi Via Roma, 150, Podenzano (PC)  Tectubi Raccordi Via Galileo Galilei, Castel S.Giovanni(PC)  Tectubi Raccordi Via Ancona, 27Calendasco (PC)  Raccordi Forgiati Loc. La Casetta , Nibbiano (PC) 	
Reference standard	NORSOK M-650 Ed.4	
Material designation and MDS No.:	WROUGHT FITTINGS TO ASTM A403 UNS S31254 (SEAM. & WLD) – MDS R13 Rev.6	
Manufacturing summary doc. No.:	MS013 _ RACCORDI FORGIATI SRL NIBBIANO MS014 _ TECTUBI RACCORDI SpA PODENZANO MS015 _ TECTUBI RACCORDI SpA C.S.GIOVANNI MS016 _ TECTUBI RACCORDI SpA CALENDASCO	Rev. No.: 2
Products and manufacturing process:	<p><u>Manufacturing routes 013A up to 013F (Raccordi Forgiati):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows.</p> <p><u>Manufacturing routes 014A up to 014L(Tectubi Raccordi Podenzano):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows, elbows in two halves; seamless cold formed tees, welded cold formed tees.</p> <p><u>Manufacturing routes 015A up to 015H(Tectubi Raccordi Castel S.Giovanni):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows, elbows in two halves</p> <p><u>Manufacturing routes 016A up to 016B (Tectubi Raccordi Calendasco):</u> Seamless and welded cold formed elbows</p>	
Mandatory conditions and sub-contractors:	Welding carried out by: Podenzano Plant Heat Treatment Procedure: PR048 External laboratory: LPM (Gagnano) & SIDERTEST (C.S.Giovanni) , maybe used for NDE.	
Other information:	Qualification extension: the qualification of welded tees qualifies all the other pieces (elbows, caps, reducers) in seamless execution as approved by the Qualifying Company (SFF). Heat treatment verification performed by GL (Germanischer LLOYD) on behalf of SFF; see inspection report No 01 Rev.1	

Qualification expires:	16.12.2026				
Tested and Qualified Thickness and Weight					
Products and manufacturing process:	Test record No.	Tested thickness (mm)	Qualified thickness (mm)	Plant	Raw material supplier
B.W. Welded Tees 16" x 8" wth. 32/ 20 From Plates (Hot forming method)	CERT.16-00076	32 mm	up to 40 mm	Raccordi Forgiati (Nibbiano)	Bohler
B.W. Welded Tees 16" x 8" wth. 32/ 20 From Plates (Hot forming method)	CERT.16-00077	32 mm	up to 40 mm	Tectubi Raccordi C.S.Giovanni	Bohler
B.W. Welded Tees 16" x 8" wth. 32/ 20 From Plates (Hot forming method)	CERT.16-00078	32 mm	up to 40 mm	Tectubi Raccordi Podenzano	Bohler
Welded elbow LR 45° 16" wth.13mm	CERT.16-00079	13 mm	up to 16,25 mm	Tectubi Raccordi Calendasco	Bohler
Qualification/Acceptance signatures					
Manufacturer:	Prepared by/Date: P. Aradelli <i>[Signature]</i> 09/08/2021	Checked by/Date: L. Zacconi <i>[Signature]</i> 09/08/2021 RACCORDI S.p.A. QA MANAGER EN ISO 9712 Level 2 PT-MT-UT-VT 09/08/2021			
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. 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.					
Qualified/Accepted by (company name/address): SFF Scandinavian Fittings & Flanges			Signature/Date: <i>[Signature]</i> 16.12.2021		

REV.1 : typing mistake amended in tested and qualified thickness section; modified "other information" paragraph.






REV.2 : Re-qualification to Norsok M-650 Ed.4 / ISO 17782:2018

	QTR Qualification Test Record NORSOK M-650	QTR. No.: 803/2016 Rev. No.: 2
Manufacturer name/address/ Web page:	ALLIED INTERNATIONAL Group Srl Loc. Vascellino, 29010 – Nibbiano Val Tidone (PC), Italy www.alliedfittings.com Plants: Tectubi Raccordi Via Roma, 150, Podenzano (PC)  Tectubi Raccordi Via Galileo Galilei, Castel S.Giovanni(PC)  Tectubi Raccordi Via Ancona, 27Calendasco (PC)  Raccordi Forgiati Loc. La Casetta , Nibbiano (PC) 	
Reference standard	NORSOK M-650 Ed.4 / ISO 17782-2018 / ISO 17781 2018	
Material designation and MDS No.:	WROUGHT FITTINGS TO ASTM A815 UNS S31803 (SEAM. & WLD) – MDS D43 Rev.6	
Manufacturing summary doc. No.:	MS001 _ RACCORDI FORGIATI SRL NIBBIANO MS002 _TECTUBI RACCORDI SpA PODENZANO MS003 _TECTUBI RACCORDI SpA C.S.GIOVANNI MS004 _TECTUBI RACCORDI SpA CALENDASCO	Rev. No.: 2
Products and manufacturing process:	<p><u>Manufacturing routes 001A up to 001G (Raccordi Forgiati):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows.</p> <p><u>Manufacturing routes 002A up to 002L(Tectubi Raccordi Podenzano):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows, elbows in two halves; seamless cold formed tees, welded cold formed tees.</p> <p><u>Manufacturing routes 003A up to 003H(Tectubi Raccordi Castel S.Giovanni):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows, elbows in two halves</p> <p><u>Manufacturing routes 004A up to 004B (Tectubi Raccordi Calendasco):</u> Seamless and welded cold formed elbows</p>	
Mandatory conditions and sub-contractors:	Welding carried out by: Podenzano Plant Heat Treatment Procedure: PR048 External laboratory: LP (Gagnano); SIDERTEST (C.S.Giovanni) , maybe used for NDE.	
Other information:	Qualification extension: the qualification of welded tees qualifies all the other pieces (elbows, caps, reducers) in seamless execution as approved by the Qualifying Company (SFF). Heat treatment verification performed by GL (Germanischer LLOYD) on behalf of SFF; see inspection report No 01 Rev.1	

Qualification expires:	16.12.2026				
Tested and Qualified Thickness and Weight					
Products and manufacturing process:	Test record No.	Tested thickness (mm)	Qualified thickness (mm)	Plant	Raw material supplier
B.W. Welded Tees 16" x 8" wth. 48/ 48 From Plates (Hot forming method)	CERT.16-00068	48 mm	up to 60 mm	Raccordi Forgiati (Nibbiano)	Arcelor Mittal
B.W. Welded Tees 16" x 8" wth. 48/ 48 From Plates (Hot forming method)	CERT.16-00069	48 mm	up to 60 mm	Tectubi Raccordi C.S.Giovanni	Arcelor Mittal
B.W. Welded Tees 16" x 8" wth. 48/ 48 From Plates (Hot forming method)	CERT.16-00070	48 mm	up to 60 mm	Tectubi Raccordi Podenzano	Arcelor Mittal
Welded elbow LR 45° 16" wth.20mm	CERT.16-00071	20 mm	up to 25 mm	Tectubi Raccordi Calendasco	Outokumpu
Qualification/Acceptance signatures					
Manufacturer:	Prepared by/Date: P. Aradelli <i>[Signature]</i> 10/08/2021	Checked by/Date: L. Zacconi <i>[Signature]</i> 16/08/2021 Loretta Zacconi RACCORDI FORGIATI QA MANAGER EN ISO 9001 Level 2 PT-MT-UT-VT SNT-PT-UT-VT II PT-MT-UT-VT			
<p>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.</p> <p>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.</p>					
Qualified/Accepted by (company name/address):			Signature/Date:		
 Scandinavian Fittings & Flanges			<i>[Signature]</i> 16.12.2021		

REV.1 : typing mistake amended in tested and qualified thickness section; modified "other information" paragraph.






REV.2 : Re-qualification to Norsok M-650 Ed.4 / ISO 17782:2018 / ISO 17781:2018





	QTR Qualification Test Record NORSOK M-650		QTR. No.: 750/2016
Manufacturer name/address/ Web page:	ALLIED INTERNATIONAL Group Srl Loc. Vascellino, 29010 – Nibbiano Val Tidone (PC), Italy www.alliedfittings.com Plants: Tectubi Raccordi Via Roma, 150, Podenzano (PC)  Tectubi Raccordi Via Galileo Galilei, Castel S. Giovanni(PC)  Tectubi Raccordi Via Ancona, 27Calendasco (PC)  Raccordi Forgiati Loc. La Casetta , Nibbiano (PC) 		
Reference standard	NORSOK M-650 Ed.4/ ISO 17782-2018 / ISO 17781 2018		
Material designation and MDS No.:	WROUGHT FITTINGS TO ASTM 815 UNS S32750 (SEAM. & WLD) – MDS D53 Rev.6		
Manufacturing summary doc. No.:	MS005_ RACCORDI FORGIATI SRL NIBBIANO MS006_ TECTUBI RACCORDI SpA PODENZANO MS007_ TECTUBI RACCORDI SpA C.S.GIOVANNI MS008_ TECTUBI RACCORDI SpA CALENDASCO	Rev. No.: 2	
Products and manufacturing process:	<p><u>Manufacturing routes 005A up to 005G (Raccordi Forgiati):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows.</p> <p><u>Manufacturing routes 006A up to 006L(Tectubi Raccordi Podenzano):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows, elbows in two halves; seamless cold formed tees, welded cold formed tees.</p> <p><u>Manufacturing routes 007A up to 007H(Tectubi Raccordi Castel S.Giovanni):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows, elbows in two halves</p> <p><u>Manufacturing routes 008A up to 008B (Tectubi Raccordi Calendasco):</u> Seamless and welded cold formed elbows</p>		
Mandatory conditions and sub-contractors:	Welding carried out by: Podenzano Plant Heat Treatment Procedure: PR048 External laboratory: LPM (Gagnano)-SIDERTEST (C.S.Giovanni) , maybe used for NDE.		

Other information:	Qualification extension: the qualification of welded tees qualifies all the other pieces (elbows, caps, reducers) in seamless execution as approved by the Qualifying Company (SFF). Heat treatment verification performed by GL (Germanischer LLOYD) on behalf of SFF; see inspection report No 01 Rev.1				
Qualification expires:	16.12.2026				
Tested and Qualified Thickness and Weight					
Products and manufacturing process:	Test record No.	Tested thickness (mm)	Qualified thickness (mm)	Plant	Raw material supplier
B.W. Welded Tees 16" x 8" wth. 32/ 20 From Plates (Hot forming method)	CERT.16-00072	32 mm	up to 40 mm	Raccordi Forgiati (Nibbiano)	Yakin
B.W. Welded Tees 16" x 8" wth. 32/ 20 From Plates (Hot forming method)	CERT.16-00073	32 mm	up to 40 mm	Tectubi Raccordi C.S.Giovanni	Yakin
B.W. Welded Tees 16" x 8" wth. 32/ 20 From Plates (Hot forming method)	CERT.16-00074	32 mm	up to 40 mm	Tectubi Raccordi Podenzano	Yakin
Welded elbow LR 45° 16" wth.22mm	CERT.16-00072	22 mm	up to 27,5 mm	Tectubi Raccordi Calendasco	Arcelo Mittal
Qualification/Acceptance signatures					
Manufacturer:	Prepared by/Date: P. Ayadelli 10/08/2021	Checked by/Date: Loretta Zacconi 10/08/2021 QA MANAGER EN ISO 9712 Level 2 PT-MT-UT-VT SNT-TG			
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. 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.					
Qualified/Accepted by (company name/address): SFF Scandinavian Fittings & Flanges		Signature/Date: Jarle Kjørestad 16.12.2021			

REV.1 : typing mistake amended in tested and qualified thickness section; modified "other information" paragraph.

REV.2 : Re-qualification to Norsok M-650 Ed.4 / ISO 17782:2018 / ISO 17781:2018

	QTR Qualification Test Record NORSOK M-650	QTR. No.: 760/2016 Rev. No.: 3
Manufacturer name/address/ Web page:	ALLIED INTERNATIONAL Group Srl Loc. Vascellino, 29010 – Nibbiano Val Tidone (PC), Italy www.alliedfittings.com Plants: Tectubi Raccordi Via Roma, 150, Podenzano (PC)  Tectubi Raccordi Via Galileo Galilei, Castel S.Giovanni(PC)  Tectubi Raccordi Via Ancona, 27Calendasco (PC)  Raccordi Forgiati Loc. La Casetta , Nibbiano (PC) 	
Reference standard	NORSOK M-650 Ed.4/ ISO 17782-2018 / ISO 17781 2018	
Material designation and MDS No.:	WROUGHT FITTINGS TO ASTM 815 UNS S32760 (SEAM. & WLD) – MDS D53 Rev.6	
Manufacturing summary doc. No.:	MS009 _ RACCORDI FORGIATI SRL NIBBIANO MS010 _ TECTUBI RACCORDI SpA PODENZANO MS011 _ TECTUBI RACCORDI SpA C.S.GIOVANNI MS012 _ TECTUBI RACCORDI SpA CALENDASCO	Rev. No.: 2 for MS-010-MS-011 & MS-012 Rev. No. 3 for MS-009
Products and manufacturing process:	<p><u>Manufacturing routes 009A up to 009F (Raccordi Forgiati):</u> Seamless hot formed tees, reducers, elbows, caps;</p> <p><u>Manufacturing routes 010A up to 010L(Tectubi Raccordi Podenzano):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows, elbows in two halves; seamless cold formed tees, welded cold formed tees.</p> <p><u>Manufacturing routes 011A up to 011H(Tectubi Raccordi Castel S.Giovanni):</u> Seamless hot formed tees, reducers, elbows, caps; welded hot formed tees, reducers, elbows, elbows in two halves</p> <p><u>Manufacturing routes 012A up to 012B (Tectubi Raccordi Calendasco):</u> Seamless and welded cold formed elbows</p>	
Mandatory conditions and sub-contractors:	Welding carried out by: Podenzano Plant Heat Treatment Procedure: PR048 External laboratory: SIDERTEST (C.S.Giovanni) , maybe used for NDE.	
Other information:	Qualification extension: the qualification of welded tees qualifies all the other pieces (elbows, caps, reducers) in seamless execution as approved by the Qualifying Company (SFF). Heat treatment verification performed by GL (Germanischer LLOYD) on behalf of SFF; see inspection report No 01 Rev.1	

Qualification expires:	16.12.2026				
Tested and Qualified Thickness and Weight					
<i>Products and manufacturing process:</i>	<i>Test record No.</i>	<i>Tested thickness (mm)</i>	<i>Qualified thickness (mm)</i>	<i>Plant</i>	<i>Raw material supplier</i>
Seamless Tees 12" x 8" wth. 55mm From forged bar (Hot forming method)	CERT.22_0291	55 mm	up to 55 mm	Raccordi Forgiati (Nibbiano)	Forge Fedriga
B.W. Welded Tees 16" x 8" wth. 32/ 20 From Plates (Hot forming method)	CERT.16-00081	32 mm	up to 40 mm	Tectubi Raccordi C.S.Giovanni	ArcelorMittal
B.W. Welded Tees 16" x 8" wth. 32/ 20 From Plates (Hot forming method)	CERT.16-00081	32 mm	up to 40 mm	Tectubi Raccordi Podenzano	ArcelorMittal
Welded elbow LR 45° 16" wth.20mm	CERT.16-00084	20 mm	up to 25 mm	Tectubi Raccordi Calendasco	Outukumpu
Seamless elbow LR 45° 10" wth.20mm	CERT.16-00083	20 mm	up to 25 mm	Tectubi Raccordi Calendasco	Forge Fedriga/Aso
Qualification/Acceptance signatures					
Manufacturer:	Prepared by/Date: P.Aradelli  10/08/2021		Checked by/Date: L.Zacconi  10/08/2021		
<p>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.</p> <p>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.</p>					
Qualified/Accepted by (company name/address):  Scandinavian Fittings & Flanges			Signature/Date:  02.09.2022		

REV.1 : typing mistake amended in tested and qualified thickness section; modified "other information" paragraph.

REV.2 : Re-qualification to Norsok M-650 Ed.4 / ISO 17782:2018 / ISO 17781:2018

REV.3: Qualification extension for RACCORDI FORGIATI plant only referred to MS-009A to F ; from 40mm up to 55mm