



QTR

Qualification Test Record

NORSOK M-650

QTR. No.:
QN
500/06

Rev. No.:1

Manufacturer name/address/ Web page:	SCHMIEDEWERK STOOSS AG CH-8908 HEDINGEN www.stooss.com / e-mail: info@stooss.com	
Reference standard	NORSOK M650 Rev. 3 – QUALIFICATION of MANUFACTURERS of SPECIAL MATERIAL	
Material designation and MDS No.:	ASTM A182-F51/UNS S31803 modified NORSOK MDS D44 Rev. 3	
Manufacturing summary doc. No.:	MS-QN-F51-530	Rev. No.: 2
Products and manufacturing process(es):	HAMMER FORGING & PUNCHING (H5/H7) followed by RING ROLLING (W1/W2): -sleeves, rectangular rings, bodies, seats and flanges	
Mandatory conditions and sub-contractors:	Sub-Supplier / Steel Manufacturer: BÖHLER- Edelstahl GmbH (A)- M650 Rev.3 certificate HOLDER COGNE ACCIAI Speciali S.p.a (I) M650 Rev. 3 certificate HOLDER	
Other information:	Limitation in procedure – weight and size Forging Group H5/W1: 150kg / OD 300mm / Height max.200mm Forging Group H7/W2: 300kg / OD 500mm / Height max.300mm	

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)
seamless rolled ring	29377 C11	35 mm	+10%	13,5kg	
regular production tests with elevated Charpy-V impact requirements (+20Joule) for Rev. 3 Qualification purposes witnessed by German Lloyds and 3.2 certification					

Qualification / Acceptance signatures

Manufacturer: SCHMIEDEWERK STOOSS AG Maienbrunnenstrasse 8 CH-8908 Hedingen	Prepared by/Date: Detlev M. Repitsch 01.03.2007 <i>D.M. Repitsch</i>	Checked by/Date: Olaf Fiege <i>Olaf Fiege</i> 01.03.2007
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*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):



Frank Mohn Flatøy AS
Oil & Gas Division
N-5918 FREKHAUG, NORWAY

Signature/Date:

24.04.2007
Frank Mohn

