

	Qualification Test Record (QTR) NORSOK M-650		QTR. No.: 02			
			Rev. No.: 07			
Manufacturer name/address/ Web page:	<i>H. Butting GmbH & Co. KG, Gifhorner Str. 59, 29379 Wittingen-Knesebeck, Germany</i> <i>www.butting.de</i>					
Reference standard	NORSOK M-650, Edition 4					
Material designation and MDS No.:	ASTM A928 Type 25Cr Duplex (PRE=>40) UNS S32760 Cl.1/3/5 NORSOK M-630:2020 MDS D52 Rev. 6					
Manufacturing Summary doc. No.:	D-02			Rev. No.:06		
Products and manufacturing process(es):	Cold formed Stainless Steel Pipes, longitudinally welded by EB/GTAW Double sided Furnace HT Prod. route No. 1 PAW/GTAW Double sided Furnace HT Prod. route No. 2 PAW/GTAW Double/single sided Induction HT (in line) Prod. route No. 3 PAW/GTAW Double sided Induction HT (391) Prod. route No. 4 EB/GTAW Double sided Induction HT (391) Prod. route No. 5					
Mandatory conditions and sub-contractors:	<ul style="list-style-type: none"> • Cold forming, Heat treatment, Pickling • Raw Material Suppliers <i>Plate: Allegheny, Böhler, Industeel, Outokumpu</i> <i>Coil: Allegheny, Outokumpu</i> 					
Other information:	<ul style="list-style-type: none"> • Test Laboratory accredited to ISO 17025 • Verification reports included in Section 3 • Qualification testing acc. to MDS D52 Rev.4 or 5, however all testing also meets requirements of MDS D52 Rev.5 • Rev. 03 – Re-Qualification Rev. 04 – Qualification acc. to M-650 Ed. 4 Rev. 06 – Re-Qualification and Qualification of Prod. route No. 4 + 5 Rev. 07 – Re-Qualification and Qualification testing to extend qualified wall thickness of Prod. route No. 5 					
Qualification expires:	14.03.2029					
Tested and qualified thickness and weight						
Products and manufacturing process(es):	Reference no.	Qualification order no.	Tested thickness mm	Qualified thickness mm	Test piece weight kg	Qualified weight kg
Welded pipes / PR 1	QTR-02/R1	1055094	35,0	40,00	N/A	N/A
Welded pipes / PR 1	QTR-02/R1	55/06732/03	23,83	29,79	N/A	N/A
Welded pipes / PR 2	QTR-02/R2	55/06732/02	15,90	19,88	N/A	N/A
Welded pipes / PR 2	QTR-02/R2	53/10563/06	9,53	11,91	N/A	N/A
Welded pipes / PR 3	QTR-02/R3	65/40002/01	4,57	5,71	N/A	N/A
Welded pipes / PR 4	QTR-02/R4	1169058	15,40	19,25	N/A	N/A
Welded pipes / PR 5	QTR-02/R5	1164104	15,40	19,25	N/A	N/A
Welded pipes / PR 5	QTR-02/R5	1255682	25,40	31,75	N/A	N/A
Qualification/acceptance signatures						
Manufacturer: BUTTING GmbH & Co. KG	Prepared by/Date: <i>Sigrun Claus / 28.02.2024</i>			Checked by/Date: <i>Sabine Nagel / 28.02.2024</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.
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: 06.03.2024

Velle R. Østerhus