



Wednesday Jan-07-2015

From:

Cameron Canada Corporation
3707 97 St.

Edmonton, Alberta, Canada
T6E 6J2
780-468-2732

www.c-a-m.com

To:

..

Subject:

Serial: 120427404

Quantity/Series: 50

Comment:

Part Number: 5A-T3R10S20LZ3

Description: 1" RP 2000 WOG FNPT SLT, FIRESAFE, ANTI-STATIC

Sales Order: N/A

Purchase Order: N/A



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Cameron Canada Corporation
3707 97 St.
Edmonton, Alberta, Canada
T6E 6J2
780-468-2732

To:

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Document Summary Page

The MTR's are printed in the following order:

#	Heat #	Heat Code	Part Description	Product
1	L	LOC	Nutron T3, B3, B2, TT Sour Low Temp.	--LOC
2	Hydro Test	598	API 598	-Hydro Test
3	339990		BODY, 7/8" 4000 WOG T3	5A-10001032400
4	D70456	HE	CAP, 1" RP 4000 WOG FNPT	5A-1010101032400
5	R6271		STEM, 7/8", ANTI-STATIC, ASTM A564 17-4	5A-11301013617001
6	S8313		BALL, 7/8", w/1/8" HOLE FOR ANTI-STATIC SP	5A-11501041617026



VALVES & MEASUREMENT
Cameron Canada Corporation
3707 - 97 Street
Edmonton Alberta Canada T6E 6J2
Phone 780.463.6868
Fax 780.465.1244
www.c-a-m.com

GENERAL LETTER OF COMPLIANCE

for:

**Nutron Models
T3, B3 & B2 & TT**

Style 'L': Sour Low Temperature Service

Cameron Valves & Measurement hereby certifies that the design, fabrication, testing and quality control of the above NUTRON brand ball valves for Sour Low Temperature Service have been made in accordance with the following applicable standards (latest edition in effect at time of manufacture): API 598 (1-1/2" and smaller), API 6D (TT only), ASME B16.34, CSA Z245.15 Sour Service (2" FP and larger) and V&M Engineering Standards. As part of compliance to these specifications, the valves have been marked in accordance with MSS SP-25. The valve has also been marked "SOUR" as required by CSA Z245.15 marking requirements for Sour Service.

The materials of construction for this valve conform to the metallurgical requirements of NACE MR0175/ISO 15156:2009 (Parts 1 & 2 for Carbon & Alloy Steels in SSC Region 3 Sour Service and Parts 1 & 3 for CRA's as specified in CSA Z245.15 Chapter 13). Per NACE MR0175-2009/ISO 15156, it is the customer's/user's responsibility to ensure that the valve materials will be satisfactory in the intended service.

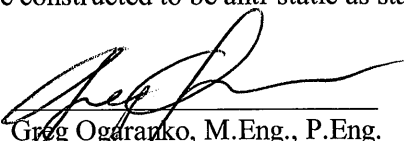
The minimum service temperature of these valves is -46°C/-50°F. Impact testing has been performed in accordance with applicable ASTM requirements and those of CSA Z245.15 for Category II M45C Service.

The 'Z' option code designation at the end of a figure number indicates that the valve meets the requirements of API-607 Fourth Edition, May 1993.

These valves (1-1/2" and larger) conform to the Pressure Equipment Directive requirements and are marked as CE certified (Certificate #8888-001-2002).

The B2 and TT valve models are constructed to be anti-static as standard.

Approved by:


Greg Ogarko, M.Eng., P.Eng.
Engineering Manager

**VALVES & MEASUREMENT**

Cameron Canada Corporation
3707-97th St.
Edmonton Alberta Canada T6E 6J2
Phone 780.468.2732
www.c-a-m.com

CERTIFICATE OF CONFORMANCE**API 598 Pressure Testing – Carbon Steel
(2" RP and Smaller)**

COMPLIANCE: These valves are tested in accordance with Cameron Valves & Measurement's standard procedures and API Standard 598, as per the chart below.

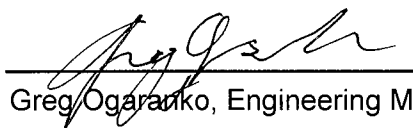
Test durations are 15 seconds in length as a minimum. Test duration is defined as the period of inspection after the valve is fully prepared and is under full pressure.

Butt weld end valves shall be tested in accordance with the ANSI rating.

Actual test pressure is rounded to next highest increment on the gauge.

Carbon Steel
Shell and Seat Test Pressures
(Table Based on Rating for Group 1.1 Materials per ANSI B16.34)

Valve Class	Maximum Working Pressure	Hydrostatic Shell Test Pressure (PSI)	Air Seat Test Pressure +/- 10 PSI
150 ANSI	285	450	80
300 ANSI	740	1125	80
600 ANSI	1480	2225	80
800 ANSI	1975	3000	80
900 ANSI	2220	3350	80
1500 ANSI	3705	5575	80
2500 ANSI	6170	9275	80
275 WOG	275	425	80
720 WOG	720	1100	80
1000 WOG	1000	1500	80
1440 WOG	1440	2175	80
1500 WOG	1500	2250	80
2000 WOG	2000	3000	80
2160 WOG	2160	3250	80
3000 WOG	3000	4500	80
3600 WOG	3600	5400	80
4000 WOG	4000	6000	80
5000 WOG	5000	7500	80
6000 WOG	6000	9000	80


Greg Ogarko, Engineering Manager

MTR COVER SHEET

Company: ZINTRON INDUSTRIAL LTD
Address: No.198-1, Sinhe Rd, Hsin Feng Hsiang,Hsinchu, Taiwan, R.O.C.
Phone: 886-3-568-7100
Fax: Line 1: 886-3-568-7119
E-Mail: zintron@zintron.com.tw

Date:	2014/8/8				
Customer :	CAM DISTRIBUTED VAL EDMONTON				
Address:	COOPER CAMERON CANADA CORP 3707-97 Street Edmonton, Alberta T6E 6J2				
Customer PO:	4510387971	Item No.	30	Date:	2014/10/17
Part No.	5A-10001032400 REV 01	Part Desc.:	BODY,7/8" 4000 WOG,ASTM A350 (LATEST EDITION) Gr LF2		
Heat No.	339990_	Heat Code:			

S.O.No.:		Item No.:		Date:	
Quantity:		Weight:			

We hereby certifies that the parts shipped on your purchase order specified above have been produced in accordance with purchase order instructions and specification.

APPROVED BY: Martin
Authorized Signature: QA Manager: Martin Chu
Print Name: Martin Chu
Title: QA Manager

Original MTR/Certification provided by(attached):

Supplier: ZINTRON INDUSTRIAL LTD
Address: No.198-1, Sinhe Rd, Hsin Feng Hsiang,Hsinchu, Taiwan, R.O.C.
Phone: 886-3-568-7100
Fax: Line 1: 886-3-568-7119
E-Mail: zintron@zintron.com.tw
200

Note: MTR/Certification shall be legible for electronic archiving.



MTR HEAT NUMBER ANNEX FORM

Part Number: 5A-10001032400 REV 01

PO: 4510387971-30

Quantity: 5000

[illegible]

APPROVED

By laia at 10:55 am, 10/23/14



Zintron Industrial LTD

No.198-1, Sinhe Rd., Sinfong Township, Hsinchu County 304, Taiwan (R.O.C.)
 Tel : 886-3-568-7100
 Fax : 886-3-568-7119
 E-mail : zintron@zintron.com.tw

[T3-7/8"B 4000 LF2]

Report No: 2325-200

MILL TEST CERTIFICATE REPORT

Client	Cooper Cameron Valves Canada	Shipping Date	Aug.08.2014
Product	BODY, 7/8" 4000 WOG, ASTM A350 (LATEST EDITION) Gr LF2	Material	ASTM A350 LF2/A105 (5A-81504032074)
Order No	4510387971-30	Condition	Forge
Part No	5A-10001032400 REV 01		
Order Q'ty	7570 pcs	Shipping Q'ty	5000 pcs

CHEMICAL PROPERTIES

Material Spec.	Chemical Composition %														
	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	V	Cb	Residue	C.E.		
	Max.	0.230	0.300	1.050	0.035	0.035	0.400	0.300	0.120	0.400	0.080	0.020	1.000	0.430	
	Min.		0.150	0.600											
Heat No: 339990_	0.190	0.210	0.840	0.015	0.009	0.040	0.100	0.010	0.120	0.001	0.001	0.271	0.360		

MECHANICAL PROPERTIES

Material Spec.		Tensile Strength	Yield Strength	Elong.%	R.A.%	Hardness1	Hardness2		
	Max.	95000 psi				187 HB	187 HB		
	Min.	70000 psi	36000 psi	22 %	30 %	137 HB	137 HB		
Heat No: 339990_		76278 psi	48088 psi	36.1 %	74.3 %	174 HB	170 HB		

Charpy V-Notch Impact Test for Standard Size 10x10mm Specimen

Material Spec.	-46°C V-Notch Impact	Impact No.1	Impact No.2	Impact No.3		
Heat No: 339990_	46.05 ft-lbs	40.74 ft-lbs	52.73 ft-lbs	44.68 ft-lbs		

Heat Treatment Procedure as follows:

1. Austenitize at 1550-1700°F(843-930°C). Cycle time shall be one hour minimum.
2. Oil quench.
3. Temper at 1100-1300°F(590-704°C), holding at temperature a minimum of 30 min/in.(30min/25mm) of maximum thickness

- 1.C.E.= %C+%Mn/6 + (%Cr+%Mo + %V)/5 +(%Ni+%Cu)/15
- 2.The Charpy V-notch impact test was implemented as below:
 (1)Specimen Size :ASTM E23 10 mm x 10 mm x 55 mm V-Notch
 (2)The test specimen orientation: longitudinal.

We hereby certify that the material provided complies with all CVM requirements as stated in the applicable purchase order and that inspections were performed and certificates issued in accordance with EN 10204, 3.1, 2004.

APPROVED BY:

Martin

QA Manager: Martin Chu

APPROVED

By laia at 10:56 am, 10/23/14



Global
 ISO 9001:2008
 Registration Number: 69Q15438

HEAT TREATMENT ANNEX FORM

[illegible]

APPROVED
By laia at 10:57 am, 10/23/14



無放射性污染暨品質證明書
(出廠證明書)
TEST CERTIFICATE

OFFICE : 臺中市后里區甲后路702號
702, CHIAHOU ROAD, HOU LI SHUNG,
TAICHUNG HSIEN, TAIWAN, ROC
TEL : (04)25565101
FAX : (04)25569555

客戶名稱 CUSTOMER NAME			證明書編號 CERTIFICATE NO.	22BB0282-001
規格名稱 SPEC.	ASTM A105	產品名稱 PRODUCT	交運日期 SHIPPING DATE	2013/11/14 ~ 2013/11/14
		HOT ROLLED STRAIGHT ROUND BAR	證明書列印日期 CERTIFICATE DATE	2013/11/15

尺寸及規格 DIM. (mm)	長度 LEN. (m)	數量 QTY (bdl.)	重量 WEIGHT (kg)	爐號 HEAT NO	拉力試驗 TENSILE			化學成分(%)CHEMICAL ANALYSIS														重量單 編號 SHIPPING NO.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																										
					降伏YP /mm ²	抗拉TS /mm ²	伸長率 EL(%)	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Pb	Al	Nb	V	B		CO																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																									
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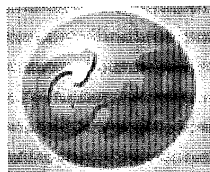
茲證明本表所列產品,均係材料規格製造及試驗並符合規格之要求
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS MANUFACTURED AND TESTED WITH
SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENT OF THE ABOVE MATERIAL SPECIFICATION.

冶金研發處處長
MANAGER
METALLURGICAL R&D DEP.

郭志毅

APPROVED

By laia at 10:59 am, 10/23/14



Giant Young Machinery Component Parts Co., Ltd.

No. 13 Fang Yuan Ind. Park 4 th Rd. , Chang Hwa Hsien , Taiwan

TEL: 886-4-8965977

FAX: 886-4-8965981

機械性質測試證明 MECHANICAL PROPERTIES CERTIFICATE

材質 (Material): ASTM A350 LF2 報告編號 (Report No): GF20141013039
數量 (Quantity): 1PC 訂單號碼 (Order No): GF1031013
日期 (Date): OCT.13.2014 試片 (Specimen): Forged Specimen

拉 伸 試 驗 Tension Test

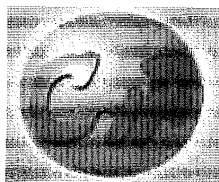
Heat No.	試 片 Test specimen		抗拉強度 T.S	降伏強度 Y.S	伸長率 Elongation	斷面縮率 R.A	硬度值 1 Hardness 勃氏硬度	硬度值 2 Hardness 勃氏硬度
	標點長(mm) Gauge Length	直徑 (mm) Dia	kgf/mm ²	0.2% offset kgf/mm ²	%	%	Brinell HB	Brinell HB
339990	25	6.23	53.63 (76278 psi)	33.81 (48088 psi)	36.1	74.3	174	170
			空 白 B L A N K					

Q.A.CHIEF:

陳加鎮

APPROVED

By laia at 11:01 am, 10/23/14



Giant Young Machinery Component Parts Co., Ltd.

No. 13 Fang Yuan Ind. Park 4 th Rd. , Chang Hwa Hsien , Taiwan

TEL: 886-4-8965977

FAX: 886-4-8965981

衝擊試驗報告表 IMPACT TEST REPORT

客戶:

品名:

檢驗編號:

Customer: Cameron International Corporation Product: Forged specimen Application No: GF20141013005

委託事項:

衝擊試驗

材質:

檢驗日期:

Job Description: Impact Testing

Material: ASTM A350-LF2

Date Issued: Oct.13,2014

1. Testing specification: ASTM A-350 LF2
2. Testing Instrument: Impact Tester
3. Specimen Size :ASTM E23 10 mm x 10 mm x 55 mm V-Notch
4. Testing Temperature: - 50° F
5. The test specimen orientation:longitudinal

Testing Result:

試片編號 Specimen No	衝擊值 Energy Value (Ft-Lbs)			平均值 Average Value(Ft-Lbs)	備註 Remark
	No. 1	No. 2	No. 3		
339990	40.74	52.73	44.68	46.05Ft-Lbs	
	空白 B L A N K				

Q.A.CHIEF:

陳加鎮

APPROVED

By laia at 11:01 am, 10/23/14

Material Test Report

Specification Notes:

Name	Revision	Grade	Description	Revision Year
ASTM A105/ASTM A350 GR LF2 Cameron			Carbon & Low-Alloy Steel Forgings	

Product Information:

Item #	Product Code	Description	Heat Number	Heat Code	PO #
1	5A-1010101032400	CAP,1" RP 4000 WOG FNPT, ASTM A105/LF2	D70456	HE	

Chemical Information:

Item #	C	Mn	P	S	Si	Ni	Cr	Mo	Cu	V	CE	Cb/Nb	Cu+Ni	Cr+Mo
Min		0.6			0.10									
Max	0.21	1.35	0.030	0.030	0.3	0.4	0.3	0.12	0.4	0.08	0.43	0.02	1.00	0.32
1	.2	1.21	.009	.018	.21	.04	.05	.01	.11	0.0		.014		

Physical Information:

Item #	Tensile (psi)	Yield (psi)	% Elongation	Charpy ft/lb	Charpy Temp (°F)	% Red of Area	Hardness (Brinell)
Min	70000	36000	22	15	-80	30	137
Max	95000				-50		197
1	76300	49700	34	83, 57, 87	-50	71	148

Additional Notes:

NORMALIZED AS PER ASTM A350 LF2

We certify that the items referenced in this document were manufactured and tested in accordance with Cameron Purchase Order requirements and EIH0204 3.1


Quality Manager
Cameron Canada

Wen Zone

TUV

ISO 9001
No. 01 100 029186**原 璋 實 業 有 限 公 司****WON ZONE CORPORATION**

3F No. 185 Chung Hwa Road Sec. 2, Chung Li City 32068, Taiwan

32068 桃園縣中壢市中華路二段 185 號 3 樓 統一編號: 16879927

Tel: +886-3-4341 325 Fax: +886-3-4341 525 E-mail: wonzone.taiwan@msa.hinet.net

CERTIFICATE OF CHEMICAL ANALYSIS AND MECHANICAL PROPERTIES						CERTIFICATE NO. 141027- 3 DATE: 27-Oct-14					
To. CAMERON CANADA CORPORATION 3707-97th Street, EDMONTON, AB T6E 6J2, CANADA											
INVOICE NO. WZ-141027A						Your Order No. 4510517522/521523/539725					
MATERIAL SPECIFICATION: ASTM A-564 TYPE 630 H1150D											
Q'TY	PART NAME	DRAWING No.	Heat Code	Mechanical Properties							
				Y.S.(KSI)	T.S.(KSI)	ELO.(%)	HRC	RA (%)	ft-lbf (-75°F)		
				<u>105 min</u>	<u>125 min</u>	<u>16 min</u>	<u>29~33</u>	<u>50 min</u>	<u>15 min</u>		
6,400	5A-11301013617001 Stem 7/8"	#02040	R6271	121	139	22	30	70	92/92/94		
164	5A-11301513617001 Stem 1½"	#02038	FO	127	138	22	32	72	96/86/100		
1,936	5A-11301513617001 Stem 1½"	#02038	FR	119	136	24	32	72	95/97/98		
720	5A-11501013617026 Ball 7/8"	#06082	S8492	116	137	25	32	72	103/95/96		
180	5A-11502013617015 Ball 2"	#06080	S8421	110	135	22	30	70	84/84/86		
Heat Code	Chemical Composition (%)										
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb+Ta	
	<u>0.07max</u>	<u>1.0max</u>	<u>1.0max</u>	<u>.030max</u>	<u>.040max</u>	<u>15-17.5</u>	<u>3.0-5.0</u>	<u>0.5 max</u>	<u>3.0-5.0</u>	<u>0.15-0.45</u>	
R6271	0.02	0.64	0.49	0.023	0.029	15.04	4.36	0.19	3.40	0.23	
FO	0.02	0.63	0.51	0.023	0.029	15.17	4.32	0.18	3.40	0.23	
FR	0.02	0.63	0.46	0.018	0.030	15.20	4.33	0.17	3.46	0.22	
S8492	0.02	0.63	0.45	0.025	0.029	15.27	4.22	0.18	3.47	0.22	
S8421	0.02	0.63	0.46	0.018	0.030	15.20	4.33	0.17	3.46	0.22	
Solution Treatment: 1900°F for 30 Min/Inch (Minimum of 1 Hour), Fast Air Cooling to below 90°F											
Double Aged at 1150°F for 4 hours minimum and cooled to below 90°F in air											
Charpy Impact Test Specimens: 10*10*55mm(Longitudinal)											
Re Orig Heat #SE0302-G80 for R6271; #SE0082-BA2 for FO; #SE1134-GK0 for FR;											
#SE0979-G80 for S8492; #SE1134-GE8 for S8421											
NOTE: CERTIFICATE ACCORDING TO EN 10204/3.1B											
QUALITY CONTROL INSPECTOR						MANAGER					
Sandy Yeh						Grant Hsu					

APPROVED

By laia at 8:04 am, 11/20/14



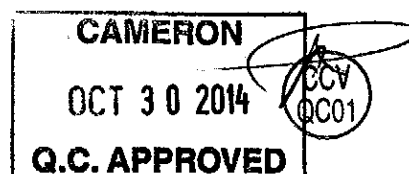
ISO 9001
No. 01 100 029186

原 璋 實 業 有 限 公 司

WON ZONE CORPORATION

3F No. 185 Chung Hwa Road Sec. 2, Chung Li City 32068, Taiwan
32068 桃園縣中壢市中華路二段 185 號 3 樓 統一編號: 16879927
Tel: +886-3-4341 325 Fax: +886-3-4341 525 E-mail: wonzone.taiwan@msa.hinet.net

CERTIFICATE OF CHEMICAL ANALYSIS AND MECHANICAL PROPERTIES					CERTIFICATE NO. 141013- 2 DATE: 13-Oct-14			
To. CAMERON CANADA CORPORATION 3707-97th Street, EDMONTON, AB T6E 6J2, CANADA								
INVOICE NO. WZ-141013A					Your Order No. 4510471667			
Material Specification: ASTM A351 CF8M					Heat Treatment: Solution Annealed (1050°C min./2hrs/water)			
Q'TY	PART NAME	DRAWING No.	Heat Code	Mechanical Properties				
				T.S.(MPa)	Y.S.(MPa)	ELO.(%)	HB	
				485 min	205 min	30 min	140-237	
1,000	5A-11500541617015 Ball ½"	#06076	S8312	517	229	47	168	
6,120	5A-11501041617026 Ball 7/8"	#06082	S8313	548	251	49	144	
768	5A-11501541617015 Ball 1½"	#06079	S8315	521	307	49	156	
450	5A-11502041617015 Ball 2"	#06080	S8318	530	278	46	154	
162	5A-11503041617015 Ball 3"	#06083	S8342	523	286	48	155	
Heat Code	Chemical Composition (%)							
	C	Mn	Si	S	P	Cr	Ni	Mo
	0.08max	1.5max	1.5max	.040max	.040max	18-21	9-12	2.0-3.0
S8312	0.0465	0.7673	0.4173	0.0071	0.0377	18.6200	9.4424	2.2732
S8313	0.046	0.91	0.512	0.0101	0.035	18.50	9.36	2.13
S8315	0.043	1.05	0.498	0.0098	0.0297	18.59	9.47	2.14
S8318	0.047	0.89	0.527	0.0099	0.0314	18.52	9.47	2.22
S8342	0.056	1.11	0.569	0.0083	0.0302	18.69	9.46	2.21
Re: Orig Heat # D598 for S8312; #140826-03-3 for S8313; #B140925-16-2 for S8315; B140909-09-2 for S8318; #B140821-15-3 for S8342								
NOTE: CERTIFICATE ACCORDING TO EN 10204/3.1B								
QUALITY CONTROL INSPECTOR					MANAGER			
Sandy Yeh					Grant Hsu			





ISO 9001
No. 01 100 029186

原 璋 實 業 有 限 公 司

WON ZONE CORPORATION

3F No. 185 Chung Hwa Road Sec. 2, Chung Li City 32068, Taiwan
32068 桃園縣中壢市中華路二段 185 號 3 樓 統一編號: 16879927
Tel: +886-3-4341 325 Fax: +886-3-4341 525 E-mail: wonzone.taiwan@msa.hinet.net

CERTIFICATE OF CHEMICAL ANALYSIS AND MECHANICAL PROPERTIES					CERTIFICATE NO. 141013- 2 DATE: 13-Oct-14				
To. CAMERON CANADA CORPORATION 3707-97th Street, EDMONTON, AB T6E 6J2, CANADA									
INVOICE NO. WZ-141013A					Your Order No. 4510471667				
Material Specification: ASTM A351 CF8M					Heat Treatment: Solution Annealed (1050°C min./2hrs/water)				
Q'TY	PART NAME	DRAWING No.	Heat Code	Mechanical Properties					
				T.S.(MPa)	Y.S.(MPa)	ELO.(%)	HB		
				<u>485 min</u>	<u>205 min</u>	<u>30 min</u>	<u>140-237</u>		
1,000	5A-11500541617015 Ball ½"	#06076	S8312	517	229	47	168		
6,120	5A-11501041617026 Ball 7/8"	#06082	S8313	548	251	49	144		
768	5A-11501541617015 Ball 1½"	#06079	S8315	521	307	49	156		
450	5A-11502041617015 Ball 2"	#06080	S8318	530	278	46	154		
162	5A-11503041617015 Ball 3"	#06083	S8342	523	286	48	155		
Heat Code	Chemical Composition (%)								
	C	Mn	Si	S	P	Cr	Ni	Mo	
	<u>0.08max</u>	<u>1.5max</u>	<u>1.5max</u>	<u>.040max</u>	<u>.040max</u>	<u>18-21</u>	<u>9-12</u>	<u>2.0-3.0</u>	
S8312	0.0465	0.7673	0.4173	0.0071	0.0377	18.6200	9.4424	2.2732	
S8313	0.046	0.91	0.512	0.0101	0.035	18.50	9.36	2.13	
S8315	0.043	1.05	0.498	0.0098	0.0297	18.59	9.47	2.14	
S8318	0.047	0.89	0.527	0.0099	0.0314	18.52	9.47	2.22	
S8342	0.056	1.11	0.569	0.0083	0.0302	18.69	9.46	2.21	
Re: Orig Heat # D598 for S8312; #140826-03-3 for S8313; #B140925-16-2 for S8315; B140909-09-2 for S8318; #B140821-15-3 for S8342									
NOTE: CERTIFICATE ACCORDING TO EN 10204/3.1B									
QUALITY CONTROL INSPECTOR					MANAGER				
Sandy Yeh					Grant Hsu				

