



# MATERIAL MANUFACTURE STATEMENT

Certificate No.:  
10000457393-PA-DNV GL-IND Rev. 0

Initial date:  
31 March, 2023

Validity:  
30 March, 2028

This statement consists of 3 pages

This is to certify that the product(s)

## Open Die Forgings

Manufactured by,

## Hempel Forge Limited

Block no: 156, Village – Vasna Margiya, Opposite to GGSONGC, Near Bidaj form, Taluka & District: Kheda – 387 120, Gujarat, India

has been reviewed / assessed with respect to:  
THE REQUIREMENTS SPECIFIED IN Norsok M-650 ED. 4 ON QUALIFICATION OF MANUFACTURERS OF SPECIAL MATERIALS AND FOUND TO COMPLY.

Applications/limitations:

See page 2 & 3

This Material Manufacture Statement to be read in full.

Reference to the part of this statement which may lead to misinterpretation is not permissible.

This certificate is valid for the following products:

**NORSOK M-630:2020 MDS D44 Rev. 6 ASTM A182 Gr. F51 UNS S31803**  
**NORSOK M-630:2020 MDS D54 Rev. 6 ASTM A182 Gr. F53 UNS S32750**  
**NORSOK M-630:2020 MDS D54 Rev. 6 ASTM A182 Gr. F55 UNS S32760**  
**NORSOK M-630:2020 MDS D44 Rev. 6 ASTM A182 Gr. F60 UNS S32205**  
**NORSOK M-630:2020 MDS N14 Rev. 1 ASTM B564 Gr. UNS N06625**

Place and date:  
**Ahmedabad; 31 March, 2023**

For the issuing office:  
**DNV Business Assurance India Pvt. Ltd.**

**Manojkumar Panchal**

Head of Section, Manager – Product Assurance



Certificate No.: 10000457393-PA-DNV GL-IND Rev. 0  
 Project no : PRJN-242861-2021-PA-IND

## Certificate history

Revision	Description	Issue Date
00	Original Statement	31 March, 2023

## Products covered by this Statement

Product Description	Product Material Specification and Grade	Product Limitation		Manufacturing Summary & QTR reference
		Tested	Qualified	
Forged Block	NORSOK M-630:2020 MDS D44 Rev. 6 ASTM A182 Gr. F51 UNS S31803	Thk: 260 mm	Thk: 260 mm	HFL/DOC/20-21/8.2.1 Rev. 00, Dt. 05.03.2021 & HFL/QTR/01 Rev. 00, Dt. 31.03.2023
		Wt: 140 kg	Wt: 280 kg	
Forged Block	NORSOK M-630:2020 MDS D54 Rev. 6 ASTM A182 Gr. F53 UNS S32750	Thk: 260 mm	Thk: 260 mm	HFL/DOC/20-21/8.2.2 Rev. 00, Dt. 05.03.2021 & HFL/QTR/02 Rev. 00, Dt. 31.03.2023
		Wt: 140 kg	Wt: 280 kg	
Forged Blank	NORSOK M-630:2020 MDS D54 Rev. 6 ASTM A182 Gr. F55 UNS S32760	Thk: 115 mm	Thk: 115 mm	HFL/DOC/20-21/8.2.3 Rev. 00, Dt. 05.03.2021 & HFL/QTR/03 Rev. 00, Dt. 31.03.2023
		Wt: 410 kg	Wt: All	
Forged Block	NORSOK M-630:2020 MDS D44 Rev. 6 ASTM A182 Gr. F60 UNS S32205	Thk: 260 mm	Thk: 260 mm	HFL/DOC/20-21/8.2.4 Rev. 00, Dt. 05.03.2021 & HFL/QTR/04 Rev. 00, Dt. 31.03.2023
		Wt: 140 kg	Wt: 280 kg	
Forged Block	NORSOK M-630:2020 MDS N14 Rev. 1 ASTM B564 Gr. UNS N06625	Thk: 280 mm	Thk: 280 mm	HFL/DOC/20-21/8.2.5 Rev. 00, Dt. 05.03.2021 & HFL/QTR/05 Rev. 00, Dt. 31.03.2023
		Wt: 262 kg	Wt: All	

## Sites covered by this Statement

Site Name	Address
Hempel Forge Limited	Block no: 156, Village – Vasna Margiya, Opposite to GGSONGC, Near Bidaj form, Taluka & District: Kheda – 387 120, Gujarat, India



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Project no : PRJN-242861-2021-PA-IND

## Applications/Limitations

1. This material manufacture statement 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 / Norsok M-630.
2. Supply of the products as listed above shall be as per inspection documentation EN 10204 type - 3.1/3.2 requirements under the discretion of the Purchaser.
3. The production test sample shall be as per relevant MDS under the discretion of the purchaser.
4. The re-qualification process as per Norsok M-650 Ed. 4, clause 8.2 shall be repeated if any essential changes are made to the production route or the manufacturing procedure. e.g. major change of manufacturing process/method/equipment, heat treatment process/procedure etc.
5. If production is carried out at different plants / locations, a separate qualification is required for each plant. This applies also for change of in-house to subcontractors or change of subcontractor for essential operations as e.g. heat treatment, etc.
6. NDT operator qualification shall be as per EN ISO 9712 and based on the purchaser's requirements.
7. Weld repair is not permitted.
8. A temperature uniformity survey for the heat treatment furnaces shall be carried out annually in accordance with API Spec 6A Annex M, ASTM A991 or equivalent and additional requirements of Norsok M-650 Ed. 4 Annex B.
9. This certificate is issued after satisfactory completion of qualification as per Norsok M-650 Ed. 4 and Norsok M-630:2020
10. This certificate is issued based on the requestion letter from the manufacturer dated 05.03.2021 from the manufacturer.
11. Acceptance of QTR is at the discretion and determination of the purchaser.

## Terms and conditions

The Statement is subject to the following terms and conditions:

- Product Liability rests with Manufacturer, in case of damages caused by defective products
- The Statement is valid only for the product(s) listed above
- A visit shall be made to the manufacturer in case of changes to essential variables, manufacturing summary or during re-qualification. Manufacturer shall inform the local DNV office for any changes made with respect to QTR / Manufacturing Summary

The following changes may render this Statement invalid:

- Any deviation to application / limitation listed above
- Changes or amendments to the reference standard and manufacturing summary

## END OF STATEMENT