



CLYDESDALE WORKS, CLYDESDALE ROAD  
MOSSEND, LANARKSHIRE ML4 2RR  
TEL: (0)1698 742300

Customer Client Besteller

Customer's Ref. No. de Commande Bestell-Nr.  
PO 4410000026

Sales Ref. 0023014  
No. de Service Commercial Nr.  
Works No. 30408001  
No. d'usine  
Works -Nr.

Product Description Produit Prüfgegenstand  
HOT FINISHED SEAMLESS STEEL  
CASING  
VALLOUREC GRADE VM 125 CY

Doc Ref. No. Document No. Dok. Ref. Nr.  
Cert. No. No. du certifiical Nr.  
010/1451/0018



Additional Test Results  
Résultats additionnels  
Weitere Prüfergebnisse

Item No No article Pos. Nr.	Description Beschreibung	R <sub>e</sub>			R <sub>m</sub>			A %			Hydro pressure Hyd. Prüfdruck Prossion Hyd		Cast Number No de coulée Schmelz-Nr.		Additional Test Results Résultats additionnels Weitere Prüfergebnisse
		PSI	PSI	21N <sub>so</sub>	PSI	PSI	21N <sub>so</sub>	PSI	PSI	PSI	PSI	Schmelz-Nr.	Schmelz-Nr.		
1	13.625 IN OD X 0.625 IN	139236	152290	19	136626	146923	19	138801	149099	20	V230635	V230635	ODAVE-33.2MVAVE-33.2IDAVE-33.3 HRC KCV -10DEG.C(10x10) TRAN V230635 = 141: 142: 142 = 142J		
					134595	145473	20	V230635	V230635		V230635	V230635	ODAVE-32.4MVAVE-33.1IDAVE-32.5 HRC KCV -10DEG.C(10x10) TRAN V230635 = 159: 160: 154 = 158J		
					131695	143007	21	V230635	V230635		V230635	V230635	ODAVE-31.5MVAVE-31.7IDAVE-31.1 HRC KCV -10DPG.C(10x10) TRAN V230635 = 161: 162: 166 = 165J ODAVE-32.5MVAVE-33.1IDAVE-33.0 HRC KCV -10DEG.C(10x10) TRAN V230635 = 188: 182: 183 = 184J		



All test certificates issued by Vallourec Manufacturing Oil & Gas UK Limited have an embossed seal. Any recipient of a copy of a Vallourec Manufacturing Oil & Gas UK Limited test certificate without a seal should ensure from the supplier that it is a true and accurate reproduction of the original. These results are required by Vallourec Manufacturing Oil & Gas UK Limited and comply with the requirements of the Product.

Tous les certificats émis par Vallourec Manufacturing Oil & Gas UK Limited portent un cadret. Tout détenteur d'une copie de certificat de Vallourec Manufacturing Oil & Gas UK Limited sans le cadret doit constater au fournisseur que les résultats sont exacts et conformes aux exigences de la description du produit.

Alle Vallourec Manufacturing Oil & Gas UK Limited Anfahrungszeugnisse tragen ein eingestanztes Firmenlogo. Jeder Empfänger einer Kopie eines Vallourec Manufacturing Oil & Gas UK Limited Anfahrungszeugnisses ohne Firmenlogo soll sich beim Verkäufer vergewissern, dass es eine treue und genaue Wiedergabe der ursprünglichen Fassung ist. Diese Ergebnisse sind von Vallourec Manufacturing Oil & Gas UK Limited bescheinigt und entsprechen den Bedingungen der Erzeugnisbeschreibung.

Date 18-Dec-2014  
(for Quality Manager)

CLYDESDALE WORKS, CLYDESDALE ROAD  
MOSSEND, LANARKSHIRE ML4 2RR  
TEL: (0)1698 742300

Sales Ref. 0023014  
No. de Service Commercial 0023014  
Verkaufs Nr. 30408001  
Works No. 30408001  
Works -Nr. 30408001

Doc. Ref. No. 010/1451/0017



Customer Client Besteller  
Customer's Ref. PO 4410000026  
No. de Commande  
Product Description Product Prüfgegenstand  
HOT FINISHED SEAMLESS STEEL  
CASING  
VALLOUREC GRADE VM 125 CY

Item No No d'article Pos -Nr	Description Beschreibung	R e		R m		A %		Hydro pressure Hyd Prüfdruck Pression Hyd		Cast Number No de coulée Schmelz-Nr	Additional Test Results Résultats additionnels Weitere Prüfergebnisse
		PSI	PSI	PSI	PSI	2IN <sub>50</sub>	PSI	PSI			
1	VM@ 21 THREADED COUPLER MATERIAL CHECK TEST QUENCH AND TEMPERED BASIC OXYGEN STEEL IF LADLE ANALYSIS IS REPORTED AS 0.000 THEN NO INTENTIONAL ADDITIONS HAVE BEEN MADE QUALITY PLAN MTR/VM0G/001 INTERTEK INSPECTED 13.625 IN OD X 0.625 IN	137061	146923	19	19	PSI	PSI	2IN <sub>50</sub>	PSI	V215898 V215898 V215898	LONGITUDINAL ROUND BAR TENSILE SPECIMEN AT ROOM TEMPERATURE RE = RTO.65 COUPLINGS M.P.I. ID/OD LONG/TRANS CHARPY SHEAR > 75% MIN. TEMPERING TEMP. = 560degC PSL - 3 ODAVE-30.6MMAVE-31.10DAVE-31.4 HRC R0AVE-10BEG-10X1010HRCAN V215898 = 159; 164; 159 = 161J ODAVE-29.8MMAVE-30.21DAVE-30.0 HRC R0AVE-10DEG-10X1010HRCAN V215898 = 140; 148; 144 = 144J



Analysis Type Type D'Analyse	Cast Number No. de coulée	Chemical Analysis %						Analysis chimique de coulée %						Chemische Zusammensetzung %					
		C	Si	Mn	P	S	Cr	Mo	Ni	Al	Cu	Nb	Sn	Ti	V	B			
Ladle Check Check	V215898 V215898 V215898	0.27 0.26 0.25	0.23 0.25 0.24	0.52 0.46 0.46	0.009 0.013 0.012	0.002 0.004 0.004	1.03 0.88 0.88	0.52 0.44 0.43	0.04 0.04 0.04	0.021 0.024 0.04	0.03 0.02 0.04	0.000 0.016 0.013	0.000 0.000 0.001	0.000 0.017 0.015	0.02 0.02 0.02	0.002 0.003 0.003			

all test certificates issued by Vallourec Manufacturing Ltd & Gas UK Limited  
Have an embossed seal. Any recipient of a copy of a Vallourec Manufacturing  
Oil & Gas UK Limited test certificate without a seal should ensure from the  
supplier that it is a true and accurate reproduction of the original. These results  
are certified by Vallourec Manufacturing Oil & Gas UK Limited and comply with  
the requirements of the Product

Tous les certificats émis par Vallourec Manufacturing Oil & Gas UK Limited portent un  
cachet en relief. Tout destinataire d'une copie de certificat de Vallourec Manufacturing Oil & Gas  
UK Limited doit constater le fournisseur pour s'assurer de  
l'authenticité de la copie. Ces résultats sont certifiés par Vallourec Manufacturing Oil  
& Gas UK Limited et sont conformes aux exigences de la description du produit.

Alle Vallourec Manufacturing Oil & Gas UK Limited sind ein eingetragenes  
Firmenlogo. Jeder Empfänger einer Kopie eines Testzertifikats von Vallourec Manu-  
facturing Oil & Gas UK Limited sollte sich beim Lieferanten bestätigen, dass  
es eine treue und genaue Wiedergabe der ursprünglichen Fassung ist. Diese Ergebnisse sind  
von Vallourec Manufacturing Oil & Gas UK Limited bestätigt und entsprechen den  
Bedingungen der Erzeugnisbeschreibung.

Date 18-Dec-2014  
(for Quality Manager)

CLYDESDALE WORKS, CLYDESDALE ROAD  
 MOSSEND, LANARKSHIRE ML4 2RR  
 TEL: (0)1698 742300

# Test Certificate

# Certificat d'essai

# Abnahmezeugnis

Customer Client Besteller

Customer's Ref. No. de Commande  
PO 4410000026

Bestell-Nr.

Sales Ref. No. 0023014  
 No. de Service Commercial 30408001  
 Verkaufs Nr. 30408001  
 Works No. 30408001  
 No. d'usine -Nr.

Product Description  
HOT FINISHED SEAMLESS STEEL  
 CASING  
 VALLOUREC GRADE VM 125 CY  
 Prüfgegenstand

Doc. Ref. No. Document No. Dok. Ref. Nr.  
 Cert. No. 010/1451/0017  
 No. du certificat  
 Prüf Nr.



Item No No drarticle Pos.-Nr.	Description Description Beschreibung	R <sub>e</sub>	R <sub>m</sub>	A %	Hydro pressure Hyd Prüfdruck Pression Hyd	Cast Number No. de coulée Schmelz-Nr.	Additional Test Results Résultats additionnels Weitere Prüfergebnisse
		PSI	PSI	21N <sub>50</sub>	PSI		

1	I3.625 IN OD X 0.625 IN	129229	140832	21	PSI	V215898 V215898	ODAVE-31.6MMAVE-31.7IDAVE-32.0 HRC KCV -10DEG.C(10X10) TRAN V215898 = 174: 173: 170 = 172J
		129664	141557	19		V215898 V215898	ODAVE-30.3MMAVE-30.1IDAVE-30.6 HRC KCV -10DEG.C(10X10) TRAN V215898 = 148: 152: 154 = 151J
		127343	139527	22		V245654 V245654	ODAVE-30.5MMAVE-30.2IDAVE-30.8 HRC KCV -10DEG.C(10X10) TRAN V245654 = 174: 179: 178 = 177J
						V245654	ODAVE-30.6MMAVE-30.5IDAVE-30.3 HRC KCV -10DEG.C(10X10) TRAN V245654 = 159: 160: 144 = 154J



Analysis Type Type D'analyse Analyseart	Cast Number No. de coulée Schmelz-Nr.	Chemical Analysis % Analyse chimique de coulée %										Chemische Zusammensetzung %					
		C	SI	Mn	P	S	Cr	Mo	Ni	Al	Cu	Nb	Sn	Ti	V	B	
Ladle Check Check	V245654 V245654 V245654	0.27 0.26 0.25	0.24 0.26 0.26	0.54 0.51 0.51	0.012 0.016 0.017	0.004 0.005 0.006	1.04 0.97 0.96	0.50 0.48 0.48	0.08 0.08 0.08	0.039 0.049 0.04	0.04 0.04 0.04	0.000 0.021 0.019	0.000 0.005 0.005	0.021 0.021 0.022	0.02 0.03 0.03	0.002 0.003 0.003	

All test certificates issued by Vallourec Manufacturing Oil & Gas UK Limited have an embossed seal. Any recipient of a copy of a Vallourec Manufacturing Oil & Gas UK Limited test certificate without a seal should request Vallourec support that it is a true and accurate reproduction of the original. These results are certified by Vallourec Manufacturing Oil & Gas UK Limited and comply with the requirements of the Product

Tous les certificats émis par Vallourec Manufacturing Oil & Gas UK Limited ont un cachet. Tout détenteur d'une copie de certificat de Vallourec Manufacturing Oil & Gas UK Limited sans le cachet doit contacter le fournisseur pour s'assurer de l'authenticité de la copie. Ces résultats sont certifiés par Vallourec Manufacturing Oil & Gas UK Limited et sont conformes aux exigences de la description du produit.

All Vallourec Manufacturing Oil & Gas UK Limited Abrasivezeugnisse tragen ein eingestanztes Firmensiegel. Jeder Empfänger einer Kopie eines Vallourec Manufacturing Oil & Gas UK Limited Abstrahers ohne Siegel sollte den Hersteller kontaktieren, um sicherzustellen, dass es eine treue und genaue Reproduktion des Originals ist. Diese Ergebnisse sind von Vallourec Manufacturing Oil & Gas UK Limited bestätigt und entsprechen den Anforderungen der Erzeugnisbeschreibung.

Date 18-Dec-2014  
 (for Quality Manager)

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MOSEND, LANARKSHIRE ML4 2RR  
TEL: (0)1698 742300

Customer Client Besteller

Customer's Ref. No. de Commande  
PO 4410000026

Bestell-Nr.

Sales Ref. 0023014  
No. de Service Commercial Nr.  
Works No. 30408001  
No. d'usine  
Werks -Nr.

Product Description / Produkt  
HOT FINISHED SEAMLESS STEEL CASING  
VALLOUREC GRADE VM 125 CY  
Prüfgegenstand

Doc. Ref. No. Document No. Nr.  
Dok. Ref. Nr.  
Cert. No. 010/1451/0014  
No. du certificat  
Prüf Nr.



Carl No. 52974

Additional Test Results  
Résultats additionnels  
Weitere Prüfergebnisse

Item No No article Pos. Nr.	Description Beschreibung	R <sub>e</sub>		R <sub>m</sub>		A %		Hydro pressure Hyd. Prüfdruck Pression Hyd.		Cast Number No. de coulée Schmelz-Nr.		Additional Test Results Résultats additionnels Weitere Prüfergebnisse
		PSI	PSI	PSI	PSI	2IN. St.	PSI	H232085	Schmelz-Nr.			
1	VAM® 21 THREADED AND COUPLED CHECK TEST QUENCH AND TEMPERED BASIC OXYGEN STEEL IF LADLE ANALYSIS IS REPORTED AS 0.000 THEN NO INTENTIONAL ADDITIONS HAVE BEEN MADE QUALITY PLAN MIP/VMOG/001 INTERTEK INSPECTED	133435	144313	18	9200	20	9200	H232085	H232085	H232085	<p>UTRASONIC TESTED TO API SGT SR 2 ADDITIONAL NDE TESTING BY EMI LONGITUDINAL ROUND BAR TENSILE SPECIMEN AT ROOM TEMPERATURE RE = RT0.65 HYDROSTATIC DURATION 5 SECONDS SR16 TO S16-30-10 FULL LENGTH DRIFFED DRIFF DIAMETER = 12.250" CHARPY SHEAR &gt; 75J CIN. TEMPERING TEMP. = 560degC ODAVE-30.3MVAVE-30.7IDAVE-30.4 HRC KCVE = 10DEG C 110X101 TRAN 234J H232085 = 240; 233; 231 = 234J ODAVE-30.1MVAVE-29.9IDAVE-29.8 HRC KCVE = 10DEG C 110X101 TRAN 231J H232085 = 232; 227; 235 = 231J</p>	

IT IS CERTIFIED THAT, UNLESS OTHERWISE STATED, THE SUPPLIES DETAILED HEREON HAVE BEEN MANUFACTURED, INSPECTED AND TESTED IN ACCORDANCE WITH OUR QUALITY MANAGEMENT SYSTEM APPROVAL ISO 9001 AND CONFORM TO THE TERMS OF OUR ORDER ACKNOWLEDGEMENT.

Analysis Type Type D'Analyse Analyseart	Cast Number No. de coulée Schmelz-Nr.	Chemical Analysis %								Analysis chimique de coulée %							
		C	Si	Mn	P	S	Cr	Mo	Ni	Al	Cu	Nb	Sn	Ti	V	B	
Ladle Check Check	H232085 H232085 H232085	0.25 0.23 0.23	0.19 0.20 0.20	0.47 0.45 0.46	0.009 0.014 0.015	0.001 0.003 0.003	0.91 0.89 0.90	0.26 0.26 0.26	0.06 0.06 0.06	0.097 0.112 0.112	0.05 0.05 0.05	0.017 0.017 0.017	0.002 0.003 0.004	0.018 0.019 0.017	0.00 0.01 0.01	0.002 0.002 0.003	

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All Vallourec Manufacturing Oil & Gas UK Limited Abnahmezeugnisse tragen ein eingetragenes Prüfzeichen. Jeder Empfänger einer Kopie eines Vallourec Manufacturing Oil & Gas UK Limited Abnahmezeugnisses ohne dieses eingetragene Prüfzeichen sollte sich beim Verkäufer vergewissern dass es eine true und accurate Reproduktion des Originals ist. Diese Ergebnisse sind von Vallourec Manufacturing Oil & Gas UK Limited bescheinigt und entsprechen den Bedingungen der Erzeugnisbeschreibung.

Interetek  
Reviewed  
Initials  
Date 18/12/14

Date 16-Dec-2014  
(for Quality Manager)

CLYDESDALE WORKS, CLYDESDALE ROAD  
MOSSEND, LANARKSHIRE ML4 2RR  
TEL: (0)1698 742300

Customer Client Besteller

Customer's Ref. No. de Commande  
PO 4410000026

Bestell-Nr.

Sales Ref. No. de Service Commercial  
00230014

No. de Service Commercial  
30408001

Works No. d'usine  
-Nr.

Product Description  
HOT FINISHED SEAMLESS STEEL  
CASING  
VALLOUREC GRADE VM 125 CY

Doc. Ref. No. Document  
010/1451/0014

Dok. Ref. No. certifiant  
010/1451/0014

Prüf Nr.



Cert No. 230374

Item No No d'ordre Pos.-Nr.	Description Description Beschreibung	R e		R m		A %		Hydro pressure Hyd Prüfdruck Pression Hyd		Cast Number No. de coulée Schmelz-Nr.	Additional Test Results Résultats additionnels Weitere Prüfergebnisse
		PSI	MPa	PSI	MPa	21N	So	PSI	MPa		
1	13.625 IN OD X 0.625 IN	129084	141267	22	9200	H232085 H232085	ODAVE-31.6MMWAVE-30.8IDAVE-31.1 HRC KCV - -10DEG.C(10x10) TRAN H232085 = 208; 201; 202 = 204J				
		130099	141267	21	9200	H232085 H232085	ODAVE-31.0MMWAVE-31.2IDAVE-31.4 HRC KCV - -10DEG.C(10x10) TRAN H232085 = 237; 240; 232 = 236J				
		130969	141702	20	9200	H232085 H232085	ODAVE-31.9MMWAVE-31.9IDAVE-31.8 HRC KCV - -10DEG.C(10x10) TRAN H232085 = 217; 217; 222 = 219J				
		130534	141412	19	9200	H232085 H232085	ODAVE-29.3MMWAVE-29.6IDAVE-29.5 HRC KCV - -10DEG.C(10x10) TRAN H232085 = 198; 211; 203 = 204J				
		128214	138946	19	9200	H232085 H232085	ODAVE-29.7MMWAVE-29.8IDAVE-28.6 HRC KCV - -10DEG.C(10x10) TRAN H263472 = 279; 218; 224 = 224J				



IT IS CERTIFIED THAT UNLESS OTHERWISE STATED THE SUPPLIES DETAIL HEREON HAVE BEEN MANUFACTURED, INSPECTED AND TESTED IN ACCORDANCE WITH THE QUALITY MANAGEMENT SYSTEM APPROVAL, ISO 9001 AND CONFORM TO THE TERMS OF OUR ORDER ACKNOWLEDGEMENT

Analysis Type Type d'analyse Analyseart	Cast Number No. de coulée Schmelz-Nr.	Chemical Analysis %										Analysis chimique de coulée %										Chemische Zusammensetzung %									
		C		Si		Mn		P		S		Cr		Mo		Ni		Al		Cu		Nb		Sn		Ti		V		B	
Ladle Check	H263472	0.23	0.18	0.47	0.001	0.001	0.92	0.26	0.06	0.096	0.05	0.017	0.002	0.015	0.00	0.002															
Check	H263472	0.22	0.19	0.46	0.018	0.002	0.92	0.25	0.06	0.111	0.05	0.017	0.004	0.015	0.01	0.003															
Check	H263472	0.22	0.19	0.46	0.018	0.003	0.90	0.26	0.06	0.108	0.05	0.017	0.004	0.015	0.01	0.003															

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Alle testcertificaten uitgegeven door Vallourec Manufacturing Oil & Gas UK Limited hebben een ingedrukt zegel. Indien u een kopie van een testcertificaat van Vallourec Manufacturing Oil & Gas UK Limited ontvangt zonder een zegel, moet u ervoor zorgen dat de afzender een juiste en nauwkeurige reproductie van het origineel is. Deze resultaten worden gecertificeerd door Vallourec Manufacturing Oil & Gas UK Limited en voldoen aan de eisen van het Product

Aller Vallourec Manufacturing Oil & Gas UK Limited Administrationsskriver bærer en indpreget sigil. Hvis du modtager en kopi af et Vallourec Manufacturing Oil & Gas UK Limited testcertifikat uden et sigil, bør du sikre dig fra leverandøren, at det er en rigtig og nøjagtig gengivelse af det originale. Disse resultater er certificeret af Vallourec Manufacturing Oil & Gas UK Limited og overholder produktets krav

Date 16-Dec-2014  
(for Quality Manager)

CLYDESDALE WORKS, CLYDESDALE ROAD  
MOSEND, LANARKSHIRE ML4 2RR  
TEL: (0)1698 742300

Sales Ref: 0023014  
No. de Service Commercial: 0023014  
Verkaufs Nr.: 0023014  
Works No. 30408001  
No. d'usine: 30408001  
Werks -Nr.: 30408001  
Doc. Ref. No. 010/1451/0014  
Document: 010/1451/0014  
Dok. Ref. Nr.: 010/1451/0014  
Cert. No.: 010/1451/0014  
No. du certificat: 010/1451/0014  
Prüf Nr.: 010/1451/0014



BSI Registered Supplier  
Cert No. 53074

Customer: Client: Besteller:

Customer's Ref. No. de Commande: PO 4410000026  
Product Description: Product: HOT FINISHED SEAMLESS STEEL  
Prüfgegenstand: CASING  
VALLUREC GRADE VM 125 CY

Item No d'article Pos-Nr	Description Beschreibung	R e		A %	Hydro pressure Hyd Prüfdruck Pression Hyd		Cast Number No de coulée Schmelz-Nr.	Additional Test Results Résultats additionnels Weitere Prüfergebnisse
		PSI	PSI		2 IN Sq	PSI		
1	13.625 IN OD X 0.625 IN	130099	141267	20	9200	9200	H263472 H263472	ODAVE-31.2MMAVE-30.91DAVE-30.8 HRC KCV - -10DEG.C(10x10) TRAN H263472 = 212: 211: 208 = 210J
		131114	141847	21	9200	9200	H263472 H263472	ODAVE-31.3MMAVE-30.41DAVE-30.5 HRC KCV - -10DEG.C(10x10) TRAN H263472 = 202: 199: 207 = 203J
		130824	142282	21	9200	9200	H263472 H263472	ODAVE-29.6MMAVE-29.51DAVE-30.0 HRC KCV - -10DEG.C(10x10) TRAN H263472 = 217: 220: 216 = 218J
		132420	142717	19	9200	9200	H263472 H263472	ODAVE-30.4MMAVE-30.31DAVE-30.4 HRC KCV - -10DEG.C(10x10) TRAN H263472 = 222: 219: 219 = 219J
		131985	142572	19	9200	9200	H263472 H263472	ODAVE-29.5MMAVE-29.31DAVE-29.2 HRC KCV - -10DEG.C(10x10) TRAN H263472 = 205: 218: 220 = 214J

Intertek  
Reviewed  
Date: 21/08/14

Analysis Type Type D'Analyse	Cast Number No. de coulée	Chemical Analysis %		Analysis chimique de coulée %		Chemische Zusammensetzung %	
Analysenart	Schmelz-Nr.						

All test certificates issued by Vallourec Maintenance Oil & Gas UK Limited have an embossed seal. Any recipient of a copy of a Vallourec Maintenance Oil & Gas UK Limited test certificate without a seal should ensure from the recipient of the original. These results are certified by Vallourec Maintenance Oil & Gas UK Limited and comply with the requirements of the product.

Tous les certificats émis par Vallourec Maintenance Oil & Gas UK Limited portent un cachet. Tout détenteur d'une copie de certificat de Vallourec Maintenance Oil & Gas UK Limited sans le cachet doit contacter le fournisseur pour s'assurer de l'authenticité de la copie. Ces résultats sont certifiés par Vallourec Maintenance Oil & Gas UK Limited et sont conformes aux exigences de la description du produit.

Aller Vallourec Maintenance Oil & Gas UK Limited. Adapter les exigences de l'analyse. Travaux de certification. Interrogation. Jeder Empfänger einer Kopie eines Vallourec Maintenance Oil & Gas UK Limited Zertifikats ohne Firmenstempel soll sich beim Verkäufer vergewissern, dass es sich um eine Kopie des Originals handelt. Diese Ergebnisse sind von Vallourec Maintenance Oil & Gas UK Limited bescheinigt und entsprechen den Bedingungen der Beschreibung.

Date: 16-Dec-2014  
(for Quality Manager)