

INSPECTION REPORT

Requested by	Felipe Vilas Botana RELESA
Seller / Supplier	
Manufacturer	RELESA
Inspection Location	Ctra. Fuente Alamo –Las Palas, Km. 3,5. 30320 Fuente Alamo, Murcia. España
Date / Period of inspection	08.11.2015
Inspector's name	RAQUEL OLMO
Equipment / Material inspected	ELECTROWELDING PROCESS
Project name	
Client reference number	
Manufacturer internal work order	
Other reference	

SCOPE

Inspection Scope	Sampling / Criteria applied	Result*
Visual Qualitative Verification	100%	CONFORM
Quantitative Verification	NA	NA
Test Witnessing	PENDING	PENDING
Document Review	100%	CONFORM
Marking Verification	NA	NA

* 1. Conform // 2. Not Conform // 3. Pending // 4. Subject to client's evaluation.

1. NON CONFORMITY

Not applicable

2. EQUIPMENT / MATERIAL INSPECTED

SGS inspected the manufacturing process developed automatically, on the L4 line .

3. REFERENCE DOCUMENTS

- I.T 22. Ed. 4: Instrucción técnica para la fabricación de rejilla electrosoldada en la E.V.G. (L4).
- I.T.01. Ed. 4: Instrucción técnica para la compra y recepción del fleje.
- I.T.02. Ed.4: Instrucción técnica para la compra y recepción del alambre.
- I.T.07. Ed.6: Instrucción técnica para la inspección en negro.
- I.T.19. Ed.5: Instrucción técnica para la fabricación en el robot de oxicorte.

5. INSPECTION ACTIVITIES

SGS inspector witnessed the manufacturing process of electrowelded grating, developed in L4.

The description of the process is documented in the technical instruction, IT 22: technical instruction for the production of electrowelded grating in E.V.G. (L4), performed by the manufacturer and which forms part of its quality management system.

JOINING PROCESS OF THE BEARING BARS-TRANSVERSE BARS

During the inspection, it was verified that the process of joining (bearing bars- transverse bars), is made by welding to fusion, without filler material, forming one body with the union.

The heat required to carry out welding to the melting temperature, is obtained by means of electrical energy, and by pressure. The manufacture process gets penetration of bearing bars with transverse bars. This pressure is constantly measured by the manometer installed on the machine itself, which is verified by the EC-04 gauge.

Additionally, and in those parts that require it, the resulting mesh can be trimmed by flame cutting, and then applies the framework of closing, by means of a mounting plate with the same characteristics to the grating

JOINING PROCESS OF THE FRAMES

The welding process inspected (the grille perimeter, formed by plate), is performed by identical welding process to the one described for bearing bars-transverse bars.

6. INSTRUMENTS USED

Instrument	Nº Reference	Calibration Date
Manometer	EC-04	26/02/2014 Certificado nº 77/14 CTM.

7. CONCLUSION

On the basis of our findings at the dates and place of our inspection, it is found that the permanent joining process carried out by RELESA, in its line of production L-4, coincides with the characteristics that identify and define a process of welding by electric resistance.

The above reflects our findings at time and place of inspection. This certificate does not relieve sellers/suppliers from their contractual responsibilities nor does it prejudice buyers' right of claim toward sellers/suppliers for compensation for any apparent and/or hidden defects not detected during our random inspection or occurring thereafter.

Above findings are limited to date and place of intervention only.

Realizado por: RAQUEL OLMO
Función: INSPECTOR
Industrial Services Division
SGS
Fecha: 08/10/2015

