

Ameritube Case Studies

Recent projects completed by Ameritube

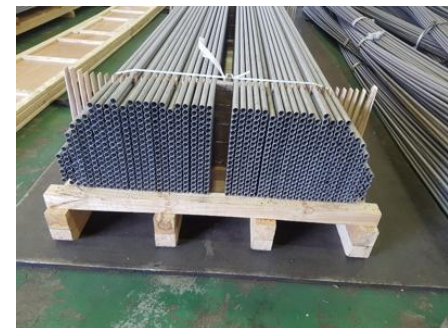




Duplex Bundles for Motiva

- 14 U-Bend bundles with difficult testing, bending and annealing requirements:

1. MTR's will be provided for final and raw material.
2. PMI 10% per heat confirmed by Ameritube. PMI equipment model, calibration certificate to be provided with the quote
3. Electric resistance stress relieve of U-Bends + 6" of straight length of rows 1& 2 (39 U's only) @ 1870-2010 degrees F for 15 seconds with water quench or forced air cooling. The tube surface shall be free of heat tint or surface oxides. Clamp areas shall be free of arc is not acceptable.
4. ASTM A923 test method C Ferric Chloride Corrosion test) would be done and meet the given criteria by third party
5. Repair of tube dents is not permitted. Repair welding of tube is not permitted.
6. Eddy current test per SA-789.
7. Tube hardness shall not exceed rockwell C28.
8. One specimine 1in LG from each lot shall be checked for detrimental intermetallic phases per ASTM A923 test methods A&C.
9. Testing according to ASTM A923 to be done at ISO 17025 certified labaratory. Identical samples to be send via express mail to Ameritube LLC address.
10. Proposal is in conformance with bend schedule and requirements specified in the notes.
10. Quality system to be approved by Ameritube representative
11. Samples and MTRs to be provided as soon as raw material received, after material processed with 2 nd Invoice prior to shipment from Busan, Korea.
12. Raw material MTR to be provided at time of receipt and testing of Korean raw material.
13. NITROGEN CONTENT SHALL BE 0.14% MIN & THE PRE(N) OR PRE(W) TO BE 34 MIN.
14. MAXIMUM SULPHUR SHALL BE 0.010%



SA249 316/316L Bundles for Praxair



1. U-BENDS PLUS 12" TANGENT SHALL BE SOLUTION ANNEALED AFTER BENDING.
BEND ANNEAL TEMP AT 1950 DEGREES F.
2. TUBES TO MEET SUPPLEMENTAL REQUIREMENTS OF SA-249 S8
3. WELDED TUBES SHALL BE SUPPLIED IN THE SOLUTION ANNEALED CONDITIONS AND TESTED PER ASTM E426(EDDY CURRENT TESTING) OR SUPPLEMENTAL REQUIREMENTS SA-249 S9 (ADDITIONAL TESTING OF WELDED TUBING FOR ASME SECTION I).
4. NDE REPORT REQUIRED
5. FOLLOWING TESTING SHALL BE PERFORMED PER HEAT NO. TEST SHALL BE PERFORMED BY TUBE VENDOR PER ASTM 262 PRACTICE A AND EPR METHOD TEST PER ASTM G108. AFTER SAMPLES HAVE PASSED TESTING, VENDOR SHALL SUPPLY TWO(2) 6"LG SECTIONS OF TUBE SAMPLE FROM EACH HEAT NUMBER
6. TUBES TO BE 316L/316 DUAL CERTIFIED
7. NO CHINESE MATERIAL ALLOWED
8. ALL DIMENSIONS ARE +/- 1/16"



Ameritube LLC Projects

Customer	Country	Amount	Tubes	Year
Ohmstede	TX	\$ 725,000.00	14000	2007
Grand Bahama Power	Bahamas	\$ 265,000.00	3600	2010
Edgen Murray - PDVSA	Venezuela	\$ 2,200,000.00	12000	2010
Venmar	Venezuela	\$ 465,000.00	4500	2012
STI	TX	\$ 309,500.00	4600	2014
MeadWestVaco	TX	\$ 205,000.00	3655	2014
Ataqa Power Station	Egypt	\$ 642,000.00	14000	2015
Dow Chemical	TX / LA	\$ 664,000.00	1200	2015
Nuclear Customer	PA	\$ 300,000.00	1500	2015
Elta Systems Ltd.	Israel	\$ 431,000.00	3500	2015
Consumer's Energy	MI	\$ 703,000.00	7300	2017
Metalforms	TX	\$ 1,850,000.00	5500	2019
Koch Heat Transfer	Canada	\$ 320,000.00	3500	2019
Metalforms	TX	\$ 178,000.00	1925	2019