


# Inspeksjonsrapport

## Inspection Report



<b>Oppdragsgiver</b> <i>Client</i> Static Seals AS Rådmann Friis vei 45, 3610 Kongsberg		<b>Utførende enhet/lab.</b> <i>Department/laboratory responsible</i> Kiwa AS PB 1019 3601 KONGSBERG	
<b>Rapportnr.</b> <i>Report no.</i> <b>25NO-00105OR01</b>			
<b>Tittel</b> <i>Title</i> <b>Third party verification of VAKUUM test according to EN-545 on ductile cast iron pipe with dimension DN300. At Ulefos Esco AS.</b>			
<b>Inspeksjon utført ...</b> <i>Inspection performed...</i> - i felt <i>In field</i> JA - i fabrikk i produksjon <i>in fabric in production</i> Nei No	<b>Inspeksjon utført av</b> <i>Inspection performed by</i> Asgeir Haukaas 		<b>Dato for utført inspeksjon</b> <i>Date of inspection</i> 23.1.2025 <b>Prøvetaking utført av Kiwa</b> <i>Sampling by Kiwa</i> Nei No
<b>Revisjonsnr.</b> <i>Revision no.</i> -	<b>Konfig.kont.</b> <i>Config.contr.</i> Ja Yes	<b>Antall sider</b> <i>No. of pages</i> 6	<b>Ant. vedlegg</b> <i>No. of append.</i> 1 (calibration report)
<b>Kopi nr.</b> <i>Copy no.</i>	<b>Dato</b> <i>Date</i> 7.2.2025	<b>Kundens ref.</b> <i>Client's ref.</i> Anders Nygård	<b>Bestillingsnr.</b> <i>Order no.</i> Etter avtale
<b>Fordeling</b> <i>Distribution</i> Klient: PDF Kopi 1: Kiwa TI 3000			

Inspeksjonsresultater gjelder utelukkende de inspiserte objekter. Utdrag av rapporten må ikke gjengis uten skriftlig godkjenning fra Teknologisk Institutt as.

Inspection results relate only to the items inspected. The report shall not be reproduced except in full, without the written approval of the laboratory.

### Innhold

1. Summary.....	2
2. Reference documents .....	3
• Standard: EN 545:2010 - Ductile iron pipes, fittings, accessories and their joints for water pipelines - Requirements and test methods.....	3
3. Start and stop for test .....	3
4. Photos.....	4
5. Conclusion .....	4

## 1. Summary

Static Seals AS has engaged Kiwa AS to verify a vacuum test between two flanges with Dn 300

Two flanges set up with vacuum. The minimum time for a vacuum test is 2 hours without any leakage being detected.

Gauge manometer was calibrated: 14.1.2025

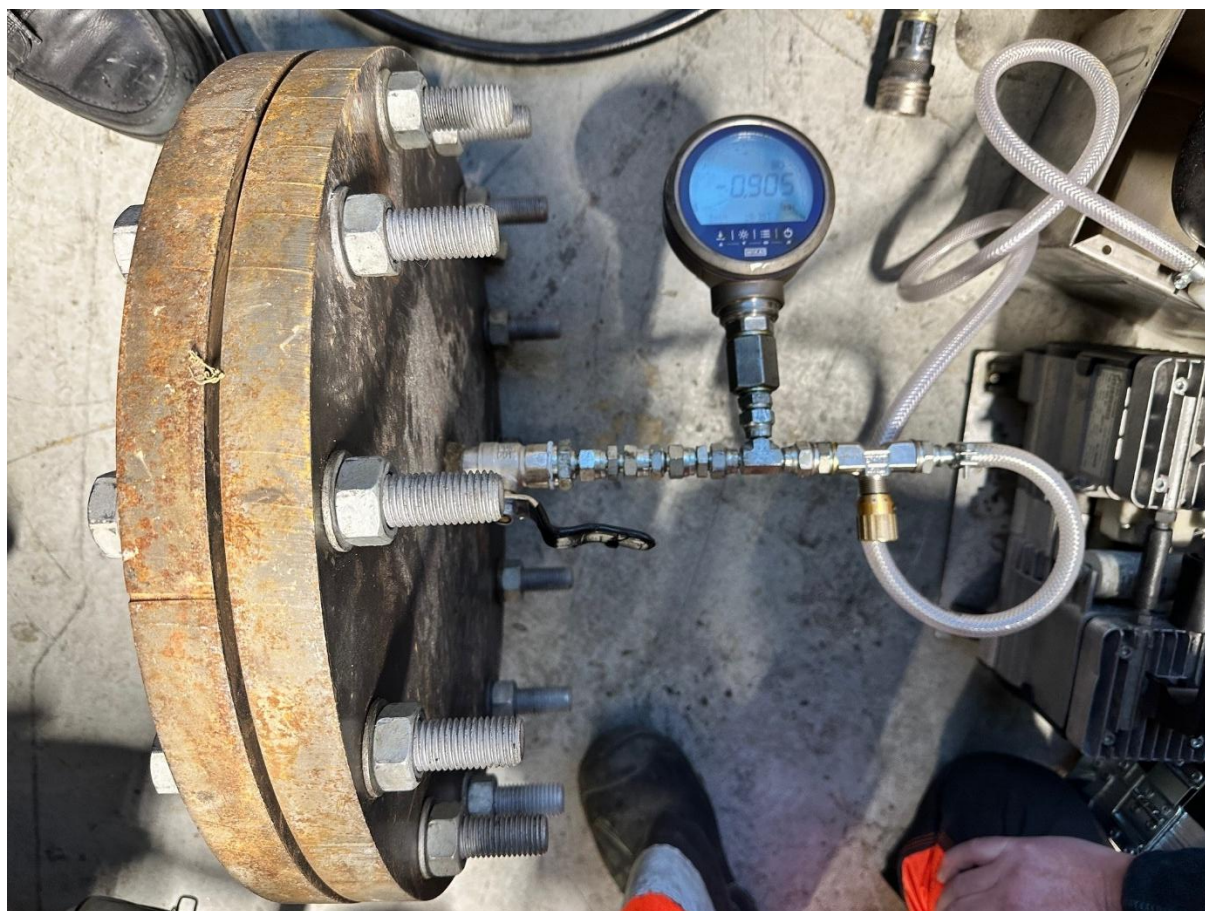


Photo 1. Type of test. Two flanges set up with vacuum.

## 2. Reference documents

- Standard: EN 545:2010 - Ductile iron pipes, fittings, accessories and their joints for water pipelines - Requirements and test methods
- Flanges: DN 300 , EN 1092, PN 10
- Gasket: The gasket is in accordance with EN 1514. The rubber part is in drinking water approved EPDM in accordance with EN-681. The hard part is in glass-filled PP (PP-GF40)

## 3. Start and stop for test

Start test: 22.1.2025 kl 13:50

Stop test: 23.1.2025 kl 11:00

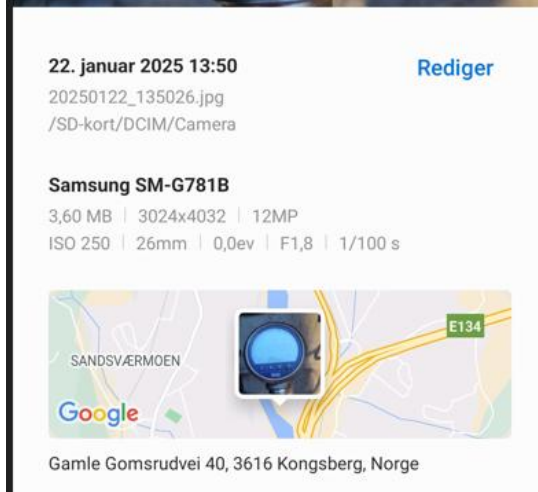


Photo 2. Start test: 22.1.2025 kl 13:50

Photo 3. Stop test: 23.1.2025 kl 11:00

#### 4. Photos



Photo 4. Gasket Dn300

#### 5. Conclusion

Vacuum test of gasket shows no leakage after minimum of 2 hours. The test meets the requirements of EN 545:2010

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Rapportnr. Report no.  
25NO-00105OR01  
Revisjonsnr. Rev.nr. -  
Vedlegg Appendix 1  
Dato Date 7.2.2025



### Appendix 1 page 1 of 2, Calibration report

Dinformation		VATEM01	
2025-01-14			
Test	VATEM01		
NameSort	Afriso		
GaugeType	Manometer		
Status			
Placering	Drift		
Lagerplats	Test avd		
Noggrannhet	+/- 1bar		
Måtområde	0-40bar		
Inkøpsdatum	2025-01-14 07:56:20		
Levereras av/avd	Tech Instrument A/S		
Inkøpspris	200,00 kr		
Account			
Kalibreras av/avd	Målerommet		
Kal. intervall (#1)	182	Næsta kal. (1)	2025-07-15 00:00:00
Return date(2)		Returdatum (2)	
Reminder (3)		Påminnelse (3)	
Senaste ændring	2025-01-14 00:00:00	S:a kal. kostnader	

Noteringar

# Inspeksjonsrapport

## Inspection Report

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25NO-00105OR01  
Revisjonsnr. Rev.nr. -  
Vedlegg Appendix 2  
Dato Date 7.2.2025



Appendix 1 page 2 of 2, Calibration report

### Kalibreringsprotokoll

VATEM01

2025-01-14

Typ	Manometer	Kalibreres av/avd	Målerommet
Status		Date	2025-01-14
Placering	Drift	Referens/likare nr.	
Lagerplats	Test avd	Registrert av	Administrator
Konto			

#### Notes to log:

Under kalibrering ble det brukt Digital pressure indicator ID-MRT101 og Pneumatic/Hydraulic Hand-Pump ID-MRT101

Egenskap	Max	Min	Unit	Resultat	Anmärkning
1) Kontr. mot testmanom.10bar	11,0000	9,0000	bar	10,0020	OK
2) Kontr. mot testmanom.16bar	17,0000	15,0000	bar	16,0030	OK
3) Kontr. mot testmanom.24bar	25,0000	23,0000	bar	24,0020	OK
4) Kontr. mot testmanom.2 bar	2,2000	1,8000	bar	2,0000	OK