



230020349788



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TESTING

CNAS L0891

# TEST REPORT

No. of Report: JCBG (01) 250511133

Name of Sample : CSL Pipe

Client : Changzhou Cheeron Construction Machinery Equipment Co., Ltd.

Test Category : Commissioned Testing



China Steel Group Zhengzhou Metal Products Research Institute Co., Ltd.

National Metal Products Quality Inspection and Testing Center





## Test Report

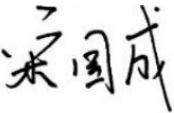
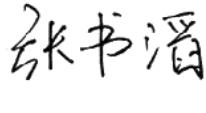
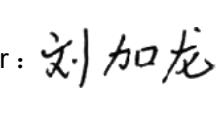
No. of report: JCBG(01)250511133

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Client	Changzhou Cheeron Construction Machinery Equipment Co., Ltd.		
Supervisory Entity*	---		
Project Name*	---		
Project Component*	---		
Manufacturing*	Changzhou Cheeron Construction Machinery Equipment Co., Ltd.		
Name of Sample	CSL Pipe	Sample Commission Number	JC(01)250512294
Type/Model	SCG50*3.0	Rebar Grade	Q235B
Sample Quantity	Base material: 2*1.5m, 2*0.5m; joint: 6 * 0.7m	Batch Number/ID*	---
Representative Quantity*	---	Sample Characteristics	No obvious visual defects
Testing Category	Commissioned testing	Commission Date	2025-05-12
Commissioning Party	Cheng Li	Witness	---
Sample Receipt Date	2025-05-20	Test Completion Date	2025-05-27
Test Based on	1. GB/T 31438-2015 <i>Thin-Walled Steel Acoustic Tubes for Concrete Cast-in-Place Piles</i> 2. GB/T 228.1-2021 <i>Metallic Materials - Tensile Testing - Part 1: Method of Test at Room Temperature</i> 3. GB/T 246-2017 <i>Metallic Materials - Tube Flattening Test Method</i> 4. GB/T 244-2020 <i>Metallic Materials - Tube Bending Test Method</i> 5. GB/T 7735-2016 <i>Automatic Eddy Current Testing for Imperfections in Seamless and Welded (Excluding Submerged Arc-Welded) Steel Tubes</i>		
Criteria Based on*	GB/T 31438-2015 <i>Concrete Cast Pile Steel Thin Wall Acoustic Test Tube</i> and customer requirements		
Testing Items	Testing items see page 2		



Testing Conclusion	The test items of the submitted samples meet the requirements of GB/T 31438-2015 and customers' needs.
Remarks	<p>1. Client Requirements: GB/T31438-2015 does not contain specifications for this model. The client requires testing and evaluation in accordance with this standard. Seal integrity test requirements: 1MPa internal pressure for 1 minute, external pressure 4MPa. 1mm/min. E4H eddy current testing acceptance grade, with two specimens required.</p> <p>2. Eddy current testing is a subcontracted service. Our organization has not been authorized to subcontract to Anhui Huaxia High-Tech Development Co., Ltd. (CMA No. : 211221340589, valid until February 7, 2027). Eddy current acceptance grade E4H.</p>

Approval :  Verification:  Chief tester: 



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No.	Testing Item	Unit	Technical Requirements	Testing Result	Single Determination
1	Appearance quality (defect inspection)	/	Acoustic tubes must be free from cracks, scars, folds, laminations, and lap weld imperfections; scratches, scuff marks, and misalignments of longitudinal weld seams in tube sections shall not exceed 0.1 mm.	None of the six test samples showed cracks, knots, folds, delamination, or lap welding defects; none showed scratches, scraping marks, or longitudinal misalignment of the pipe joint welds.	Qualified
2	Tensile Strength	MPa	≥315	428;416	Qualified
3	Elongation	%	≥14	26.5;25.0	Qualified
4	Compression Resistance	/	When the distance between the plates is 75% of the outer diameter of the CSL pipe, no crack should appear in the CSL pipe.	When the distance between the plates is 75% of the outer diameter of the CSL pipe, no cracks appear in both specimens.	Qualified
5	Bending Resistance (bending radius 6D/45° )	/	CSL pipe should not be cracked.	No cracks were observed in either specimen.	Qualified
6	Sealability	Internal Pressure Test (1MPa;1min)	/	No leakage and joint deformation shall occur.	No leakage at the joint, no deformation of the interface
		External Pressure Test (4MPa;1min)	/	No leakage and joint deformation shall occur.	No leakage at the joint, no deformation of the interface
7	Wall Thickness	mm	3.0±0.15	3.14;3.15	Qualified

8	Dimensional Variation	External Diameter	mm	$\pm 1.00$	$+0.22; +0.31$	Qualified
		Wall Thickness		$\pm 0.15$	$+0.14; +0.15$	
9	External Diameter		mm	$50 \pm 1.00$	$50.22; 50.31$	Qualified
10	Tear Tests		/	At room temperature, it should be able to withstand the drawing force of 3000N, and the connection part will not be loose or broken after 60min.	At room temperature, the two specimens are subjected to a drawing force of 3000N for 60min, and the connection part of both specimens is not loose or broken.	Qualified
11	Anti-Rolling Performance		/	The CSL pipe joint does not slip for 10 minutes when the torque is $120N \cdot m$ .	Two CSL pipe joints were continuously connected for 10min at a torque of $120N \cdot m$ , and no slip occurred in the joints.	Qualified
12	Eddy Current Inspection		/	No signal higher or equal to the trigger/alarm level.	No signal higher than or equal to the trigger alarm level was found in the two sample eddy current tests.	Qualified

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## Testing Report Notes

1. The report is invalid without the official "Inspection Seal" on the cover, first page, and cross-page seams.
2. The report may not be reproduced without written approval (except for complete reproduction).
3. The report is invalid without the signatures of the chief inspector, reviewer, and approver.
4. Any alterations to the report render it invalid.
5. Any objections to the testing report must be raised with the testing agency within 15 days of receipt. Failure to raise objections within this period is deemed acceptance of the test results.
6. When this agency is not responsible for sampling, it is only accountable for the samples received.
7. For tests commissioned by the client, items marked with an asterisk (\*) in the report are provided by the client, and this agency does not bear responsibility for verifying their accuracy.
8. Samples required to be retained per contract must be collected within 15 days of receiving the testing report. Samples not collected within this period will be handled according to the agency's internal policies.

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