

ICS 25.020

Supersedes
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Introduction

The manufacturing requirements specified in this part of SN 200 are used to achieve the relevant SMS product quality. Consequently, these requirements must always be satisfied unless otherwise stipulated in drawings, purchase order documents, and/or other manufacturing documents. This standard is indicated as a binding document in drawings (title blocks), contracts and/or purchase order documents. If the requirements cannot be fulfilled, SMS group must be consulted.

1 Scope

This company standard specifies for SMS group the requirements to be fulfilled for the performance of product/material inspections.

2 Normative references

The following documents, which are quoted here either in whole or in part, are required for the application of the present document. Dated references refer only to the date of the edition indicated. Undated references refer to the most recent edition of the respective document including all revisions.

DIN EN 10204:2005-01	Metallic products - Types of inspection documents; German version
DIN EN 13018	Non-destructive testing; Visual testing; General principles
SN 200-1	Manufacturing instructions; Requirements and principles
ISO 10474:2013-07	Steel and steel products - Inspection documents

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3 Warranty

The manufacturer/supplier shall warrant the proper execution of all his supplies and services.

He is responsible for compliance with the regulations concerning hazardous materials and environmental protection as per [SN 200-1](#) and for material grade/quality, proper execution of welding, dimensional accuracy, proper surface condition, treatment processes etc. SMS group reserves the right to carry out examinations. The examination by the SMS group Quality Assurance department does not relieve the manufacturer/supplier of his warranty obligations.

4 Inspection/Testing

4.1 Inspection specifications

4.1.1 Cleanliness

Each manufacturer is responsible for ensuring that no machining residues (e.g. welding slag, loose burr, chips, drill emulsions etc.) are left on the product. The clean condition shall be guaranteed by visual examination according to [DIN EN 13018](#).

4.1.2 Performance of non-destructive testing

For the non-destructive testing of components written testing instructions shall be drawn up and consider all requirements made by SMS group e.g. on drawings or in specifications.

4.1.3 Component parts

Inspection specifications for component parts are stated on the relevant drawings, in the purchase orders and in the individual parts of this series of standards ([SN 200-1 to -8](#)); the scope of inspection depends on the scope of supplies and services of the respective manufacturer.

For special component parts, delivery and inspection instructions are available as component-specific SN standards which are binding when indicated on the pertaining drawing. In exceptional cases, additional inspection schedules for component parts are drawn up by the SMS group Quality Inspection department and made available to the manufacturers together with the drawings and ordering documents.

4.1.4 Assembled units

Given the wide range of products of SMS group, it is not possible to specify standard inspection instructions for assembled units (assemblies) within the scope of this SN.

Manufacturers of assembled units are therefore bound to contact the SMS group Quality Inspection department for coordination of the relevant inspection activities. For the most part, the scopes of assembly and inspection are shown in specific schedules, which are made available to the manufacturers and represent constituent parts of this series of standards ([SN 200-1 to -8](#)). Within the scope of these inspections, the minimum requirements for inspection are functional and movement tests of oscillating and rotating parts.

4.1.5 Intermediate and final inspection

All features produced by the manufacturer shall be examined by the manufacturer/supplier himself.

Independently of the manufacturer's obligation to draw up records, the SMS group quality inspectors shall have the right to check the fulfillment of all features or to demand proof of fulfillment to be furnished by the manufacturer. If inevitable, destructive testing shall be permitted for this purpose and the manufacturer shall carry out such testing if so requested by the quality inspector of SMS group.

4.2 Special inspection specifications

Equipment according to [DIN EN 1090](#) or Directive [2014/68/EU](#) or other national regulations/directives such as technical standards, codes and regulations (e.g. (TR) Russia, GB or ASME etc.) shall be inspected/tested for acceptance as specified in the legal prescriptions or prescriptions having legal character. Country-specific regulations are indicated in the ordering documents and shall be complied with.

4.3 Inspections by the end user

Inspections contractually agreed between SMS group and the customer will be notified to the manufacturer in the respective manufacturing documents.

5 Inspection documentation

5.1 Basic specifications

5.1.1 Results of the inspections by the supplier / manufacturer

Recording of the inspection results shall be made in accordance with the instructions and on the basis of the criteria stated in the drawings, the purchase orders and in the individual parts of this series of standards (SN 200-1 to -8). Inspection records and certificates shall be drawn up in German and/or English.

For clear identification, SMS group requires that the purchase order number, serial number (if available), WBS number, material number, quantity, order item and the designation of the part are indicated in all documents.

All inspections performed on the basis of the inspection instructions given in the individual parts of this SN shall be documented and the desired and the actual values stated in the records.

All records whose presentation is specified in this SN 200 are constituent parts of the scope of order and supply. When inspection records are missing or not complete, payments will be withheld by SMS group.

The original records shall be presented to the inspector of the SMS group Quality Inspection department at his visit to the manufacturer's works and handed over or sent to him as stipulated in the purchase order or agreement.

If SMS group does not carry out an inspection at the manufacturer's works, the original records shall be sent to the SMS group department of Quality Inspection.

5.1.2 Results of the intermediate and final inspection by employees of the SMS group

All features tested/examined within the scope of intermediate or final inspection shall be recorded by the SMS group quality inspector or documented by him on the record drawn up by the manufacturer.

5.1.3 Component parts

If the drawing stipulates identification marking of every single component part (e.g. by stamping figures or engraving), the actual values of every single component part shall be documented (one record for every part). For parts with a quantity > 1, which do not receive an identification marking, a recording of the actual values of the respective max. and min. dimensions (i.e. one record per lot with values from ... to ...) is sufficient.

5.1.4 Assembled units

The inspection records of assembled units shall state the desired and the actual values.

5.1.5 Structure and layout of the inspection documents

The supplier shall record the inspection results on inspection documents which correspond to the specifications of SMS group. The specifications can be requested when required. It shall be ensured that the records can be assigned to the manufacturing documents of SMS group. The original records shall be prepared in DIN A4 format.

5.2 Inspection documents according to DIN EN 10204 or ISO 10474

5.2.1 Basic specifications

As a general rule, inspection documents according to DIN EN 10204:2005-01 and/or ISO 10474:2013-07 shall be prepared as specified in the manufacturing documents, see Annex A (informative).

If payments by SMS group or its customers depend on the handover of inspection documents, an inspection certificate type 3.2 as per DIN EN 10204:2005-01 and/or ISO 10474:2013-07 shall be drawn up by the manufacturer in cooperation and mutual agreement with the SMS group quality inspector instead of an inspection certificate type 3.1 as per DIN EN 10204:2005-01 and/or ISO 10474:2013-07.

5.2.2 Blank parts and semi-finished products

The results of non-specific inspections of blank parts and semi-finished products which are not subject to specification as per SN 200-2 shall be confirmed by the manufacturer in a test report 2.2 as per DIN EN 10204:2005-01 and/or ISO 10474:2013-07 to prove compliance with the order. The inspection results for materials based on ASME, GB/T or other national standards shall be confirmed in an inspection certificate in conformity with the applicable national standards and proving compliance with the order.

5.2.3 Component parts

For component parts, at least the inspection records stipulated in the individual parts are required, if there are no special requirements included in the manufacturing documents.

For specific inspections, an inspection certificate 3.1 DIN EN 10204:2005-01 and/or ISO 10474:2013-07 shall be drawn up, and the test records of the component parts shall be attached to the certificate.

5.2.4 Assembled units

For assembled units for which no special requirements are made in the manufacturing documents, the minimum requirement is a document type 2.1 "Declaration of compliance with the order" as per [DIN EN 10204:2005-01](#) and/or [ISO 10474:2013-07](#). For specific inspections, an inspection certificate 3.1 DIN EN 10204:2005-01 and/or ISO 10474:2013-07 shall be drawn up and the test records of the assembled units shall be attached to the certificate.

5.3 Safekeeping of inspection documents

The suppliers shall undertake to archive the inspection documents for 10 years and make them available to SMS group only when so requested in the ordering documents.

Annex A (Informative)

Overview of inspection documents according to DIN EN 10204

Table A.1 shows the types of inspection documents according to [DIN EN 10204:2005-01](#) and their designations in German, English and French.

Table A.1 – Types of inspection documents according to DIN EN 10204:2005-01

Designations of the document types according to EN 10204				Contents of the document	Validation of the document by
Art.	German	English	French		
2.1	Werksbescheinigung	Declaration of compliance with the order	Attestation de conformité à la commande	Confirmation of compliance with the order	the manufacturer
2.2	Werkszeugnis	Test report	Relevé de contrôle	Confirmation of compliance with the order with indication of the results of non-specific inspection	the manufacturer
3.1	Abnahmeprüfzeugnis 3.1	Inspection certificate 3.1	Certificat de réception 3.1	Confirmation of compliance with the order with indication of the results of specific inspection	the manufacturer's authorized inspector who is independent of the manufacturing department
3.2	Abnahmeprüfzeugnis 3.2	Inspection certificate 3.2	Certificat de réception 3.2	Confirmation of compliance with the order with indication of the results of specific inspection	the manufacturer's authorized inspector who is independent of the manufacturing department, and either by the purchaser's authorized inspector or by the inspector designated in the official regulations

Bibliography

ASME	American Society of Mechanical Engineers
GB/T	Voluntary National Standards
2014/68/EU	Directive 2014/68/EU of the European Parliament and of the Council of 15 May 2014 on the harmonization of the laws of the member states relating to the making available on the market of pressure equipment
DIN EN 1090	Execution of steel structures

Amendment June 2022

Amendments made in comparison with [SN 200-10:2016-05](#):

Editorial revisions:	SN 200-10:2016-05 transferred to SN 200-8; New introduction; Update of normative references; Section 4 "Inspection instructions" changed to "Inspection/Testing"; new subdivision of chapters Section 5 "Inspection results" renamed "Inspection documentation"; new subdivision of chapters
Section 5.1.1	Addition of second paragraph referring to "for clear identification ...", section 4.1.2; addition of serial number

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