



# TEST CERTIFICATE

TO BS EN10204 3.1

## VALEN FITTINGS LTD.

MANUFACTURERS OF STAINLESS, NICKEL ALLOY & ALUMINIUM PIPE FITTINGS

VALEN HOUSE, WESTGATE

ALDRIDGE, WALSALL

WEST MIDLANDS WS9 8DG

TEL: (01922) 454913 Fax: (01922) 451930

E-mail: QA@valen fittings.co.uk

ISSUE TO :

HULSEN



Certificate No. 029124

25-5

TEST CERTIFICATE N°: 0226 REV A

DATE:  
11/08/05

OUR REF:  
3480

ORDER N°:  
250227

CAST / HEAT N° 100095613

ITEM	QUANT.	DESCRIPTION
1	2	355 mm x 6 mm 90° SRE
2	1	406 mm x 6 mm 90° SRE
3	1	406 mm x 6 mm 90° LRE

### CHEMICAL ELEMENTS

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
ACT	0.13	0.34	0.04	0.50	4.4	0.07	0.01	0.02
ACT								

### MECHANICAL PROPERTIES

Yield	150 MPa	UTS	296 MPa	%ELONG	24	HARDNESS	
-------	---------	-----	---------	--------	----	----------	--

HEAT TREATMENT 350/400°C + 20°C X T/25 x 1HR AIR COOL  
HEAT TREATMENT REFERENCE P10792

MANUFACTURING SPEC  
AD W6/1 & B361/2002 GRADE 5083-0  
DIMS TO DIN 2605 WP-WX  
STARTING MATERIAL SB209/EN485-5083-0

SUPPLEMENTARY TESTS  
100% RADIOGRAPHY-SATISFACTORY  
FOR TENSILE TESTING SEE ROTECH  
REPORT NO 52504 & 10223-01-SW

We hereby certify that the products described herein have been manufactured to the specification indicated and all test results shown herein are correct.

*P. Bameff*  
FOR VALEN Q.A. DEPT.

# Abnahmeprüfzeugnis

Inspection Certificate EN 10204:2004-3-2  
Certificat de Réception (EN 10204:1991-3.1C)  
Certificato Collaudo Materiali

Besteller - Customer - Acheteur - Committente:  
Valen Fittings Ltd  
Valen House  
Westgate, Aldridge  
West Midlands, WS9 8DG

Hersteller - Manufacturer - Fabricant - Produttore:  
Novelis Deutschland GmbH  
Werk Nachterstedt  
Postfach 1345, Germany

Prüfgegenstand - Article - Produit - Prodotto: Aluminium Plate

Prüfgrundlagen/Anforderungen - Technical requirements/Demand - Spécifications techniques/Exigences - Norma di controllo/Requisiti:

AD 2000 - Merkblatt W6/1 (Einzelgutachten)

Werkstoff - Material - Matière - Materiale

entsprechend - according to suivant- secondo

Ausgabe Edition - Edizione:

EN AW-5083 -O

Lieferzustand - State of delivery - Etat de livraison - Stato di fornitura: See Anlage 2

Erschmelzungsart - Melting process - Procédé d'élaboration - Procedimento di elaborazione: Anlage 2.

Kennzeichnung - Marking - Marquage - Punzonatura:

Material:

EN AW 5083 -O, Cast No, 100095613

Plate No VF9262 (No 1), VF9263 (No 2)

Herstellerzeichen - Brand of the manufacturer - Novelis

Marque du fabricant - Marchio del produttore:

Stempel des Sachverständigen - Inspectors stamp

Poinçon de l'expert - Punzone dell'ispettore.



Pos.- Nr./Item No. Poste-No No.pos	Stückzahl Number of Quote Numero pezzi	Gegenstand - Article Désignation du produit - Tipo di prodotto	Schmelze-Nr. Heat No. No Coulée No Colata	Probe-Nr. Test No. No d'éprouvette No di prova
01	01	2000 mm x 4000mm x 6mm thk	100095613	VF9262
01	01	2000 mm x 4000mm x 6mm thk	100095613	NO 1 VF9263 NO 2

Zusätzliche Angaben - Additional remarks - Autres remarques - Osservazione:

Die gestellten Anforderungen sind lt. Anlagen erfüllt.

The requirements are fulfilled as per annex  
Les conditions imposées sont satisfaites suivant annexes -  
I risultati sono conformi ai requisiti richiesti come da allegati.

(Ort - Location - Lieu - Località)

LONDON

(Datum -Date - Data)

21/07/05

Prüfstelle für Druckgeräte  
Notified Body for Pressure Equipment  
Worthington





Ergebnis der Prüfungen  
Test Results  
Résultats des Essais  
Risultati delle Prove

Anlage - Annex - Annexe - Allegato: 1

Prüf-Nr. 10223-01(SW)

Inspection No.

Certificat N°

N° di collaudo

Teil

Part

Partie

Parte

Blatt-Nr. 1 of 1

Sheet-No.

Page N°

Pag N°

## Mechanische Prüfungen - Mechanical tests - Essais mécaniques - Prove meccaniche

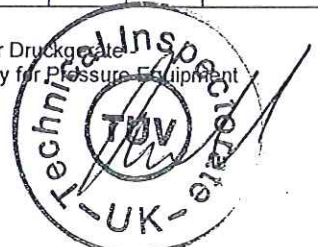
Prüfart - Test type - Type d'essai - Tipo di prova: Probenart - Specimen size Type de l'éprouvette Tipo di provetta: Probenzustand - Specimen condition - Etat d'éprouvette - Stato delle provette:			ZUGVERSUCH / TENSILE TEST								HARDNESS HB					
Probe-Nr. Test No. No. d'éprouvette N° di prova.	Probenabmessung Dim. of specimen Dim. de l'éprouvette Dim. della provetta		Probenentnahme Specimen Prélevement Prelevamento			Prüftemperatur Test Temperature Température d'essai Temperatura di prova °C	Streck-/Dehngrenze Yieldpoint/Proof Stress Limite d'élasticité Lim. di snervamento 0.2 N/mm²	Zugfestigkeit Tensile strength Résistance à la traction Carico di rottura RM N/mm²	Bruchdehnung Elongation Allongement Allungamento A Lo= 5.65 √so %	Bruchreduktion Reduction of area Striction/Strizione Z %	1 = [J] Schlagarbeit - Energy of impact Energie de rupture - Energia di rottura 2 = [J/cm²] Kerbschlagzähigkeit-Impact Strength Résilience - Resilienza 3 = [%] Krist.Bruchanteil - Cryst. proportion Partie cristalline - Proporzione cristallina 4 = [mm10 <sup>-2</sup> ] Breitung - Expansion 5 = [%] Elargissement - Espansione 6 = Härte (Einheiten) - Hardness - Dureté - Durezza					
Wärme-Nr. Heat No. N° Coulée Colata N°	Dicke Thickness Epaisseur Spessore	Breite, Ø Width, Ø Largeur Ø Largh, Ø	Ort - Location Lieu - Zona	Richtung Direction - Senso	Lage - Position Posizione						Werte -Values- Valeurs- Valori 1 2 3 Σ/n				Bemerkung Remarks Remarques Osservazioni	
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
Req'ts / Anforderungen			1	2	3	20	min 125	min 275 350	min 17	30						
Analysis % Max unless Stated S.i 0,40 Fe,0,40 Cu,0,10 Mn,0,40 to 1,00 Mg,4,0 to 4,9 Cr,0,05 to 0,25 Zn,0,25 Ti,0,15.																
100095613 (VF9262) Plate No 1	5,96	12,59	1	2T	3	20	151	296	26,5	33,3						
100095613 (VF9263) Plate No 2	5,96	12,60	1	2T	3	20	152	296	23,5	31,7						
Notes			1) From 3x thk 2) L = Longitudinal / T = Transverse 3) Full Thickness													
4) Besichtigung / Maßkontrolle / Visual and Dimensional check - ohne Beanstandung / Satisfactory																
5) Chemische / Chemical Analysis: siehe Anlage 2 / See annex 2																
6) Manufacturers 3.1. certificate shows in house tests only																

Ort -Location -Lieu - Localita)

LONDON

(Datum Date -Data)

21/07/05

Prüfstelle für Druckgeräte  
Notified Body for Pressure Equipment  
S Worrall

LABORATORY:- MOXLEY INDUSTRIAL CENTRE, WESTERN WAY,  
ADDRESS WEDNESBURY, WEST MIDLANDS, WS10 7BG  
TEL: 0121 505 4050 FAX: 0121 505 1115  
www.rotechlabs.co.uk info@rotechlabs.co.uk

REGISTERED :- DARLASTON P.O. BOX 10, WEDNESBURY,  
OFFICE WEST MIDLANDS, ENGLAND, WS10 8JD  
TEL: 0121 526 3131 FAX: 0121 526 2869

## Test Report

Our Ref: CTV/RKP Number 52504 Issue 1 Date 19.07.2005 Page 1 of 1

A/C No: V016

Tested For:-

Valen Fittings Ltd.  
Valen House, Westgate,  
Aldridge,  
West Midlands WS9 8DG

### PLATE TESTS

#### RELEVANT INFORMATION

Description: 6mm Thick Aluminium Plate No.2  
Client: Hulsen  
Cast No: 100095613  
Testing Specification: AD 2000-Merkblatt W6/1:2003 (Para 5.1)  
Material Specification: EN AW 5083 - O  
Inspection Authority: TUV (Mr. S. Worrall)  
Note: GT384 Rev A  
Purchase Order No: P37509/3480/117  
Test Date: 19.07.2005

#### RESULTS

##### Tensile Test Ambient Temperature

Reviewed / 19/7/05  
Signature

Tested in accordance with ASTM BSEN 10002-1:2001

Ref	Specimen Size (mm)	Proof Stress (0.2Rp)(Mpa)	UTS (Mpa)	G.L.5.65 $\sqrt{so}$ (mm)	%El	% RA
Transverse Plate	12.60 x 5.96	152	296	49	23.5	31.7
Requirements:		125	275		17	30
		(Min)	(Min)		(Min)	(Min)

#### CONCLUSION

The tests carried out satisfied the requirements of AD 2000-Merkblatt W6/1:2003 (Para 5.1).

End of Report

REPORT COMPILED BY

  
R.K.PRATT

REPORT APPROVED BY

  
R.K.PRATT

Group Leader Mech Testing

TESTS MARKED "NOT UKAS ACCREDITED" IN THIS REPORT/CERTIFICATE ARE NOT INCLUDED IN THE UKAS ACCREDITATION SCHEDULE FOR OUR LABORATORY.  
TESTS MARKED "SC" HAVE BEEN SUBCONTRACTED.  
OPINIONS AND INTERPRETATIONS EXPRESSED HEREIN ARE OUTSIDE THE SCOPE OF UKAS ACCREDITATION.  
THIS REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL  
RESULTS IN THIS REPORT RELATE ONLY TO THE ITEMS TESTED



FROM: VAL  
FROM: NICKY

785857X 121pp+ 95:10T 8987/90-72



# TEST CERTIFICATE

TO BS EN10204 3.1

## VALEN FITTINGS LTD.

MANUFACTURERS OF STAINLESS, NICKEL ALLOY & ALUMINIUM PIPE FITTINGS

VALEN HOUSE, WESTGATE

ALDRIDGE, WALSALL

WEST MIDLANDS WS9 8DG

TEL: (01922) 454913 Fax: (01922) 451930

E-mail: QA@valenfittings.co.uk

ISSUE TO :

HULSEN



Certificate No. Q09135

TEST CERTIFICATE N°: 0225

DATE:  
20/07/05

OUR REF:  
3480

ORDER N°:  
250227

CAST / HEAT N° 100095613

ITEM	QUANT.	DESCRIPTION
1	1	355 mm x 6 mm 90° SRE
3	2	406 mm x 6 mm 90° LRE
4	1	508 mm x 6 mm 90° LRE

### CHEMICAL ELEMENTS

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
ACT	0.13	0.34	0.04	0.50	4.4	0.07	0.01	0.02
ACT								

### MECHANICAL PROPERTIES

Yield	150 MPa	UTS	296 MPa	%ELONG	24	HARDNESS	
-------	---------	-----	---------	--------	----	----------	--

HEAT TREATMENT 350/400°C + 20°C X T/25 x 1HR AIR COOL

HEAT TREATMENT REFERENCE P10792

#### MANUFACTURING SPEC

AD W6/1 & B361/2002 GRADE 5083-0

DIMS TO DIN 2605 WP-WX

STARTING MATERIAL SB209/EN485-5083-0

#### SUPPLEMENTARY TESTS

100% RADIOGRAPHY-SATISFACTORY  
FOR TENSILE TESTING SEE ROTECH  
REPORT NO 52495 & 10223-01-SW

We hereby certify that the products described herein have been manufactured to the specification indicated and all test results shown herein are correct.

*A. B. Barnett*

FOR VALEN Q.A. DEPT.



# Abnahmeprüfzeugnis

Inspection Certificate EN 10204:2004-3-2  
Certificat de Réception (EN 10204:1991-3.1C)  
Certificato Collaudo Materiali

Besteller - Customer - Acheteur - Committente:  
Valen Fittings Ltd  
Valen House  
Westgate, Aldridge  
West Midlands, WS9 8DG

Hersteller - Manufacturer - Fabricant - Produttore:  
Novelis Deutschland GmbH  
Werk Nachterstedt  
Postfach 1345, Germany

Prüfgegenstand - Article - Produit - Prodotto: Aluminium Plate

Prüfgrundlagen/Anforderungen - Technical requirements/Demand - Spécifications techniques/Exigences - Norma di controllo/Requisiti:

AD 2000 - Merkblatt W6/1 (Einzelgutachten)

Werkstoff - Material - Matière - Materiale

entsprechend - according to suivant - secondo

Ausgabe Edition - Edizione:

EN AW-5083 -O

Lieferzustand - State of delivery - Etat de livraison - Stato di fornitura: See Anlage 2

Erschmelzungsart - Melting process - Procédé d'élaboration - Procedimento di elaborazione: Anlage 2.

Kennzeichnung - Marking - Marquage - Punzonatura:

Material:

EN AW 5083 -O, Cast No, 100095613

Plate No VF9262 (No 1), VF9263 (No 2)

Herstellerzeichen - Brand of the manufacturer - Novelis

Marque du fabricant - Marchio del produttore:

Stempel des Sachverständigen - Inspectors stamp

Poinçon de l'expert - Punzone dell'ispettore.



Pos.- Nr./Item No. Poste-No No.pos	Stückzahl Number of Quote Numero pezzi	Gegenstand - Article Désignation du produit - Tipo di prodotto	Schmelze-Nr. Heat No. No Coulée No Colata	Probe-Nr. Test No. No d'éprouvette No di prova
01	01	2000 mm x 4000mm x 6mm thk	100095613	VF9262 NO 1
01	01	2000 mm x 4000mm x 6mm thk	100095613	VF9263 NO 2

Zusätzliche Angaben - Additional remarks - Autres remarques - Osservazione:

Die gestellten Anforderungen sind lt. Anlagen erfüllt.

The requirements are fulfilled as per annex  
Les conditions imposées sont satisfaites suivant annexes -  
I risultati sono conformi ai requisiti richiesti come da allegati.

(Ort - Location - Lieu - Località)

LONDON

(Datum - Date - Data)

21/07/05

Prüfstelle für Druckgeräte  
Notified Body for Pressure Equipment



Ergebnis der Prüfungen  
Test Results  
Résultats des Essais  
Risultati delle Prove

Anlage - Annex - Annexe - Allegato: 1

Prüf-Nr. 10223-01(SW)

Inspection No.

Certificat N°

N° di collaudo

Teil

Part

Partie

Parte

Blatt-Nr. 1 of 1

Sheet-No.

Page N°

Pag N°

## Mechanische Prüfungen - Mechanical tests - Essais mécaniques - Prove meccaniche

ZUGVERSUCH / TENSILE TEST											HARDNESS HB																															
Prüfart - Test type - Type d'essai - Tipo di prova: Probenart - Specimen size Type de l'éprouvette Tipo di provetta: Probenzustand - Specimen condition - Etat d'éprouvette - Stato della provetta:			Probe-Nr. Test No. N°. d'éprouvette N° di prova.								Probenabmessung Dim. of specimen Dim. de l'éprouvette Dim. della provetta		Probenentnahme Specimen Prélèvement Prelevamento		Prüftemperatur Test temperature Température d'essai Temperatura di prova		Streck-/Zuggrenze Tensile/Proof Stress Limite di snervamento		Zugfestigkeit Tensile strength Résistance à la traction Carico di rottura		Bruchdehnung Elongation Allongement Allungamento		Bruchreduktion Reduction of area Striction/Strizione		1 = [J] Schlagarbeit - Energy of impact Energie de rupture - Energia di rottura 2 = [J/cm²] Kerbschlagzähigkeit - Impact Strength Résilience - Resilienza 3 = [%] Krist.Bruchanteil - Cryst. proportion Partie cristalline - Proporzione cristallina 4 = [mm10-] Breitung - Expansion 5 = [%] Elargissement - Espansione 6 = Härte (Einheiten) - Hardness - Dureté - Durezza																	
Schmelze-Nr. Cast No. N° Coulée Colata N°			Dicke Thickness Epaisseur Spessore		Breite, Ø Width, Ø Largeur Largh, Ø		Ort - Location Lieu - Zona		Richtung - Senso Direction - Senso Lage - Posizion Posizione		°C		0.2 N/mm²		RM N/mm²		A Lo = 5.65 vso %		Z %		<table border="1"> <thead> <tr> <th>Werte - Values -</th> <th>Valeurs -</th> <th>Valori</th> <th colspan="2"></th> </tr> <tr> <th>1</th> <th>2</th> <th>3</th> <th>Σ/n</th> <th></th> </tr> </thead> <tbody> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>							Werte - Values -	Valeurs -	Valori			1	2	3	Σ/n						
Werte - Values -	Valeurs -	Valori																																								
1	2	3	Σ/n																																							
Req'ts / Anforderungen			1		2		3		20		min 125		min 275 350		min 17		30																									
% Max unless Stated			Si 0.40		Fe 0.40		Cu 0.10		Mn 0.40 to 1.00		Mg 4.0 to 4.9		Cr 0.05 to 0.25		Zn 0.25		Ti 0.15.																									
100095613 (VF9262) Plate No 1			5,96		12,59		1		2T		3		20		151		296		26,5		33,3																					
100095613 (VF9263) Plate No 2			5,96		12,60		1		2T		3		20		152		296		23,5		31,7																					
Notes							1) From 3x thk																																			
							2) L = Longitudinal / T = Transverse																																			
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Ort - Location - Lieu - Località)

LONDON

(Datum Date - Data)

21/07/05

Prüfstelle für Druckgeräte  
Notified Body for Pressure Equipment  
S Worrall



LABORATORY:- MOXLEY INDUSTRIAL CENTRE, WESTERN WAY,  
ADDRESS WEDNESBURY, WEST MIDLANDS, WS10 7BG  
TEL: 0121 505 4050 FAX: 0121 505 1115  
www.rotechlabs.co.uk info@rotechlabs.co.uk

REGISTERED :- DARLASTON P.O. BOX 10, WEDNESBURY,  
OFFICE WEST MIDLANDS, ENGLAND, WS10 8JD  
TEL: 0121 526 3131 FAX: 0121 526 2869

## Test Report

Our Ref: CTV/RKP Number 52495 Issue 1 Date 19.07.2005 Page 1 of 1

A/C No: V016

Tested For:-

Valen Fittings Ltd.  
Valen House, Westgate,  
Aldridge,  
West Midlands WS9 8DG

### PLATE TESTS

### RELEVANT INFORMATION

Description: 6mm Thick Aluminium Plate No.1  
Client: Hulsen  
Cast No: 100095613  
Testing Specification: AD 2000-Merkblatt W6/1:2003 (Para 5.1)  
Material Specification: EN AW 5083 – O  
Inspection Authority: TUV (Mr. S. Worrall)  
Note: GT384 Rev A  
Purchase Order No: P37509/3480/117  
Test Date: 19.07.2005

### RESULTS

#### Tensile Test Ambient Temperature

Tested in accordance with ASTM BSEN 10002-1:2001

Ref	Specimen Size (mm)	Proof Stress (0.2Rp)(Mpa)	UTS (Mpa)	G.L.5.65 <sub>vs0</sub> (mm)	%El	% RA
Transverse Plate	12.59 x 5.96	151	296	49	26.5	33.3
Requirements:		125	275		17	30
		(Min)	(Min)		(Min)	(Min)

### CONCLUSION

The tests carried out satisfied the requirements of AD 2000-Merkblatt W6/1:2003 (Para 5.1).

End of Report

REPORT COMPILED BY

  
R.K.PRATT

REPORT APPROVED BY

  
R.K.PRATT

Group Leader Mech Testing

TESTS MARKED "NOT UKAS ACCREDITED" IN THIS REPORT/CERTIFICATE ARE NOT INCLUDED IN THE UKAS ACCREDITATION SCHEDULE FOR OUR LABORATORY.  
TESTS MARKED 'SC' HAVE BEEN SUBCONTRACTED.  
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RESULTS IN THIS REPORT RELATE ONLY TO THE ITEMS TESTED



**Novelis Deutschland GmbH, Werk Nachterstedt**  
**Novelis Automotive, Painted & Specialities**

Gatersleben, Straße 1 Postfach 13 45  
 D-06469 Nachterstedt D-08433 Aschersleben

Tel.: (03 47 41) 77-0  
 Fax: (03 47 41) 204  
 www.novelis.com

FKU: VAL  
 FROM: NICKY  
 Novelis

Metallweb PLC

18/22 Birch Road East

GB -B6 7DB Wotton, Birmingham

GROSSBRITANNIEN



Abnahmeprüfzeugnis EN 10204-3.1 B  
 Inspection Certificate EN 10204-3.1 B  
 Certificat de Reception EN 10204-3.1 B

Nr./No. 81341686

Standard EN 485 (1995)

Adress Nr. Order no. No. du commande	0000073911	Werkstoff Alloy Alliage	5083	Zustand Temper Etat	0	10234
Gewicht, netto Weight, net Poids net	5.932 kg	Stückzahl Pieces Pièces	6 COLEL	AL-PLATE SHEETS / SHAYE		

Chemische Zusammensetzung in Gewichtsprozenten  
 Chemical composition in percentage by weight  
 Composition chimique en pourcentage de poids

Chem.-Nr./Casi. n°/No. du casier	Bund-Nr.	Si	Pb	Cu	Mn	Mg	Cr	Zn	Ni	
0 095613	05/77749	0,13	0,34	0,04	0,50	4,4	0,07	0,01	0,02	

Mechanische Eigenschaften  
 Mechanical properties  
 Caractéristiques mécaniques

Pos.	Code	Bund-Nr.	Abmessung Dimensions Dimension	Prüfung Inspection of Testing sous de mesure	0,2% Dehnsgrenze proof stress limite d'élasticité R <sub>0,2</sub> MPa	Zugfestigkeit Tensile strength Résistance à la traction R <sub>m</sub> MPa	Dehnung Elongation Allongement muni A <sub>50</sub>	Stapel Earing Cornes	Stück
30	1119502	7774900005	6,000 * 2000,00 * 4000,00 BX	Q	150	296	24		8
	1119503	7774900006	5083 0	Q	150	296	24		8
40	1119504	7774900007	6,000 * 2000,00 * 2000,00 BX	Q	150	296	24		16
	1119505	7774900008	5083 0	Q	150	296	24		16
	1119506	7774900009		Q	150	296	24		16
	1119507	7774900010		Q	150	296	24		16

**VALEN**  
 DATE: 1/7/05  
 ACCEPTED:  
 Q.No. P37355-3480  
 V.F.N. 9262/3  
 INSP. ASBANK

This certificate has been made out by EDP and that's why it isn't signed.

sig. D. Kühne

Nachterstedt, 26.04.05

Werkstoffverständiger

Zertifiziert nach ISO 9001, ISO/TS 16949, ISO 14001, EMAS II, OHSAS 18001  
 Sitz: Göttingen (H-B 772), Geschäftsführung: Nikolaus Ehrh von Verschuer, Erwin Engel  
 Vers. des Aufsichtsrates: Chris Bark-Jones

Anlage 2 Page 1 of 1  
 Prüf Nr. 10223-01 (SW)