



FLOWERVE Flow Control  
GESTRA Steam Systems

GESTRA AG  
Münchener Straße 77  
D-28215 Bremen

Formals / ancienneté / ancienneté



# Abnahmeprüfzeugnis Inspection certificate / Certificat de réception

EN 10 204-3.1B

No.: EA0411518

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Hersteller / Manufacturer / Fabricant:

GESTRA AG · Postfach 10 54 60 · D-28054 Bremen  
**Siekman Econosto GmbH & Co. K**  
**Freigrafenweg 2**

**44357 Dortmund**

Bestell-Nr.: **9004774<sup>9</sup>OP**  
Order No. / No. De commande

Bestelldatum:  
Date of order / Date de commande

GESTRA Auftrag-Nr.: **230337** Pos.: **30**  
GESTRA Order-No. / Item. / GESTRA No. d'ordre / Poste

Prüfgegenstand: **Duo Kondensomat BK 45 DN 25 Flansch PN40 B1 "RHOMBUSline" - BK45**  
Product tested: **Duo Steam Trap BK 45 DN 25 Flange PN40 B1 "RHOMBUSline" - BK45 / Purgeur Duo BK 45 DN 25 Bride PN40 B1 "RHOMBUSline" - BK45**  
Matériel éprouvé: **BK45**  
Stk. / pc. / pc. **75**

Lieferbedingungen: **Herstellerstandard / Manufacturer standard / Standard du fabricant**  
Terms of delivery: **Pos. 16 65f.**  
Conditions de livraison

## Bauprüfungen entsprechend DIN 3230 Teil 3

Final testing acc. to DIN 3230 Part 3, Epreuve finale conforme DIN 3230 part 3

| A  | Allgemeine Prüfungen<br>General Tests / Tests généraux   |
|----|--|
| AA | Prüfung der Bestelldaten<br>Checking of order specifications / Contrôle des données de commande            |
| AB | Prüfung der Form und Ausrüstung<br>Inspection of design and fittings / Contrôle du type et de l'équipement |
| AC | Prüfung der Kennzeichnung<br>Inspection of marking / Contrôle du repérage                                  |
| AD | Prüfung der Maße<br>Dimensional Check / Contrôle des dimensions  |
| AE | Prüfung der Oberfläche<br>Surface inspection / Contrôle de la surface                                      |
| AF | Prüfung der Anschlußflächen<br>Inspection of connecting surfaces / Contrôle des surfaces de raccordement   |
| AG | Prüfung der Betätigungsfunktion<br>Testing of operational functioning / Contrôle de la manœuvre            |
| AP | Sichtprüfung<br>Visual inspection / Inspection visuelle  |
| AR | Prüfung der Werkstoffnachweise<br>Checking of material records / Contrôle des certificats du matériau      |

| B  | Festigkeits- und Dichtheitsprüfungen<br>Strength and leak tests / Essais de résistance et d'étanchéité                                  |
|----|---|
| BA | Festigkeit des Gehäuses mit Wasser - 1,5 x PN - 1-2 min<br>Strength test on housing with water / Epreuve de résistance du corps à l'eau |

Sonstige Prüfungen: Other tests / Autres épreuves  
Funktions- und Dichtheitsprüfung des Abschlusses mit Dampf gemäß DIN EN 26948  
Function- and tightness test of the closure with steam acc. to DIN EN 26948  
Epreuve de fonction et d'étanchéité de l'obturateur à la vapeur suivant DIN EN 26948

**A 15 021, A 88 002**  
**A 88 003, A 88 004**  
**A 88 005, A 90 004**

Bemerkungen:  
Remarks / Remarques  
Kennzeichnung:  
Marks / Marques



Prüfbefund: **Die gestellten Anforderungen sind erfüllt**  
Results of tests: **Specified requirements are satisfied**  
Conclusions: **Conforme aux spécifications**

Liste der Werkstoffnachweise siehe Seite 2  
Material testing on page 2 / Epreuve du matériau voir page 2

## GESTRA AG

Abnahme + Dokumentation  
Inspection and documentation / Certification et Documentation

**Jürgen Kruse**

Der Werkssachverständige  
Worksinspector / Responsable du Service Réception

Phone: +49 421 3503 220  
FAX: +49 421 3503 176

**Bremen, 2004-12-01**



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GESTRA Steam Systems

GESTRA AG  
Münchener Straße 77  
D-28215 Bremen

Formals / Ancien / Avant



## Abnahmeprüfzeugnis

EN 10 204-3.1B

No.: EA0411518

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Inspection certificate / Certificat de réception

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### Liste der Werkstoffnachweise:

Material testing / Epreuve du matériau

| Pos.<br>Item.<br>Pos. | Stk.<br>pc.<br>pc. | Gegenstand<br>Objet<br>Objet | Kennzeichnung<br>Marks<br>Marques | Schmelze<br>melting charge<br>charge d. orneau | Hersteller<br>Manufactur<br>Producteur | Werkstoff<br>Material<br>Matériau | Werkstoffnachweis<br>Material evidence<br>Preuve du matériau | Lieferbedingung<br>Terms of delivery<br>Cond. de livraison |
|-----------------------|--------------------|------------------------------|-----------------------------------|--|--|-----------------------------------|--|--|
| 1                     | 150                | Flansch<br>Flange / Bride    | 14826                             | 14826  | Bifrangi S.P.A.                        | 1.0460/A<br>105                   | 3.1B   | TRD110; TRD107; AD-<br>W13; DIN 17243; ASTM<br>A105        |
| 2                     | 75                 | Gehäuse<br>body / cops       | 36                                | 069995   | Richard Neumayer<br>Gesell.            | 1.0460/A<br>105                   | 3.1B   | TRD110; TRD107; AD-<br>W13; DIN 17243; ASTM<br>A105        |
| 3                     | 75                 | Haube<br>Bonnet / Capot      | 28                                | 067911   | Richard Neumayer<br>Gesell.            | 1.0460/A<br>105                   | 3.1B   | TRD110; TRD107; AD-<br>W13; DIN 17243; ASTM<br>A105        |

Anlage / enclosure / p.j.

N + F Handelsgesellschaft mbH  
für Rohr und Rohrzubehör



**N+F**

N + F Handelsgesellschaft mbH · Postfach 74 05 49 · 22095 Hamburg

Gestra GmbH  
Münchener Str. 77  
28215 Bremen

**Flansche  
Rohrbogen  
Schweißittings  
Dreherel**

**Umstempel-Bescheinigung**

Nr. 8804

Tag 25.11.04

Ihre Bestell-Nr.

4500193228 v. 16.11.04

Unsere Komm.-Nr.

317018 / Pos. 1

Wir bestätigen, dass das oder die gelieferten Teile

V-Flansche PN 40, Nr. 375918 / Pos. 10

1.041 Stück

DN 25

Werkstoff C 22.8/A 105

aus den Abmessungen

Pos. 1+2

Gestra Flansche PN 40

DN 25

Pcs.

ausgewiesen durch



Werkbescheinigung  
nach EN 10204



Werkzeugnis  
nach EN 10204



Abnahmeprüfzeugnis  
nach EN 10204/3

der Firma

Bifrangli S.P.A., Abnahmeprüfzeugnis-Nr. 04/B0403420 v. 15.09.04

gefertigt und die Stempelung

Werkstoff

Schmelzen-Nr.

Probe-Nr.

Rohr-Nr.

C 22.8/A 105

14826

Vor dem Trennen übertragen worden ist. Ausmessung und Besichtigung ohne Beanstandung.  
Zum Zeichen der ordnungsgemäßen Umstempelung wurde/n das/die Teil/e

außerdem mit unserem Stempel versehen:



Mit der Umstempelung beauftragt

Herr Tasch

Das Umstempeln erfolgt mit Zustimmung des TÜV-Norddeutschland e.V. Aktienzeichen Nr. 121 W 111 230.  
Der Einsatz des Materials nach deutschem Regelwerk ist nur zulässig, wenn die im Zeugnis genannten Anforderungen das  
zulassen.

Tag/Unterschrift

25.11.04 He./sv.

Wannenschrift  
Postfach 3  
22113 Hamburg  
Internet: www.nuf.de

Telefon  
(040)  
731 2070  
e-mail: info@nuf.de

Telefax  
(040)  
732 3038

Banken  
Commerzbank Hamburg  
(BLZ 200 400 00)  
Kto.-Nr. 2 848 499

Haspa  
(BLZ 200 505 50)  
Kto.-Nr. 1038/212008

Handelsregister  
HRB-Nr. 23 283  
Geschäftsführung  
Görner Hamburg



Hersteller - Customer

N + F HANDELSGESELLSCHAFT  
PORZESRING, 3

22113 HAMBURG - D



**bifranggi** a.s.a.

VALIANZONI 14  
36068 MARCONI (VI)  
VICENZA ITALY  
Tel. 0444/8801  
Fax. 0444/8801-87718  
e-mail: bifranggi@bifranggi.it

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Abnahmeprüfungsnachricht nach DIN 50049 / 3.1B  
Test Certificate in accordance to EN 10204 / 3.1B

|                            |  |                              |  |                    |  |                                    |  |   |  |            |  |                |  |
|----------------------------|--|------------------------------|--|--------------------|--|------------------------------------|--|---|--|------------|--|----------------|--|
| Bestell-Nr.<br>Order No.   |  | Bestellungs-Nr.<br>Order No. |  | Vern.-Code<br>Code |  | FLANGE                             |  | Date<br>Date  |  | 15.08.04   |  | 04/09/03/03/03 |  |
| Proz. Nr.<br>Proc. No.     |  | C2                           |  | H<br>H             |  | C                                  |  | Si  |  | Al         |  | Cu             |  |
| 1                          |  | A3                           |  | 1370               |  | FLGESTRA DN 25/ PN 40 GREZZE       |  | Ord: 8149   |  | 14826      |  | 14826          |  |
| 2                          |  | A5                           |  | 4790               |  | FLGESTRA DN 25/ PN 40 GREZZE       |  | Ord: 8149   |  | 14826      |  | 14826          |  |
| 3                          |  | S7                           |  | 1330               |  | FLDIN 2633 NW 20/26.9 NON VERNICIA |  | Ord: 8304   |  | 14804      |  | 14804          |  |
| 4                          |  | F251                         |  | 40                 |  | FLDIN 2633 NW 350/355.6 NON VERN.  |  | Ord: 8119   |  | 31523      |  | 31523          |  |
| 5                          |  | F066                         |  | 1000               |  | FLDIN 2565 80/R3*                  |  | Ord: 8334   |  | 337479     |  | 337479         |  |
| Hersteller<br>Manufacturer |  | C22.8 Velliv - veldi. 350/3  |  | Stand<br>Standard  |  | Stand according to DIN 17243       |  | STAHL NACH DIN 17243  |  | Min<br>Max |  | Min<br>Max     |  |
| 0001 LEAL S.p.A.           |  | 0172 RIVA ACCIO S.p.A.       |  | LE                 |  | TO                                 |  | 0,18<br>0,20<br>0,22<br>0,24<br>0,26<br>0,28<br>0,30<br>0,32<br>0,34<br>0,36<br>0,38<br>0,40<br>0,42<br>0,44<br>0,46<br>0,48<br>0,50<br>0,52<br>0,54<br>0,56<br>0,58<br>0,60<br>0,62<br>0,64<br>0,66<br>0,68<br>0,70<br>0,72<br>0,74<br>0,76<br>0,78<br>0,80<br>0,82<br>0,84<br>0,86<br>0,88<br>0,90<br>0,92<br>0,94<br>0,96<br>0,98<br>1,00<br>1,02<br>1,04<br>1,06<br>1,08<br>1,10<br>1,12<br>1,14<br>1,16<br>1,18<br>1,20<br>1,22<br>1,24<br>1,26<br>1,28<br>1,30<br>1,32<br>1,34<br>1,36<br>1,38<br>1,40<br>1,42<br>1,44<br>1,46<br>1,48<br>1,50<br>1,52<br>1,54<br>1,56<br>1,58<br>1,60<br>1,62<br>1,64<br>1,66<br>1,68<br>1,70<br>1,72<br>1,74<br>1,76<br>1,78<br>1,80<br>1,82<br>1,84<br>1,86<br>1,88<br>1,90<br>1,92<br>1,94<br>1,96<br>1,98<br>2,00<br>2,02<br>2,04<br>2,06<br>2,08<br>2,10<br>2,12<br>2,14<br>2,16<br>2,18<br>2,20<br>2,22<br>2,24<br>2,26<br>2,28<br>2,30<br>2,32<br>2,34<br>2,36<br>2,38<br>2,40<br>2,42<br>2,44<br>2,46<br>2,48<br>2,50<br>2,52<br>2,54<br>2,56<br>2,58<br>2,60<br>2,62<br>2,64<br>2,66<br>2,68<br>2,70<br>2,72<br>2,74<br>2,76<br>2,78<br>2,80<br>2,82<br>2,84<br>2,86<br>2,88<br>2,90<br>2,92<br>2,94<br>2,96<br>2,98<br>3,00<br>3,02<br>3,04<br>3,06<br>3,08<br>3,10<br>3,12<br>3,14<br>3,16<br>3,18<br>3,20<br>3,22<br>3,24<br>3,26<br>3,28<br>3,30<br>3,32<br>3,34<br>3,36<br>3,38<br>3,40<br>3,42<br>3,44<br>3,46<br>3,48<br>3,50<br>3,52<br>3,54<br>3,56<br>3,58<br>3,60<br>3,62<br>3,64<br>3,66<br>3,68<br>3,70<br>3,72<br>3,74<br>3,76<br>3,78<br>3,80<br>3,82<br>3,84<br>3,86<br>3,88<br>3,90<br>3,92<br>3,94<br>3,96<br>3,98<br>4,00<br>4,02<br>4,04<br>4,06<br>4,08<br>4,10<br>4,12<br>4,14<br>4,16<br>4,18<br>4,20<br>4,22<br>4,24<br>4,26<br>4,28<br>4,30<br>4,32<br>4,34<br>4,36<br>4,38<br>4,40<br>4,42<br>4,44<br>4,46<br>4,48<br>4,50<br>4,52<br>4,54<br>4,56<br>4,58<br>4,60<br>4,62<br>4,64<br>4,66<br>4,68<br>4,70<br>4,72<br>4,74<br>4,76<br>4,78<br>4,80<br>4,82<br>4,84<br>4,86<br>4,88<br>4,90<br>4,92<br>4,94<br>4,96<br>4,98<br>5,00<br>5,02<br>5,04<br>5,06<br>5,08<br>5,10<br>5,12<br>5,14<br>5,16<br>5,18<br>5,20<br>5,22<br>5,24<br>5,26<br>5,28<br>5,30<br>5,32<br>5,34<br>5,36<br>5,38<br>5,40<br>5,42<br>5,44<br>5,46<br>5,48<br>5,50<br>5,52<br>5,54<br>5,56<br>5,58<br>5,60<br>5,62<br>5,64<br>5,66<br>5,68<br>5,70<br>5,72<br>5,74<br>5,76<br>5,78<br>5,80<br>5,82<br>5,84<br>5,86<br>5,88<br>5,90<br>5,92<br>5,94<br>5,96<br>5,98<br>6,00<br>6,02<br>6,04<br>6,06<br>6,08<br>6,10<br>6,12<br>6,14<br>6,16<br>6,18<br>6,20<br>6,22<br>6,24<br>6,26<br>6,28<br>6,30<br>6,32<br>6,34<br>6,36<br>6,38<br>6,40<br>6,42<br>6,44<br>6,46<br>6,48<br>6,50<br>6,52<br>6,54<br>6,56<br>6,58<br>6,60<br>6,62<br>6,64<br>6,66<br>6,68<br>6,70<br>6,72<br>6,74<br>6,76<br>6,78<br>6,80<br>6,82<br>6,84<br>6,86<br>6,88<br>6,90<br>6,92<br>6,94<br>6,96<br>6,98<br>7,00<br>7,02<br>7,04<br>7,06<br>7,08<br>7,10<br>7,12<br>7,14<br>7,16<br>7,18<br>7,20<br>7,22<br>7,24<br>7,26<br>7,28<br>7,30<br>7,32<br>7,34<br>7,36<br>7,38<br>7,40<br>7,42<br>7,44<br>7,46<br>7,48<br>7,50<br>7,52<br>7,54<br>7,56<br>7,58<br>7,60<br>7,62<br>7,64<br>7,66<br>7,68<br>7,70<br>7,72<br>7,74<br>7,76<br>7,78<br>7,80<br>7,82<br>7,84<br>7,86<br>7,88<br>7,90<br>7,92<br>7,94<br>7,96<br>7,98<br>8,00<br>8,02<br>8,04<br>8,06<br>8,08<br>8,10<br>8,12<br>8,14<br>8,16<br>8,18<br>8,20<br>8,22<br>8,24<br>8,26<br>8,28<br>8,30<br>8,32<br>8,34<br>8,36<br>8,38<br>8,40<br>8,42<br>8,44<br>8,46<br>8,48<br>8,50<br>8,52<br>8,54<br>8,56<br>8,58<br>8,60<br>8,62<br>8,64<br>8,66<br>8,68<br>8,70<br>8,72<br>8,74<br>8,76<br>8,78<br>8,80<br>8,82<br>8,84<br>8,86<br>8,88<br>8,90<br>8,92<br>8,94<br>8,96<br>8,98<br>9,00<br>9,02<br>9,04<br>9,06<br>9,08<br>9,10<br>9,12<br>9,14<br>9,16<br>9,18<br>9,20<br>9,22<br>9,24<br>9,26<br>9,28<br>9,30<br>9,32<br>9,34<br>9,36<br>9,38<br>9,40<br>9,42<br>9,44<br>9,46<br>9,48<br>9,50<br>9,52<br>9,54<br>9,56<br>9,58<br>9,60<br>9,62<br>9,64<br>9,66<br>9,68<br>9,70<br>9,72<br>9,74<br>9,76<br>9,78<br>9,80<br>9,82<br>9,84<br>9,86<br>9,88<br>9,90<br>9,92<br>9,94<br>9,96<br>9,98<br>10,00<br>10,02<br>10,04<br>10,06<br>10,08<br>10,10<br>10,12<br>10,14<br>10,16<br>10,18<br>10,20<br>10,22<br>10,24<br>10,26<br>10,28<br>10,30<br>10,32<br>10,34<br>10,36<br>10,38<br>10,40<br>10,42<br>10,44<br>10,46<br>10,48<br>10,50<br>10,52<br>10,54<br>10,56<br>10,58<br>10,60<br>10,62<br>10,64<br>10,66<br>10,68<br>10,70<br>10,72<br>10,74<br>10,76<br>10,78<br>10,80<br>10,82<br>10,84<br>10,86<br>10,88<br>10,90<br>10,92<br>10,94<br>10,96<br>10,98<br>11,00<br>11,02<br>11,04<br>11,06<br>11,08<br>11,10<br>11,12<br>11,14<br>11,16<br>11,18<br>11,20<br>11,22<br>11,24<br>11,26<br>11,28<br>11,30<br>11,32<br>11,34<br>11,36<br>11,38<br>11,40<br>11,42<br>11,44<br>11,46<br>11,48<br>11,50<br>11,52<br>11,54<br>11,56<br>11,58<br>11,60<br>11,62<br>11,64<br>11,66<br>11,68<br>11,70<br>11,72<br>11,74<br>11,76<br>11,78<br>11,80<br>11,82<br>11,84<br>11,86<br>11,88<br>11,90<br>11,92<br>11,94<br>11,96<br>11,98<br>12,00<br>12,02<br>12,04<br>12,06<br>12,08<br>12,10<br>12,12<br>12,14<br>12,16<br>12,18<br>12,20<br>12,22<br>12,24<br>12,26<br>12,28<br>12,30<br>12,32<br>12,34<br>12,36<br>1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Hausanschrift Telefon (0 78 31) 8 03-0  
Winelm-Zangen-Str. 8 Telefax (0 78 31) 8 03-71  
77756 Hausach e-mail neumayer@r-neumayer.de  
Internet http://www.r-neumayer.de

# NEUMAYER

Richard Neumayer Gesellschaft für Umformtechnik mbH · Hausach



Richard Neumayer Postfach 11 68 · 77750 Hausach

Firma  
Gestra AG  
Postfach 10 54 60

28054 Bremen

## ABNAHMEPRÜFZEUGNIS

DIN 50049 / EN 10204 3.1 B

Inspektioncertifikat / Certificat de réception  
Herstellerzulassung TÜV nach AD 2000 und  
Druckgeräte-Richtlinie liegt vor.

Stempel des Herstellers  
Mark of factory  
Poinçon d'usine



Stempel der Werkprüfstelle  
Mark of factory's inspection  
Poinçon de réception d'usine



Pos.: 1 von 1

|   |  |   |                                 |
|---|--|---|---------------------------------|
| Besteller / Le client / le commandant         | Werkbestellung / Your order / Votre commande                       | Tag / Date / Date                                       | Kennr. Nr. / Works-No. / Numéro |
| Gestra AG                                     | 5500000139 v. 18.05.04   | 22.09.2004  | 192928                          |
| Gegenstand / Article / Désignation du produit | Menge/Stück<br>Quantity<br>Quantité                                | Anforderungen / Requirements / Valeurs demandées        |                                 |
| Haube BK 45 3/375003.01                       | 3.198  | DIN 17 243, TRD 107/ TRD 110, AD W 13                   |                                 |
| Erzeugnisname / Product / Produit             | Werkstoff (Norm) / Material correspondent / Matériau correspondant | Erstschmelzungsort<br>Kind of melting<br>Mode de fusion | Teil-Nr. / Article No.          |
| Gesenkschmiedestück                           | C 22.8 + ASTM A 105  | E   | 027 00 51834                    |

### Prüfergebnisse

Masse und Lage der Probe  
Dimensions and Position of test piece  
Dimensions et Position de l'éprouvette

rd. 8 mm q/t

| Probe<br>Specimen<br>Éprouvette<br>N° | Menge<br>Quantity<br>Quantité | Streckgrenze<br>Yield point<br>Limite d'élasticité<br>Rp = 0,2% | Bruch<br>Rp = 1,0% | Zugfestigkeit<br>Tensile strength<br>Résistance à la traction<br>Rm | Dehnung<br>Elongation<br>Allongement (L0=50 mm)<br>A5 | Bruchdehnung<br>Reduction of area<br>Striction<br>Z | Kerbschlagenergie<br>Impact Strength<br>Résistance<br>RT | Probe: FB O-V |
|---------------------------------------|-------------------------------|---|--------------------|---|---|---|--|---------------|
| Bohrer<br>Bore<br>Bore                |                               | 250   |                    | 485<br>540  | 25  | 30  | 31   |               |
| 241618                                | 144<br>146                    | 331   |                    | 492   | 27  | 59  | 72 / 95 / 74   |               |
| 241619                                | 144<br>146                    | 322   |                    | 487   | 26  | 54  | 61 / 73 / 57   |               |
| 241620                                | 144<br>146                    | 316   |                    | 485   | 26  | 57  | 84 / 66 / 65   |               |
| 241621                                | 144<br>146                    | 324   |                    | 488   | 29  | 60  | 96 / 89 / 111  |               |

Bemerkungen / Remarks / Remarques  
Chargen-Kurzzeichen: 28

Wärmebehandlung: normalisiert, 910°C, Abkühlung ruhende Luft

| Chemische<br>Analyse<br>Chimie<br>H/He | C<br>Ti<br>% | Si<br>Nb<br>% | Mn<br>V<br>%   | P<br>N<br>% | S<br>Cu<br>%   | Cr<br>B<br>% | Mo<br>% | Ni<br>% | Al<br>% |
|--|--------------|---------------|----------------|-------------|----------------|--------------|---------|---------|---------|
| 067911                                 | 0,180        | 0,220         | 0,850<br>0,002 | 0,013       | 0,005<br>0,070 | 0,080        | 0,011   | 0,060   | 0,032   |

Beachtung und Abmessen: Ohne Beanstandung. Die gestellten Anforderungen sind erfüllt.  
Visual inspection and dimensioning: Without objection. The specified requirements are fulfilled.  
Manufacture / Réception: Les résultats ont été trouvés satisfaisants.  
Wir bestätigen, daß die Analyse mit dem Ursprungszeugnis übereinstimmt.

RICHARD NEUMAYER  
Der Werkprüfstellenleiter  
Grünzger Leiter QM

Bitte wenden Sie sich bei Rückfragen an Fr. Kornmayer (Tel. -20)

Das Zeugnis ist EDV-technisch erstellt und ohne Unterschrift gültig.

Die Dokumentensicherheit bei Mailversand wurde mit dem TÜV abgestimmt und bestätigt.

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