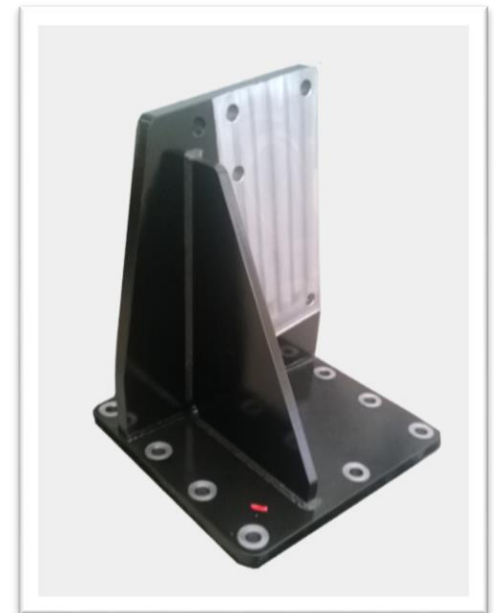
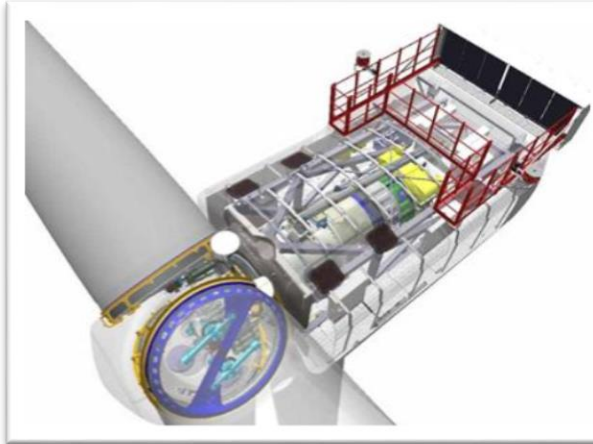


Sub-supplier with specialty in heavy complex
steel constructions and components

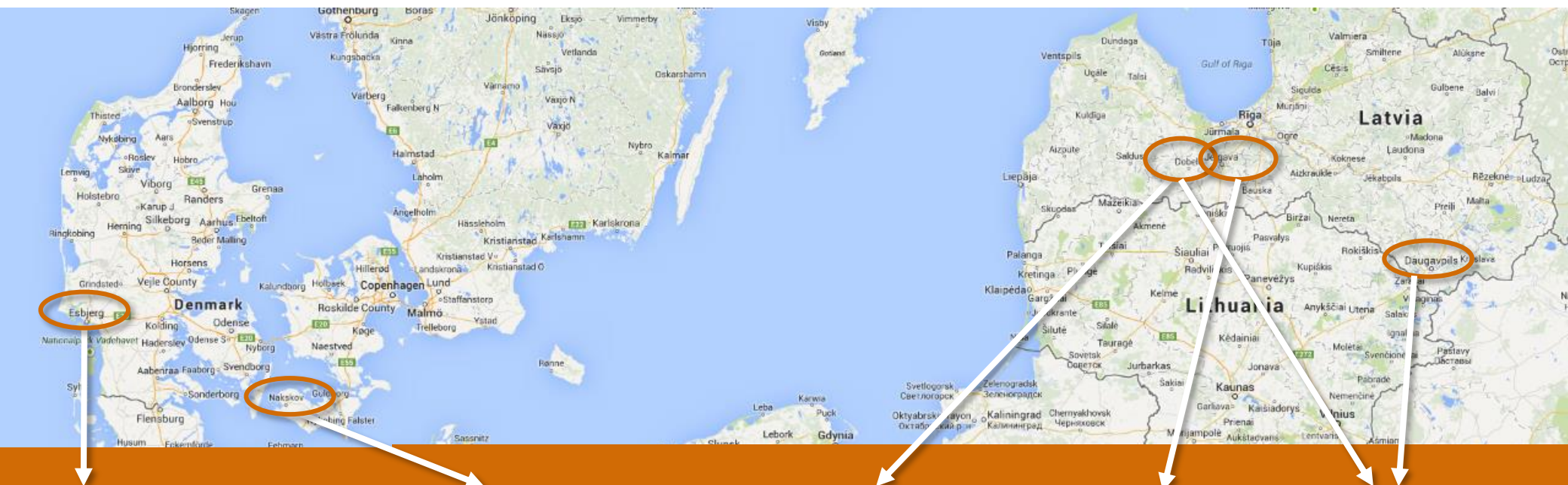
Certified Quality

Large Capacity

A World of Steel



East Metal Overview



Headquarter
Sales, Project
management, Quality,
Finance & Administration

Production
Large, heavy
constructions

EM Order Office
Production

Production
Assembly

Production
Serial production
of
large items

Sub-supplier with specialty in heavy complex steel constructions and components •
Certified quality • Large capacity • Founded in 1997 • More than 700 employees •

Business figures for last 5 years

	Turnover, EUR	Employees	Taxes payed, EUR	
			VSAOI	IIEEN
2011	28,018,307	413	1,591,502	888,766
2012	34,930,033	541	2,256,024	1,243,187
2013	42,432,664	601	2,626,182	1,400,797
2014	46,822,316	700	2,902,247	1,560,739
2015	31,948,352	597	2,354,678	1,222,521

Production Facilities



	 m ²	 m ²
①	14.000	55.000
②	16.600	8.400
③	10.000	3.000
④	3.000	

More than 700 employees



Quality Assurance

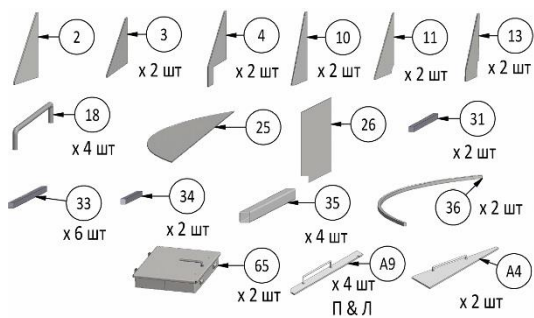


In East Metal we don't compromise quality. Therefore, we have all relevant certificates.

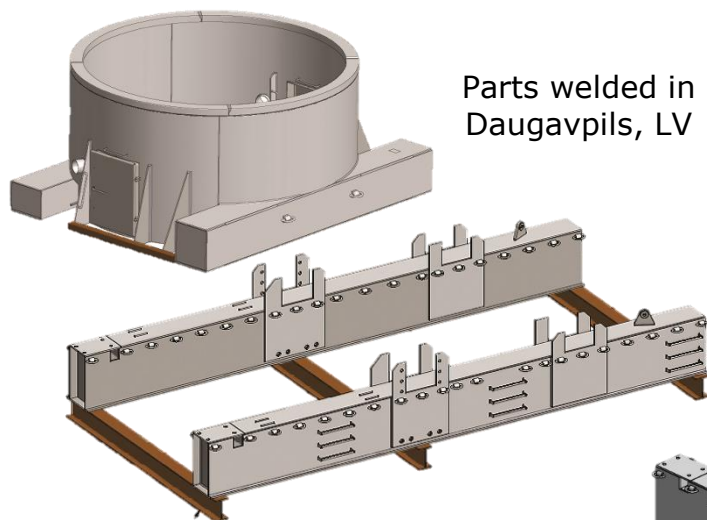


Certificates can be send on request

East Metal's Concept



Components from Dobeles, LV

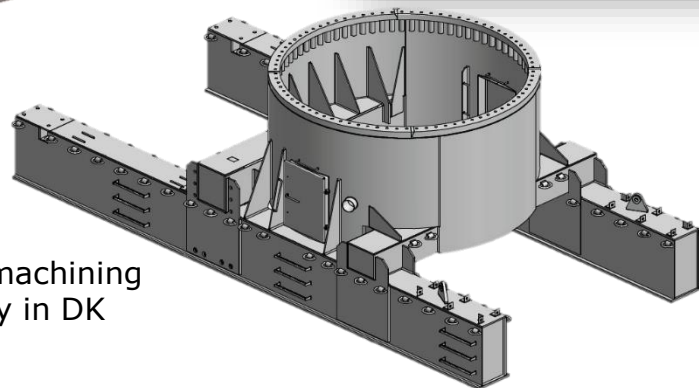


Parts welded in Daugavpils, LV



Transportation frame:
L: 10.000 mm, W: 4.200 mm
H: 3.200 mm, Weight: 32 tons

Final welding, machining and assembly in DK



East Metal's Concept



Lifting Equipment



Middle section welded
and assembled in
Nakskov

Parts produced in Dobeles

2 end sections
welded in
Daugavpils



Welded and
assembled and
delivered from
Nakskov



Case: Other projects



Pulling Test Center



Capacity:

Max. pulling strength:
1500 tons

Direct access to harbor quay



- Project management
- Product development
- Production maturing
- Production of single units
- Manufacturing of serial production of products
- Core competences:
 - Welding
 - CNC-machining of large structures
 - Pulling test stands
 - Surface Treatment
 - Assembly
 - Logistic solutions



References



SIEMENS

IB ANDRESEN INDUSTRI

Specialists in processing and shaping of **steel**

CERTEX
Lifting Products and Services

Vestas

 **SEMCO**
maritime

OMMELIFT


Eltronic

 **AH Industries**
improving solutions together

 **MHI VESTAS OFFSHORE WIND**

Welltec

 **HAARSLEV**
INDUSTRIES



JOHN DEERE

SVENDBORG BRAKES

 **DAMPTECH**
Earthquake Protection

Roblon

 **STENHØJ**



AB INVENTECH
INNOVATION - RATIONALIZATION - AUTOMATION

A. Vølund & Søn A/S
AVOS

EAST METAL DAUGAVPILS FACILITY

	Area m ²
Main building	6278
Surface treatment	1436
Rols 1	1582
Rols 2	2750
Rols 3	1348
Rols 4	1862
Rols 5	364

Outside areas: 7.000 sqm

Factory areas: 14.000 sqm

Capacity: >400.000 hours

Totally: 302

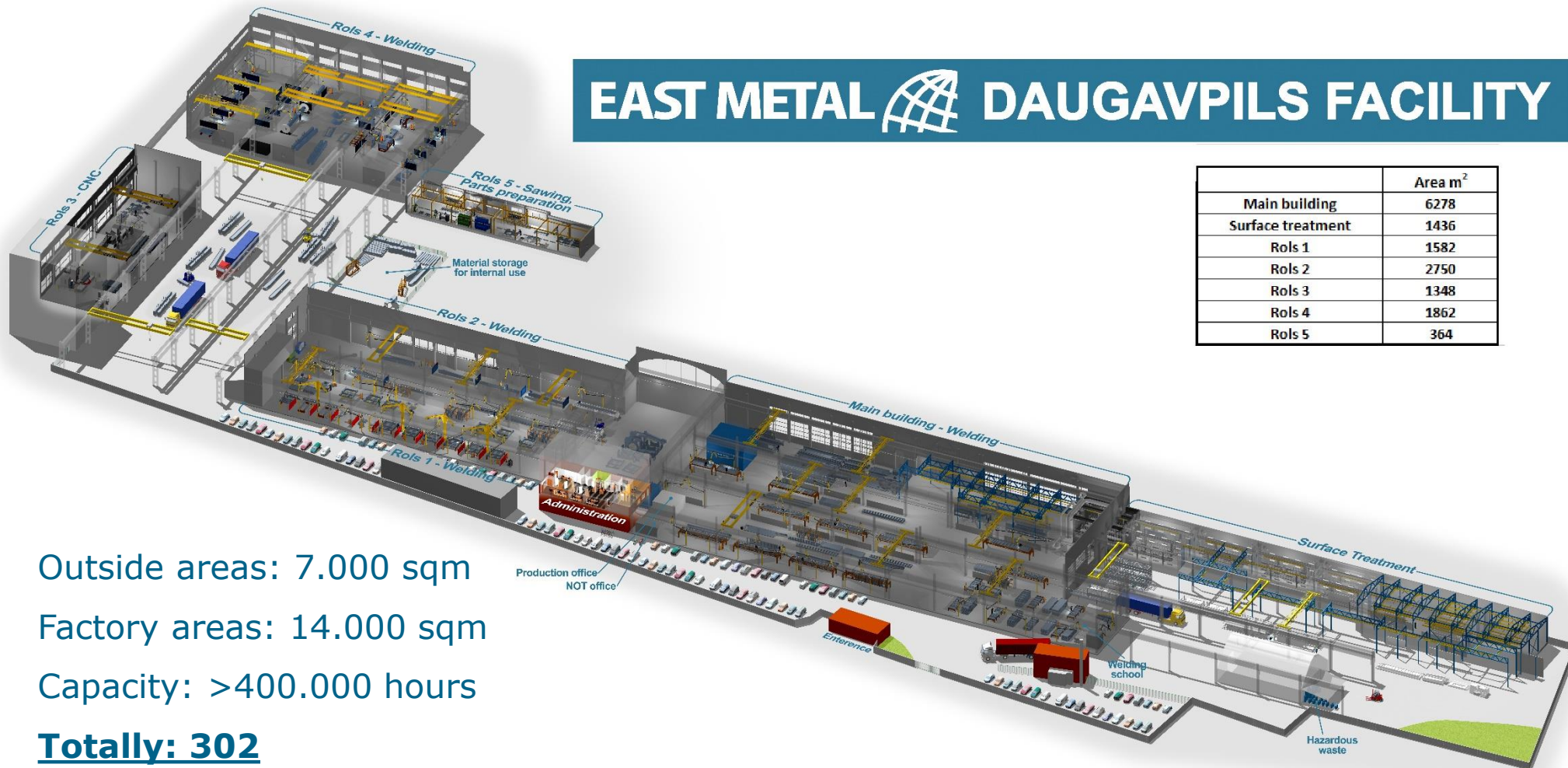
Welders: 132

Metalworkers: 39

Painting workers: 40

Controllers: 24

Engineers: 9



INTERNATIONAL INSTITUTE OF WELDING

Having met the Education and Training requirements of IIW Guideline 'International Welding Engineer' and by examination having satisfied the requirements of the Examination Board of the IIW Authorised National Body

Vasilijs Mihailovs

Date of birth: 1951-12-26

is hereby awarded the diploma of
INTERNATIONAL WELDING ENGINEER

Date: 2007-06-25

Diploma No.: D-SLV-18069-1173-070625-018-382IIW

Dr.-Ing. W. Koch
DVS®-Examination Board
The Chairman
(Stamp, name, signature)

J. Hoffmann
DVS®-Welding School
The Head
(Stamp, name, signature)

DVS
PERSZERT

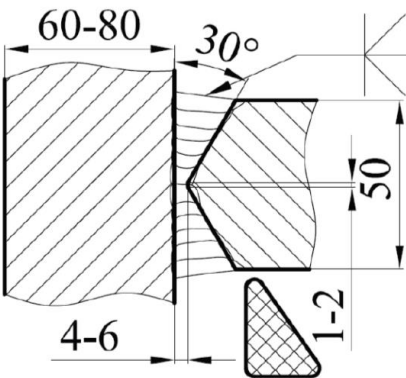
IIW Authorised National Body
for Germany

SLV
Schweißtechnische Lehr- u. Versuchsanstalt MV GmbH

EAST METAL

Welding Engineers – 3 IWE

3.)	WPQR Nr.	135-18-T-60
Savienojuma veids Joint type		BW, bs mb, ml
Metināšanas stāvoklis Welding position		PA
Materiāla marka; grupa Material grade; group		S355J2; 1.2



Welding engineering – welding of samples to qualify the procedures



Fig.1. General view of metallographic section 103_MG perpendicular to the weld axis

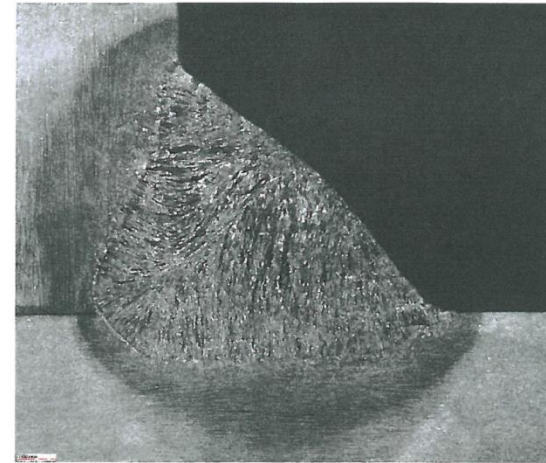


Fig.1. General view of metallographic section 33_MG1 perpendicular to the weld axis

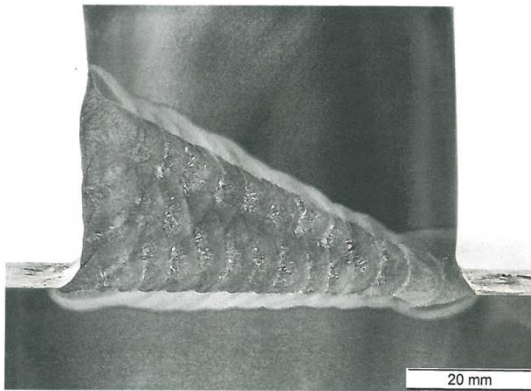


Fig.2. General view of metallographic section 126_MG/2 perpendicular to the weld axis

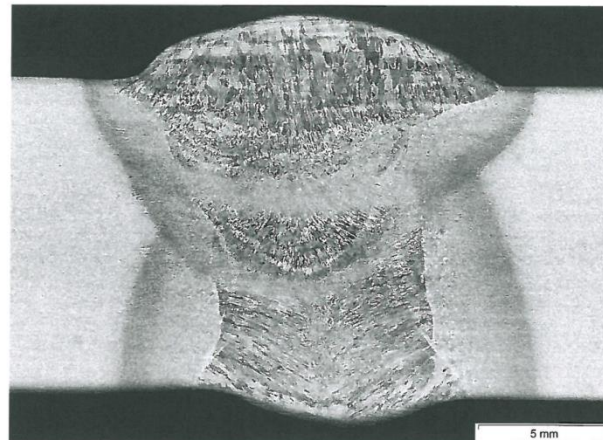


Fig.1. General view of metallographic section 174_MG perpendicular to the weld axis

Welding engineering – WPS – welding procedure specification

Ražotājs Manufacturer	SIA "EAST METAL", Uzvaras 55, Dobele	Konstrukcija Construction	SIEMENS; D115508 (Lifting bracket 100T for Q4825, Q45, 124pcs)
WPS Nr. WPS No	690	Revīzija Revision	R0
Strāvas tips, polaritāte Current Type, Polarity	DC+	Sagatavošanas un attīrīšanas metode Method of Preparation and Cleaning	Machining (tolerance for angular dimensions $\pm 3^\circ$)
H ₂ skala / scale	D	Metāla pārnese veids Mode of metal transfer	Strūklveida pārnese Spray transfer
		Maksimālais oglekļa ekvivalents (CE) Maximum allowable carbon equivalent (CE)	0.45

Savienojuma skice / Joint Details EN 9692:

1.) WPQR Nr.	135-18-FW5-30/30S	2.) WPQR Nr.	135-18-FW8-30/30S	3.) WPQR Nr.	135-18-T-60
Savienojuma veids Joint type	FW sl	Savienojuma veids Joint type	FW ml	Savienojuma veids Joint type	BW, bs mb, ml
Metināšanas stāvoklis Welding position	PB	Metināšanas stāvoklis Welding position	PB	Metināšanas stāvoklis Welding position	PA
Materiāla marka; grupa Material grade; group	S355J2; 1.2	Materiāla marka; grupa Material grade; group	S355J2; 1.2	Materiāla marka; grupa Material grade; group	S355J2; 1.2

$h \leq 1.0 \text{ mm}$

$h \leq 1.5 \text{ mm}$

Metināšanas režīmi / Welding Details

Savienoj. Joint	Gājiens Run	Process Process	Stieples diametrs Size of Filler Metal (mm)	Strāva Current (A)	Spriegums Voltage (V)	Stieples padeves ātrums Wire Feed Speed (m/min)	Metināšanas ātrums Welding speed (mm/min)	Siltuma pievade Heat input (kJ/mm)
1	1	135	1.2	280-320	30-32	10-12	380-480	0.84-1.29
2	visi/all	135	1.2	280-320	30-32	10-12	380-430	0.94-1.29
3	sakne/root	135	1.2	250-290	29-31	9-11	150-185	1.88-2.88
	starpj./fill	135	1.2	310-350	32-34	12-13	270-350	1.36-2.12
	nosedz./cover	135	1.2	310-350	32-34	12-13	325-425	1.12-1.76

Stieples apzīmējums Filler material designation	ISO 14341-A-G3Si1 NOVOFIL SG-2	Metināšanas tehnika Welding Technique	
Aizsarggāze Shielding gas	ISO 14175-M21-ArC-18	Degļa leņķis (α) Torch angle (α)	0°-15°
Aizsarggāzes plūsmas lielums Shielding Gas Flow Rate	14-18 l/min	Attālums no kontaktuzgaļa līdz detaļai Distance contact tube/work piece	15 – 20 mm
Saknes gājienu apstrāde no pretējās puses Back gouging	Slīpēšana Grinding		
Iepriekšējās uzsildīšanas temperatūra Preheat Temperature	≥ 5 °C	Sprauslas diametrs Diameter of Torch Nozzle	16 mm
Starpgājienu temperatūra Interpass Temperature	max 250 °C	Gājienu maksimālais platums Maximum width of run	30 mm

Ražotājs
Manufacturer

R. Mētra

(Uzvārds un paraksts / Name and signature)

Izstrādātājs
Designer

A. Koško

(Uzvārds un paraksts / Name and signature)

Apstiprināja
Approved by

A. Koško

(Uzvārds un paraksts / Name and signature)

3.)	WPQR Nr.	135-18-T-60
Savienojuma veids Joint type	BW, bs mb, ml	
Metināšanas stāvoklis Welding position	PA	
Materiāla marka; grupa Material grade; group	S355J2; 1.2	

Welding engineering – qualification of welders

**Tehnisko ekspertu SIA
"TUV Nord Baltik"**
PERSONĀLA SERTIFIKĀCIJAS CENTRS



WELDER'S QUALIFICATION TEST CERTIFICATE

Page 1 of 2

1 Designation (s): EN 287-1 135 P BW 1.2 S t15 PA ss mb
2
3 Examining Body: "TUV Nord Baltik" TE Ltd Personal certification centre
4
5 Certificate No: TNB PSC – MI – 131114/898E Notified Body number: 1409
6
7 Welding Procedure Specification (WPS) No: 360 R0; 0078 R1
8 Welder's name, surname: Ints Garguns
9 Identification: 130387 – 10028
10 Method of identification: Passport
11 Date and place of birth: Latvia, Jelgava, 13.03.1987
12 Employer: "EAST METAL" Ltd
13 Code / Testing Standard: LVS EN 287-1: 2012L
14 Supplementary fillet weld test: Yes / No (t12 PB sl) (Delete as necessary)
15 Job knowledge: Acceptable / not tested (Delete as necessary)



	TEST PIECE	RANGE OF QUALIFICATION
16	135 (MAG)	135; 138
17	Welding process (es)	P
18	Product type (plate or pipe)	P; T
19	Type of weld	BW, FW
20	Material group(s)	1.2; 1.1; 1.2; 1.4
21	Filler material (Designation)	S, M
22	Shielded gas (acc. to EN ISO 14175)	M21-ArC-18
23	Auxiliaries (e.g. backing gas)	
24	Material thickness [mm]	≥ 5,0
25	Outside pipe diameter [mm]	≥ 150,0
26	Welding position	PA, PB
27	Weld details	ss, mb, ml

28 Additional information is available on attached sheet and / or welding procedure specification No: 360 R0; 0078 R1

Type of tests	Performed and accepted	Not tested
30		
31	Visual testing (BW; FW)	X
32	Ultrasonic testing (BW)	X
33	Fracture test (FW)	X
34	Bend test (BW)	X
35	Notch tensile test	X
36	Macroscopic examination	X

37 We certify that the above statements are correct and that the test pieces were prepared, welded and tested in accordance with the specified codes of standards.

38 Prolongation for qualification by examining body for the following 2 years

Date	Signature	Position or title

42 Continued overleaf

43 Only the original of this certificate or authenticated copies are valid as proof of welder qualification

TE SIA "TUV Nord Baltik" Personāla sertifikācijas centrs / "TUV Nord Baltik" TE Ltd Personal certification centre
Kiljānu ielā 23, Rīgā, LV-1012, Latvija/23 Kiljānu Street, Riga, LV-1012, Latvia
Tālrunis/telephone: +371 67373138, fakss/fax: +371 67820303, E-mail: af@tuv-nord.lv, http://www.tuv-nord.lv

**Tehnisko ekspertu SIA
"TUV Nord Baltik"**
PERSONĀLA SERTIFIKĀCIJAS CENTRS



WELDER'S QUALIFICATION TEST CERTIFICATE

Page 1 of 2

1 Designation (s): EN 287-1 141 P FW 1.2 S t06 PF sl
2
3 Examining Body: "TUV Nord Baltik" TE Ltd Personal certification centre
4
5 Certificate No: TNB PSC – MI – 121213/899E Notified Body number: 1409
6
7 Welding Procedure Specification (WPS) No: 0075 R1
8 Welder's name, surname: Valerijs Gromovs
9 Identification: 200689 – 12216
10 Method of identification: Passport
11 Date and place of birth: Latvia, Dobeles, 20.06.1989
12 Employer: "EAST METAL" Ltd
13 Code / Testing Standard: LVS EN 287-1: 2012L
14 Supplementary fillet weld test: Yes / No (Delete as necessary)
15 Job knowledge: Acceptable / not tested (Delete as necessary)



	TEST PIECE	RANGE OF QUALIFICATION
16	141 (TIG)	141, 142, 143 un 145
17	Welding process (es)	P
18	Product type (plate or pipe)	P; T
19	Type of weld	FW
20	Material group(s)	1.2
21	Filler material (Designation)	S
22	Shielded gas (acc. to EN ISO 14175)	1.1 (Ar)
23	Auxiliaries (e.g. backing gas)	
24	Material thickness [mm]	≥ 3,0
25	Outside pipe diameter [mm]	≥ 150,0 (PA, PB)
26	Welding position	PA, PB, PF
27	Weld details	sl

28 Additional information is available on attached sheet and / or welding procedure specification No: 0075 R1

Type of tests	Performed and accepted	Not tested
30		
31	Visual testing	X
32	Ultrasonic testing	X
33	Fracture test	X
34	Bend test	X
35	Notch tensile test	X
36	Macroscopic examination	X

37 We certify that the above statements are correct and that the test pieces were prepared, welded and tested in accordance with the specified codes of standards.

38 Prolongation for qualification by examining body for the following 2 years

Date	Signature	Position or title
13.06.2013.		
13.12.2013.		

42 Continued overleaf

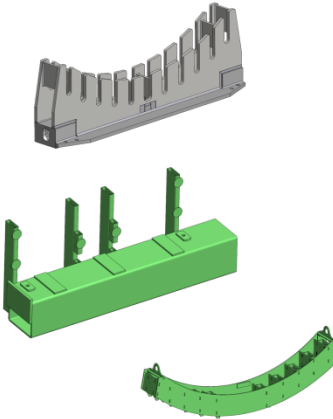
43 Only the original of this certificate or authenticated copies are valid as proof of welder qualification

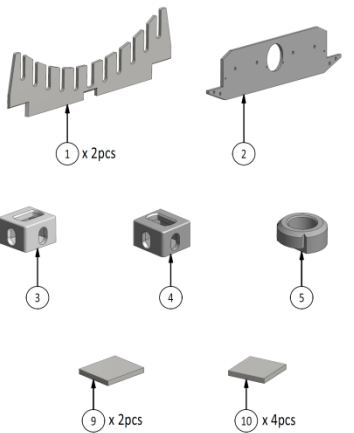
TE SIA "TUV Nord Baltik" Personāla sertifikācijas centrs / "TUV Nord Baltik" TE Ltd Personal certification centre
Kiljānu ielā 23, Rīgā, LV-1012, Latvija/23 Kiljānu Street, Riga, LV-1012, Latvia
Tālrunis/telephone: +371 67373138, fakss/fax: +371 67820303, E-mail: af@tuv-nord.lv, http://www.tuv-nord.lv

Welding engineering – welding plan

Internal dwg nr.
003448-xx-000

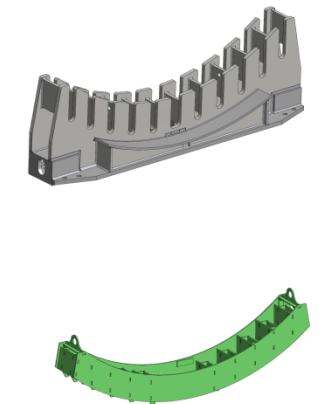
A1.1-A1.11

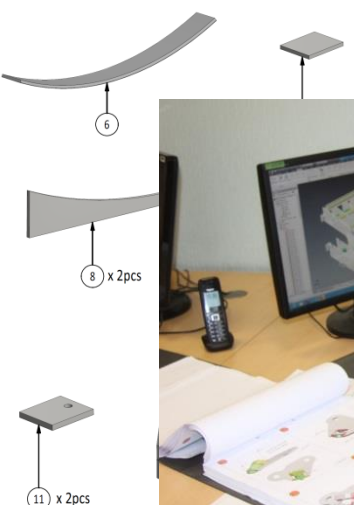


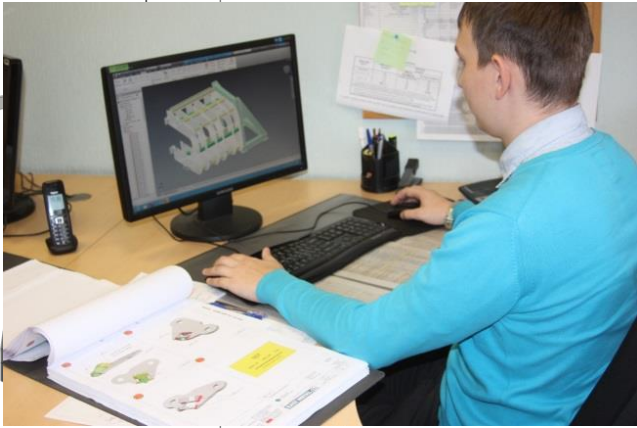


Internal dwg nr.
003448-xx-000

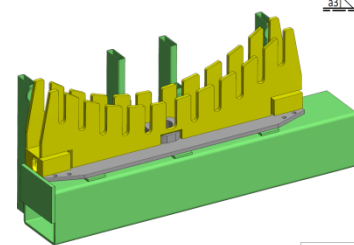
B1.1-B1.7





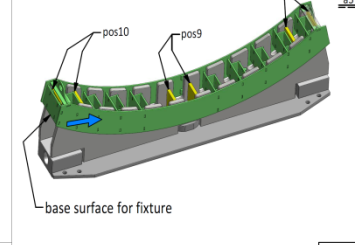


A1.1



WPS 007

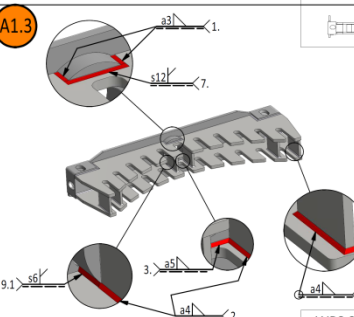
A1.2



base surface for fixture

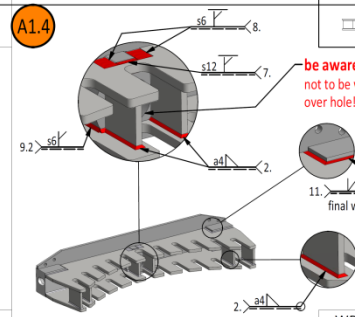
WPS 007

A1.3



WPS 020

A1.4

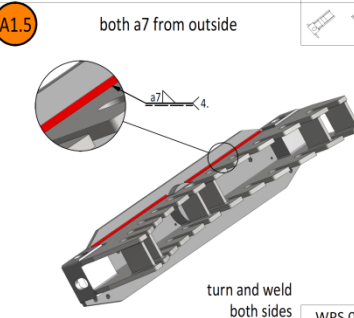


be aware!
not to be welded
over hole!

final weld

WPS 020

A1.5

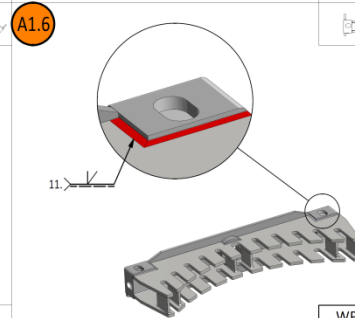


both a7 from outside

turn and weld
both sides


WPS 020

A1.6



WPS 020

No



Designations/Apzīmējumi

Position/
Stāvoklis

Reference/
Atsauce

Welding plan

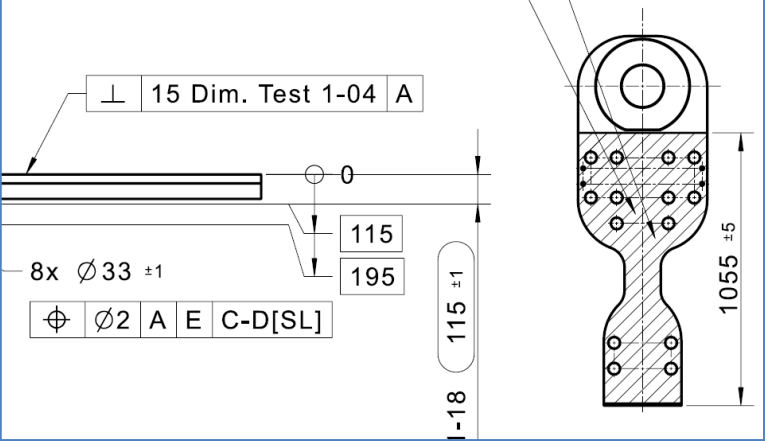
Rev. 02

Sheet 2 / 5

Geometry engineers (3) – preparing for measuring and reporting

Purchasing Specification
Restricted
Siemens corporate proprietary information

DT Report				Page 1/2		
Period of examination / Date 15.10.2015		Contractor EAST METAL		Client SIEMENS		
Object Main beam for Rear End D6 - GOW		Construction ID no. SWPDK015241509182 A9B10109548		Location Stiklu iela 7g, Daugavpils, Latvija		
Drawing no. D1033796		ECN. no. 175668		Drawing no. D1033796		
ECN. no. 175668		ECN. no. 175668		ECN. no. 175668		
Dimensional test						
Examination procedure specification – if relevant: Checking instruction Dim R2 D1033796-175668						
Measurement no.		Specified measurement	Actual measurement	Measuring tool ID no.	Result of evaluation	
Dim. Test-1-1			Min: 0.5 Max: 0.5	BD-19	☑ ☐ Acc. Not acc.	
Dim. Test-1-2			Min: 0.5 Max: 0.5	EM-02	☑ ☐ Acc. Not acc.	
			Min: 1	M-548	☑ ☐	



Measuring with laser tracker

EAST METAL 

API AUTOMATED
PRECISION



Welders



Certified welders according
EN ISO 9606

135 process: 276 certificates

136 process: 65 certificates

121 process: 17 certificates

14x process: 17 certificates

783 process: 13 certificates

Welding operators:
51 certificates



CNC machining



Object size: 4x2.5x1.2 m

Object size: 10x3.5x1.2 m



Surface treatment



Object size:

14x4x2.2 m

Object weight: 8 t

Painting and
Metalizing up to
corrosion class C5

New CNC and new workshop



805 m², to be employed:
8 CNC workers
2 maintenance people

2017/02/24



FPT M-ARX

EAST METAL 



Object size:
16x4.5x1.5 m

