



BM TRADA

CERTIFICATE OF CONFORMITY OF THE FACTORY PRODUCTION CONTROL

Notified Body No. 1224

In compliance with *Regulation 305/2011/EU of the European Parliament and of the Council of 9 March 2011* (the Construction Products Regulation or CPR), this certificate applies to the construction product

Structural Steel Components

intended for load bearing applications

Execution Class	Up to EXC 2
Declaration Method	No design (Fabrication only)
Welding Process(es)	None
Parent Metal/s	N/A
Parent Metals Group(s) & Sub Group(s)	N/A
Responsible Welding Co-ordinator/s	N/A

produced by or for

River Profiles Ltd
Unit 2 Old Mill Lane
Pratling Street
Aylesford
Kent
ME20 7DT

and produced in the manufacturing plant(s)

River Profiles Ltd, Unit 2 Old Mill Lane, Pratling Street, Aylesford, Kent
ME20 7DT

This certificate attests that all provisions concerning the assessment and verification of constancy of performance described in Annex ZA of the standard

EN 1090-1:2009+A1:2011

under system 2+ are applied and that

the factory production control fulfils all the prescribed requirements set out above.

This certificate was first issued on 7 November 2014 and will remain valid until the date of expiry shown, provided that the test methods and/or factory production control requirements included in the harmonised standard, used to assess the performance of the declared characteristics, do not change, and the product, and the manufacturing conditions in the plant are not modified significantly.

Certificate number:

1224-CPR-0694

Date of initial BM TRADA Certification:

7 November 2014

Date of last issue:

7 November 2014

Certificate expiry date:

6 November 2017

Kevin Towler
Director

BM TRADA Certification Ltd, Chiltern House, Stocking Lane, High Wycombe, Buckinghamshire, HP14 4ND, UK

This certificate remains the property of BM TRADA Certification Ltd. This certificate and all copies or reproductions of the certificate shall be returned to BM TRADA Certification Ltd or destroyed if requested. Further clarification regarding the scope of this certificate and verification of the certificate is available through BM TRADA at the above address or at www.bmtrada.com



ISO 9001 REGISTERED

This document certifies that the quality management systems of

RIVER PROFILES LIMITED

Unit 2, Old Mill Lane, Aylesford, Kent ME20 7DT

have been assessed and approved by QMS International plc to the following quality management systems, standards and guidelines:-

ISO 9001 : 2008

The approved quality management systems apply to the following:-
THE MANUFACTURE, PROCESS AND SUPPLY OF STEEL AND NON-FERROUS
COMPONENTS INCORPORATING THE REQUIREMENTS OF BS EN 1090-1.

Original Approval: 23 July 2014

Current Certificate: 23 July 2014

Certificate Expiry: 22 July 2024

Certificate Number: GB 22481



On behalf of QMS International plc

This Certificate remains valid while the holder maintains their quality management systems in accordance with the standards and guidelines above, which will be audited by QMS International plc

This Certificate is the property of QMS International plc and must be returned in the event of cancellation.

Declaration of Performance

Ref RPF053 Issue 1

Process:	Thermal Cutting CO² Laser - Oxy/Propane
Intended use:	Structural bespoke metallic construction profiled and formed components intended for use in steel structures or composite steel and concrete structures. Components can be produced using hot and cold formed materials and other technologies.
Manufacturer:	River Profiles Ltd, Unit 2 Old Mill Lane, Pratling Street, Aylesford, Kent ME20 7DT
System of assessment and verification of constancy performance:	System 2+
Notified Body:	BM TRADA Chiltern House Stocking Lane, Hughenden Valley High Wycombe Buckinghamshire, HP14 4ND
Notified Body Number:	1224

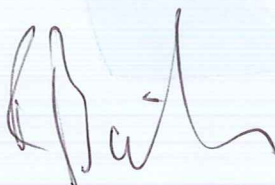
BM Trada has performed (i) initial inspection of the manufacturing plant and factory product control and (ii) continuous surveillance, assessment and evaluation of factory production control and issued Factory Production Control Certificate **1224-CPR-0694** and Welding Certificate **N/A**

Essential characteristics	Performance	Harmonised technical specification
Tolerances on dimensions and shape	BS EN 1090-2, Quality of Cut surfaces in accordance with EN ISO 9013. Hardness of free edge surfaces in accordance with BS EN 1090 - 2: 2008 +A1 2011	BS EN 1090 –1:2009+A1:2011
Weldability	BS EN 10025-2; S235, S275, S355 BS EN10210-1/BS EN10219-1: S235,S275, S355, S420,S460 BS EN 1090 - 2 (Hardness tolerance <380HV)	BS EN 1090 –1:2009+A1:2011
Fracture toughness / brittle strength (steel components only)	BS EN10025 -2/BS EN10210-1/BS EN10219-1 JR(H) 27J @ 20°C JO (H) 27J @ 0°C J2(H) 27J @ -20°C K2(H) 40J @ -20°C NH, NLH, MH, MLH 40J @ -20°C & 27J @ -50°C BS EN 1090 - 2 (Hardness tolerance <380HV)	BS EN 1090 –1:2009+A1:2011
Load bearing capacity	No Performance Determined	BS EN 1090 –1:2009+A1:2011
Fatigue strength	No Performance Determined	BS EN 1090 –1:2009+A1:2011
Resistance to fire	No Performance Determined	BS EN 1090 –1:2009+A1:2011
Reaction to fire	Class A1 (Steel only)	BS EN 1090 –1:2009+A1:2011
Release of cadmium and its compounds	No Performance Determined	BS EN 1090 –1:2009+A1:2011
Radioactivity	No Performance Determined	BS EN 1090 –1:2009+A1:2011
Durability	No Performance Determined	BS EN 1090 –1:2009+A1:2011

The performance of the product identified above is in conformity with the declared performance identified in the table.

Signed for and on behalf of **River Profiles Ltd** by:

**Roy Burmingham
Managing Director
River Profiles Ltd**





Declaration of Performance

Ref RPF063 Issue 1

Process:	Holing
Intended use:	Structural bespoke metallic construction profiled and formed components intended for use in steel structures or composite steel and concrete structures. Components can be produced using hot and cold formed materials and other technologies.
Manufacturer:	River Profiles Ltd, Unit 2 Old Mill Lane, Pratling Street, Aylesford, Kent ME20 7DT
System of assessment and verification of constancy performance:	System 2+
Notified Body:	BM TRADA Chiltern House Stocking Lane, Hughenden Valley High Wycombe Buckinghamshire, HP14 4ND
Notified Body Number:	1224

BM Trada has performed (i) initial inspection of the manufacturing plant and factory product control and (ii) continuous surveillance, assessment and evaluation of factory production control and issued Factory Production Control Certificate 1224-CPR-0694 and Welding Certificate N/A

Essential characteristics	Performance	Harmonised technical specification
Tolerances on dimensions and shape	BS EN 1090-2, Tolerance class D.1.8 Fastener holes, notches and cutouts. BS EN 1090-2, Quality of Cut surfaces in accordance with EN ISO 9013. Hardness of free edge surfaces in accordance with BS EN 1090 - 2: 2008 +A1 2011	BS EN 1090 -1:2009+A1:2011
Weldability	BS EN 10025-2; S235, S275, S355 BS EN10210-1/BS EN10219-1: S235,S275, S355, S420,S460 BS EN 1090 - 2 (Hardness tolerance <380HV)	BS EN 1090 -1:2009+A1:2011
Fracture toughness / brittle strength (steel components only)	BS EN10025 -2/BS EN10210-1/BS EN10219-1 JR(H) 27J @ 20°C JO (H) 27J @ 0°C J2(H) 27J @ -20°C K2(H) 40J @ -20°C NH, NLH, MH, MLH 40J @ -20°C & 27J @ -50°C BS EN 1090 - 2 (Hardness tolerance <380HV)	BS EN 1090 -1:2009+A1:2011
Load bearing capacity	No Performance Determined	BS EN 1090 -1:2009+A1:2011
Fatigue strength	No Performance Determined	BS EN 1090 -1:2009+A1:2011
Resistance to fire	No Performance Determined	BS EN 1090 -1:2009+A1:2011
Reaction to fire	Class A1 (Steel only)	BS EN 1090 -1:2009+A1:2011
Release of cadmium and its compounds	No Performance Determined	BS EN 1090 -1:2009+A1:2011
Radioactivity	No Performance Determined	BS EN 1090 -1:2009+A1:2011
Durability	No Performance Determined	BS EN 1090 -1:2009+A1:2011

The performance of the product identified above is in conformity with the declared performance identified in the table.

Signed for and on behalf of River Profiles Ltd by:

Roy Burmingham
Managing Director
River Profiles Ltd

RPF063 Issue 1

River Profiles Ltd
Old Mill Lane
Aylesford
Kent
ME20 7DT

Your Ref: PO RP0939
Our Ref: 0003254
Date: 5th November 2014

SURFACE PROFILE MEASUREMENTS OF THERMAL CUTS

Document Number M7991R1

Samples Received 28th October 2014. (8 steel test plates identified as in test results)

Specification BS EN ISO 9013:2002

Characteristic values – perpendicularity (u) and mean height profile R_z

Test Method

The perpendicularity was measured using a calibrated set square and feeler gauge on a surface table. The R_z value was measured using a Surtronic 3p machine (Note the 1.2mm thick sheet was measured microscopically on polished sections as it was thin)

Results.

Sample	u (mm)	Range	R_z (µm)	Range
GB40221 S355J2+N (250x150x50) Straight cut	0.40	2	45.4	2
DB48481-5 S355J2+N (250x150x25) Straight cut	0.03	2	73.4	3
DB48481-5 S355J2+N (250x150x25) Curved arc	0.17	2	79.3	3
JB1003 S355J2+N (250x150x10) Straight cut	0.04	1	79.3	3
HB40165 S275 (200x150x15) Straight cut	0.10	2	38.9	2
HB40455 S275 (200x150x8) Curved arc	0.03	1	50.1	3
HB40455 S275 (200x150x8) Straight cut	0.03	1	52.2	3
1.2CR (200x150x1.2) Straight cut	0.04	1	29.2	2



Tim Norman BSc,MSc
Principal Materials Consultant

End of Report

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