

Recommended heating-up schedules of castable refractories

Product Heating-up schedules	Category		
	Low Cement Castables for Aluminum Industries Example: GIBRAM, ASAL-85Z	"RE" type Low Cement Castables Example: Ramcrete, Drysic, Rheo-fow WPC-S series	Conventional Castable Refractories Example: CA, LC and WPC series
From room temperature to 200°C	50°C/hour	50°C/hour	50°C/hour
Maintain a temperature of 200°C for certain hours calculated as per the instructions provided.	Calculate the time to be maintained considering the lining thickness. 10-mm thickness corresponds to 1 hour. Example: When the lining thickness is 200 mm, the time to be maintained shall be 20 hours.	Calculate the time to be maintained considering the lining thickness. 20-mm thickness corresponds to 1 hour. Example: When the lining thickness is 200 mm, the time to be maintained shall be 10 hours.	Calculate the time to be maintained considering the lining thickness. 20-mm thickness corresponds to 1 hour. Example: When the lining thickness is 200 mm, the time to be maintained shall be 10 hours.
From 200°C to 350°C	25°C/hour	25°C/hour	50°C/hour
Maintain a temperature of 350°C for certain hours calculated as per the instructions provided.	Calculate the time to be maintained considering the lining thickness. 10-mm thickness corresponds to 1 hour. Example: When the lining thickness is 200 mm, the time to be maintained shall be 20 hours.	Calculate the time to be maintained considering the lining thickness. 20-mm thickness corresponds to 1 hour. Example: When the lining thickness is 200 mm, the time to be maintained shall be 10 hours.	Calculate the time to be maintained considering the lining thickness. 20-mm thickness corresponds to 1 hour. Example: When the lining thickness is 200 mm, the time to be maintained shall be 10 hours.
From 350°C to the operational temperature	25°C/hour	50°C/hour	50°C/hour

Remarks: The heating-up schedule for drying in the above table is our recommended standard one to prevent cracks and explosive fractures. In actual heating up for drying, if the lining area to be dried is relatively broad, the actual heating up schedule shall be deviated from the standard one, area by area of the lining.
Please control such deviation within $\pm 30^{\circ}\text{C}$ from the standard one for any area and carry out the homogeneous heating up as much as possible.