



VARDHMAN SPECIAL STEELS LTD.

C-58, FOCAL POINT, PHASE V, LUDHIANA (PB.) INDIA

Ph. No.: 0161-2670707-09

IS : 7283

QF MSD 4.12.06

ISO/TS 16949 : 2009

Certificate : 37659-2008

ISO 14001 : 2004

Certificate : 177315-2015

OHSAS 18001 : 2007

Certificate: 177314-2015

TEST CERTIFICATE

TEST CERTIFICATE NO. 2018/04/392

DATE. 18/04/2018



CM/L-970002816

To HAPPY FORGINGS LTD (UNIT-II)

We certify that the material described below fully conforms to IS:7283-1992. Chemical Composition and Mechanical Properties of the product tested in accordance with the Scheme of Testing and Inspection contained in the BIS Certification Marks licence No. CM/L-970002816 are as indicated below against each order No. etc.

(PLEASE REFER TO IS:7283-1992 FOR DETAILS OF SPECIFICATION REQUIREMENTS)

TEST RESULTS

Order No. & Date	Invoice No.	Grade	Heat No (Cast No)	Finished Section (Nominal Size mm)	Qty	Finish Shape	Cast Section (mm)	Red. Ratio	Supply Cond.	Color Code	Length of Bar	No of Bars
	SAH180000 18.2	1E1120	64709	90mm	28.04	RCS	200*200	4.9	Hot Rolled	Red Base / White Line	3-6MTR	95

Manufacturing Route EAF-LRF-VD-CCP With EMS & AMLC

% CHEMICAL COMPOSITION

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu	Sn	Al	Ti	Ca	B	V
Min.	0.19	--	0.80	0.015	--	--	0.45	0.08	--	--	0.020	--	--	--	--
Max.	0.23	0.18	1.10	0.025	0.020	--	0.70	0.25	--	--	--	--	0.0020	--	--
Actual	0.22	0.13	1.05	0.018	0.016	0.045	0.665	0.11	0.09	0.005	0.026	0.0015	0.0010	0.0002	0.004
	O2	N2	H2	Grain Size			Total Decarb (mm)			D.I. Value		Micro Structure			
	In PPM			(IS:4748/ASTM E112)			(IS:6396)								
Min.	--	--	--	5			--			43.2 mm		--			
Max.	--	--	--	--			--			61.0 mm		--			
Actual	13	78	1.2	6.5/7.5			--			50.76 mm		--			

INCLUSION RATING - IS:4163 / ASTM E45A/ ISO 4967, Method A

	A		B		C		D		JIS			DIN		Hardness BHN	
	Thin	Thick	Thin	Thick	Thin	Thick	Thin	Thick	A	B+C	Total	K3	K4	Min	Max
Max.	3.0	2.0	2.0	1.0	0.5	0.5	1.0	1.0						--	223
Actual	2.0	--	0.5	--	--	--	1.0	--						190	210

JOMINY HARDENABILITY (IN HRC) (IS 3848)

MM / Inch	J1/16	J3/16	J8/16												
Min.	43	35	--												
Max.	48	--	29												
Actual	44.5	39.5	24.0												

MECHANICAL PROPERTIES (IS 1608)

	Test Condition	Tensile Strength	Yield Strength	Elongation	Reduction Area	Impact Strength
Min.		--	--	--	--	--
Max.	--	--	--	--	--	--
Actual	--	--	--	--	--	--

Supplementary Requirements

Standard	Internal Soundness (ASTM E381 / IS11371)	Step Down (IS 4075) / Blue Fracture Test (IS:10138)	Surface Defects (Visual / MFLT)	Bend Test (IS1599:1985)
Required	C3R3S3 max	As per IS 4075	Depth of defect 0.3 mm max.	---
Actual	C3R3S3 max	OK As per IS 4075	OK	---
	Ultrasonic Test	MFLT	Dimension Tolerance	Ovality / Lobbing
Required	Yes	--	IS:3739	IS:3739
Actual	100% Bars manual ut done & found OK	--	Asper is 3739 gr 1	A s per IS3739 gr 1

Mixup Test 100% Bars Checked by Spark, Metascope, Ni Spot test, Mobile Spectro - OK

The Material Supplied to the Standard rolling Tolerances

Remarks:- Free from radioactive material or banned substances.

Reference Standard IS 7283:1992, Customer Specification Caterpillar Inc. CHG NO.17, DT.28.04.2010

For any Technical Support / Quality related issues please contact -

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For any Test Certificate related issues please contact -

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Checked by :
Engineer - R&D

Approved by :
Authorised Signatory

For VARDHMAN SPECIAL STEELS LTD.