



R. L. STEELS & ENERGY LTD.

TEST CERTIFICATE

Regd. Office: Gut No. 78 to 81, Pangra Shilver Chitegaon, Pathan Road, Aurangabad - 431 107
Maharashtra, India. Phone : 02431-661231, 251163 Fax : 02431-251879
E-mail : qc@rlsteels.com, Website : www.rlsteels.com

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Customer: M/S HAPPY FORGINGS.LTD.(UNIT.II)

B- XXIX-2254/1 & OPP. HINDUSTAN TYRES (ADJ. WARYAM STEELS), KANGANWAL ROAD, PO-JUGIANA, LUDHIANA.

General Information & Material Details

TC NO.	Date	Invoice No.	Date	Truck No.	No. of Pcs	Quantity in MT	Length	Supply Condition	Colour code
17-4136	30-01-2018	RL17-SI-3789	30-01-2018	RJ 50 GA 8395	5	2.040	5.0 TO 6.0 MTR	AS ROLLED	YELLOW+ BLUE+WHITE
Process Route		Heat No.	Grade	As Cast Size		Product Size		Reduction Ratio	Customer TDC
EAF/LRF/VD/CCP-with MEMS		2-VUP-4	EN353	240X280		90RCS		8.26:1	-

Chemical Composition & Tramp Elements

Element	%C	%Si	%Mn	%P	%S	%Cr	%Ni	%Mo	%Cu	%V	%Al	%Ti	%B	%Ca	%As
Min.	0.14	-	0.50	-	0.020	0.75	1.00	0.08	-	-	0.020	-	-	-	-
Max.	0.20	0.35	1.00	0.035	0.040	1.25	1.50	0.15	-	-	0.040	-	-	-	-
Actual	0.19	0.23	0.95	0.030	0.026	1.10	1.03	0.135	-	-	0.027	-	-	-	-

Tramp Elements (Contd.) & DI / CE

Element	%Sn	%Pb	%Sb	CE	DI Value	Gas (PPM)				O2	H2	N2	Size Tol. (MM)	Dimension Tolerance	
Min	-	-	-	-	-	Min				-	-	-	-	As per IS 3739, Grade I.	
Max	-	-	-	-	-	Max				20.00	2.50	90.00	Specification		
Actual	-	-	-	-	-	Actual				11.00	1.10	73.00			

Mechanical Properties

Test Code	Hardness As Rolled (BHN)	Hardness (H&T Condition) (BHN)	YS (Kg/mm ²)	UTS (Kg/mm ²)	%EL	Impact Values (Joules)		Macrostructure	Microstructure
Spec.	240 Max.	-	-	-	-	Izod	Charpy	Macrostructure As per ASTM-E-381	Matrix
Actual Value	206-217	-	-	-	-	-	-	Better Than C2R2S2	Uniform distribution of Ferrite plus Pearlite

Metallurgical Properties

Test Code	Decarb ASTM J419 (mm)	Grain Size as per ASTM E112	Inclusion Rating (As per IS 4163/ ASTM-E-45A) Plate IR				Magnaflux Test (100% Bars)	UT Test (100% Bars)	Spark/ Spectral Test (100% Bars)
			Series	A	B	C	D		
Spec.	-	6.0/8.0	T/H	2.0/1.0	2.0/0.0	2.0/0.0	2.0/1.0	-	-
Actual Value	-	6.0/7.0	T/H	1.5/0.5	0.5/0.0	0.0/0.0	1.5/0.5	OK	OK

Hardenability Test Result

Jominy Distance (mm/inch)	J 7/16"								
Spec (HRC)	37-41								
Actual Hardness (HRC)	37.00								

Remarks : Material is conforming to the customer specification.
NOTE:- This material is made for AL, and is complying to AL Std 258.02

DECLARATION : TEST RESULTS ARE BASED ON ACTUAL TESTS CARRIED OUT ON SAMPLES DRAWN AS PER QUALITY ASSURANCE PLAN. TEST CERTIFICATE CONFORMS TO THE CUSTOMER TDC.

