



R. L. STEELS & ENERGY LTD.

TEST CERTIFICATE

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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
18-0139	16-04-2018	RL18-SI-0182	16-04-2018	RJ 21 GB 3337	152	28.970	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/VDC/CP-with MEMS		2-XGN-4	EN363	180X220		63RCS		9.97:1	-

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	0.185	0.21	0.97	0.022	0.028	1.15	1.04	0.130	-	-	0.023	-	-	-	-

Gas Analysis.

Gas (PPM)		O2	H2	N2	Size Tol. (MM)
Min					
Max		20.00	2.50	90.00	Specification
Actual		11.00	1.00	72.00	As per IS 3739, Grade I.

Tramp Elements (Contd.) & DI / CE

Element	%Sn	%Pb	%Sb	CE	DI Value	Gas (PPM)			Dimension Tolerance		
Min	-	-	-	-	-	Min					
Max	-	-	-	-	-	Max					
Actual	-	-	-	-	-	Actual					

Mechanical Properties

Test Code	Hardness As Rolled (BHN)	Hardness (H&T Condition) (BHN)	YS (Kg/mm ²)	UTS (Kg/mm ²)	%El.	%RA	Impact Values (Joules)		Macrostructure As per ASTM E-381	Microstructure
Spec.	240 Max.	-	-	-	-	-	Izod	Charpy	Better Than C2R2S2	Uniform distribution of Ferrite plus Pearlite
Actual Value	206-217	-	-	-	-	-			C2R1S2	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-46A) Plate IR				Magnaflux Test (100% Bars)	UT Test (100% Bars)	Spark/Spectral Test (100% Bars)
			Series	A	B	C			
Spec.	-	6.0/8.0	T/H	2.0/1.0	2.0/0.0	2.0/0.0	-	-	-
Actual Value	-	6.0/7.0	T/H	1.5/0.5	0.5/0.0	0.0/0.0	OK	OK	OK

Other Test Results

Hardenability Test Result

Jominy Distance (mm/inch)	J 7/16"								
Spec (HRC)	37-41								
Actual Hardness (HRC)	38.00								

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.

For R L STEELS & ENERGY

(AUTHORISED SIGNATORY)

