



# VARDHMAN SPECIAL STEELS LTD.

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

Ph. No.: 0161-2670707-09

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

IS : 7283



CM-L-970002816

Vardhman

TEST CERTIFICATE NO. 2017/12/212

DATE. 10/12/2017

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
	SAAI7000 1997	1E1286	62272	100mm	74530	RCS	200*200	4.0	Hot Rolled	BLACK BASE / RED LINE	3-6MTR	39

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.	0.28	0.15	0.90	0.050	--	--	0.90	--	--	--	0.080	--	--	--	0.05
Max.	0.33	0.35	1.20	0.080	0.035	--	1.20	--	--	--	0.130	--	0.0020	--	0.10
Actual	0.32	0.245	1.13	0.056	0.019	0.075	1.160	0.025	0.12	0.005	0.10	0.0037	0.0004	0.0002	0.07

	O2	N2	H2	Grain Size	Total Decarb (mm)	D.I. Value	Micro Structure
	In PPM			(IS:4748/ASTM E112)	(IS:6396)		
Min.	--	--	--	5	--	92 mm	--
Max.	20	100	2	--	--	122 mm	--
Actual	11	68	1.2	7.0/8.0	--	111.25mm	--

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

	A	B	C	D	JIS	DIN	Hardness BHN
	Thin	Thick	Thin	Thick	Thin	Thick	IS 1500:1983
Max.	3.0	2.0	2.0	1.0	0.5	0.5	Min
Actual	2.0	--	1.0	--	--	1.0	260

### JOMINY HARDENABILITY (IN HRC) (IS 3848)

MM / Inch	J1/16	J14/16	J16/16
Min.	50	37	--
Max.	55	--	48
Actual	52.0	48.5	46.0

### 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.19.11.2010

For any Technical Support / Quality related issues please contact -

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Ridho

Checked by :  
Engineer - R&D

Approved by :  
Authorised Signatory

For VARDHMAN SPECIAL STEELS LTD.