

RAW MATERIAL INCOMING INSPECTION REPORTS

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REPORT NO.	1744	SECTION	65	HAET NO. :-	K19 8780	INVOICE NO. :-	9633080791
DATE :-	4/01/25	STEEL SUPPLIER :-	Kalga	REC.QTY :-	25350/9	INVOICE DATE :-	
	2F-7B	STEEL TC NO. :-	K19 8780	NO. OF BARS :-			
Process / Mill Route							
%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Mo
0.14	1.2	—	0.01	—	1.1	—	—
%Al	%Cu	%As	%Sb	%V	%Pb	%Ca	%Nb
0.02	—	—	—	—	—	—	—
%Ti	%B	%Zr	%Hf	%Ta	%W	%Co	%Fe
—	—	—	—	—	—	—	—
0.161	1.2	0.236	0.02	0.015	1.206	0.186	0.056
0.172	1.25	0.248	0.024	0.017	1.246	0.2	0.058
0.028	0.028	0.104	0.001	0.003	0.004	0.001	0.003
0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003

Bar Size (As per WI...)	Qty : 10 % Of Total Heat											
Diameter/Section Size (In mm)												
S NO	1	2	3	4	5	6	7	8	9	10	11	12
65	64.9	64.8	64.7	64.6	64.5	64.5	64.8	64.6	64.5	64.3		

Gas Content (PPM) As per Mill Tc	N2	H2	O2
Min	90	—	—
Max	—	—	25
Value	122	—	15
Mill Tc			

Steel Supply Condition	AS Rolled
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MACRO	(i) Internal soundness Sample : (ASTM E381 or as per customer)	Value Obs	52	R2	C2
	(ii) Dendrite structure 01 sample :		LS2	CR2	CC2
	(iii) Step Down Test Sample : (IS4075 or as per customer)		AK		

Micro structure As Rolled :	Micro structure : (or as per customer)
Mill Tc	
SSB	

ULTRASONIC TEST (AS PER ASTM A388) :	Mill Tc	100 % OK
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INCLUSION RATING (IS 14163 / ASTM: E45A OR REQUIRED BY CUSTOMER)	A	B	C	D	DS
	Sulphide	Aluminate	Silicate	Oxide	
	TN	TK	TN	TK	TN
	TK	TK	TK	TK	TK
Cust Spec If Any	—	—	2.0	1.0	0.5
Mill Tc	—	—	0.5	0.0	0.0
SSB	—	—	0.5	0.0	0.0

GRAIN SIZE :	Spec :-	5 - 8	Mill Tc	70	SSB	6.5
(ASTME112 / IS-4748)						

JOMINY HARDENBILITY	Distance	J5	J10	J25	J50
IS-3848 /ASTMA255	Specified	29.44	35.40	27.21	24.11
(As per required by Customer)	Mill Tc	41.6	35.5	27.6	24.5
	Observed	40	36	28	25

MECHANICAL PROPERTIES : (If Required in TDC /Customer)	As per IS-1608/ ASTM A 370	As per IS: 1757				
	U.T.S	Y.S	N/mm2	%EL	IMPACT VALUE	IMPACT VALUE
	N/mm2 /MPA	/MPA			CHARRY	IZOD
Specified	—	—	—	—	—	—
Observed	—	—	—	—	—	—
As Rolled Hardness	1	2	3	4	5	
(BHN (Max / Min)	NA	NA	NA	NA	NA	
(If Required in TDC /Customer)						

VISUAL :	(i) Surface Condition	100 % Bars Checked	OK NO (Rust, Cracks, etc)
	(ii) Heat No.	100 % Bars Checked	OK (K19 8780)
	(iii) Color Code.	100 % Bars Checked	OK Half (Red + Yellow)

REDUCTION RATIO :	Specify	BLOOM SIZE -	240 x 780	REDUCTION RATIO :	1:20,25
(If Required in TDC /Customer)	As Per Mill TC				

DECARB LEVEL :	(AS PER IS 6396 / ASTM E1077)	Specified	NA
(If Required in TDC /Customer)		Observed	PD

UPSETIBILITY TEST (AS PER IS 10167) :

Test Certificate verified for Each Heat no :	Available & Ok	Not Available	Not Conforming
	OK		

TDC / Customer STD	SSB/TDC/	Mill Tc No.	Mill Tc Date	Verified By :
(If Required in TDC /Customer)				

MIX-UP TEST	Verified By Mobile Spectro /X-Ray Gun/Spark Test
(If Required in TDC /Customer)	
Accepted	✓
Rejected	

Other Remarks

Checked By

Approved By

