



RAW MATERIAL INCOMING INSPECTION REPORTS

D.C. No. :- F/05/01
Issue no. :- 01, 01.07.2018
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1784	SECTION :-	80mm	HAET NO. :-	K20225	INVOICE NO. :-	9043036946
51425	STEEL SUPPLIER :-	Kalyani Steel	REC.QTY :-	28940kg	INVOICE DATE :-	21/1/25
100000	STEEL TC NO. :-	K20225	NO. OF BARS :-	135		
Process / Mfg Route						
E0F - (KF - ND - CCM SEMS - LAMLC) - R MILL						
%C	%Mn	%Si	%S	%P	%Cr	%Ni
0.350	0.600	0.150	0.002	0.000	0.900	0.150
0.450	0.900	0.400	0.040	0.035	1.200	0.300
0.424	0.871	0.136	0.027	0.003	1.310	0.020
0.440	0.890	0.187	0.022	0.015	1.193	0.023
%Mo	%Al	%Cu	%As	%Sb	%V	%Pb
0.020	0.020	0.050	0.000	0.000	0.000	0.000
0.250	0.050	0.300	0.000	0.000	0.000	0.000
0.157	0.027	0.012	0.000	0.000	0.000	0.000
0.026	0.012	0.000	0.000	0.000	0.000	0.000
%Ca	%Nb	%Ti	%B			
10ppm	0.002	0.005	0.000			
5ppm	0.002	0.005	0.000			
1ppm	0.002	0.005	0.000			
3ppm	0.002	0.005	0.000			

Bar Size	(As per WI...)	Qty : 10 % Of Total Heat										
S.NO.	1	2	3	4	5	6	7	8	9	10	11	12
	80.3	80.0	80.3	80.4	80.1	80.2	80.5	80.2	80.0	80.2	80.2	80.1

Gas Content (PPM): As per Mill Tc	N2	H2	O2
Min	60		
Max	120	2	15
Value			
Mill Tc	82	1.61	10

Steel Supply Condition:	Hot Rolled
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MACRO	(i)	Internal soundness Sample : (ASTM E381 or as per customer)	S3	R3	C2	MAX
		Value Obs.	S3	R3	C2	
	(ii)	Dendrite structure 01 sample :				
	(iii)	Step Down Test Sample : (IS4075 or as per customer)				OK

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

ULTRASONIC TEST (AS PER ASTM A388) :	Mill Tc	100% Done 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				
Cust Spec. If Any	2.0	1.5	2.0	1.0	0.5	0.5	1.0	1.0		
Mill Tc	1.5	0.5	0.0	0.0	0.0	0.0	1.0	0.5		
SSB										

GRAIN SIZE : (ASTME112 / IS-4748)	Spec:-	5-8	Mill Tc	7	SSB	7
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JOMINY HARDENBILITY IS-3848 /ASTMA255 (As per required by Customer)	Distance	1.5	3	5	7	9	11	13	15	20	25	30
	Specified	55.5-61	55.5-61	55.5-61	54-60	52.5-60	51.5-59	49.5-59	48.5-58	47.5-56	46.5-55	45.5-54
	Mill Tc	58.5	59	58	57	56	54.5	54.5	53.5	51.5	49	47
	Observed	60	59	58	57	56	54	53	52	49	48	47

MECHANICAL PROPERTIES : (If Required in TDC /Customer)	As per IS:1608/ ASTM A 370	As per IS: 1757			
	U.T.S N/mm2 /MPA	YS N/mm2 /MPA	%EL	IMPACT VALUE CHERRY	IMPACT VALUE IZOD
Specified	1030-1290	835 Min	10min	25J min	
Observed	1217-792	882.00	23.37%	34 J	

As Rolled Hardness (BHN (Max / Min) (If Required in TDC /Customer)	1	2	3	4	5
	264	265	266	268	270

VISUAL :	(i)	Surface Condition	100 % Bars Checked	OK
	(ii)	Heat No.	100 % Bars Checked	OK
	(iii)	Color Code.	100 % Bars Checked	OK

REDUCTION RATIO :	Specify	7:1 Min	BLOOM SIZE -	200x200	REDUCTION RATIO :	1:7.96
(If Required in TDC /Customer)	As Per Mill TC					

DECARB LEVEL : (AS PER IS 6396 / ASTM E1077)	Specified	0.60mm Max		
(If Required in TDC /Customer)	Observed	PD	0.22	FD

UPSETIBILITY TEST (AS PER IS 10167) :	OK
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Test Certificate verified for Each Heat no :	Available & Ok	Not Available	Not Conforming
	✓		

TDC / Customer STD (If Required in TDC /Customer)	SSB/TDC/	Mill Tc No	Mill Tc Date	Verified By :
	01001 R3	K202255	29/3/25	

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

Other Remarks	
Checked By	Approved By