RAW MATERIAL INCOMING INSPECTION REPORTS

D.C. No. :- F/05/01
Issue no. :- 01, 01.07.2018
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	17883	SECTION :-	70mm	HAET NO :-	K202254	INVOICE NO.-	9043036945
	5/4/25	STEEL SUPPLIER :-	Kalyani Steel	REC.QTY :-	12970kg	INVOICE DATE.-	2/4/25
	10/5/24	STEEL TC NO :-	K202254	NO. OF BARS :-	70		

Process /Mfg Route: EAF – LRF – VD – CCM CFMS 1AML – RMILL

	%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Mo	%Al	%Cu	%As	%Sb	%V	%Pb	%Ca	%Nb	%Ti	%B
	0.350	0.800	0.150	0.020		0.900		0.150	0.040		–	–	–	–		–	–	
	0.450	0.900	0.400	0.040	0.035	1.200	0.300	0.250	0.050	0.300	–	–	–	–	10ppm	–	–	5PPM
	0.429	0.845	0.184	0.020	0.017	1.149	0.021	0.161	0.021	0.013	–	–	–	–	7ppm	–	–	1PPM
C Value	0.448	0.892	0.188	0.018	0.015	1.200	0.026	0.170	0.024	0.012	–	–	0.003	–	–	0.002	0.005	0.0004
Ceq Value																		

Bar Size (As per WI...) Qty :10 % Of Total Heat

Bar Checked .....

S.NO.	1	2	3	4	5	6	7	8	9	10	11	12	
Diameter/Section Size(In mm)	70.3	70.5	70.1	70.4	70.5	70.3	70.5	70.3	70.1	70.4	70.2	70.5	

Gas Content (PPM): As per Mill Tc

	N2	H2	O2
Min	60		
Max	120	2.00	15
Value Mill Tc	90	1.490	11

Steel Supply Condition: Hot Rolled

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 strcuture : (or as per customer)
Mill Tc —
SSB P+F+B

ULTRASONIC TEST (AS PER ASTM A388) : Mill Tc 100 % UT OK

INCLUSION RATING (IS 14163 /ASTM: E45A OR REQUITRED BY CUSTOMER)

	A Sulphide TN	A Sulphide TK	B Aluminate TN	B Aluminate TK	C Silicate TN	C Silicate TK	D Oxide TN	D Oxide TK	DS TN	DS 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	0.5	0.0	0.0	0.0	1.0	0.5		
SSB										

GRAIN SIZE : (ASTME112 / IS-4748) Spec.:- 5-8 Mill Tc 7.0 SSB 7

JOMINY HARDENBILTY IS-3848 /ASTMA255 (As per required by Customer)

	Distance	1.5	3	5	7	9	11	13	15	20	25	30	
	Spcificified	55.5-61	55.5-61	55-61	54-60	53.5-60	51.5-59	49.5-58	48-58	44-56	41-53	38.5-51	
	Mill Tc	59	58	57	56	55	54	53.5	52.5	49.5	46		
	Observed	59	58	57	56	55	54	53	51	47	43	42	

MECHANICAL PROPERTIES : (If Required in TDC /Customer)

	As per IS:1608/ ASTM A 370 U.T.S N/mm2 /MPA	Y.S N/mm2 /MPA	%EL	As per IS: 1757 IMPACT VALUE CHARRY	IMPACT VALUE IZOD
Specified	1030 – 1230	835 Min	10 Min	25J min	
Observed	1069.104	878.00	28.20%	34 J	

As Rolled Hardness (BHN (Max / Min) (If Required in TDC /Customer)

1	2	3	4	5

VISUAL :

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

REDUCTION RATIO : Specifiy 7:1 Min BLOOM SIZE - 200X200 REDUCTION RATIO : 1 : 10.39
(If Required in TDC /Customer) As Per Mill TC

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

UPSETIBILITY TEST (AS PER IS 10167) : OK

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

TDC / Customer STD (If Required in TDC /Customer) SSB/TDC/ QF1001 RB Mill Tc No. K202254 Mill Tc Date 1.04.25 Verified By :

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