



RAW MATERIAL INCOMING INSPECTION REPORTS

Q.C. No. : 5/05/05
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Report NO.	F38	SECTION :-	75	HAET NO :-	K197196	INVOICE NO -	2100005731									
DATE :-	2/12/2024	STEEL SUPPLIER :-	Kaigah	REC.QTY :-	5680K9	INVOICE DATE -	2/5/11/2024									
GRADE :-	2F75	STEEL TC NO :-	K197196	NO. OF BARS :-												
(01)	Process / Mill Route															
Chemistry	%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Mo	%Al	%Cu	%As	%Nb	%V	%Ti	%B	%N
Min	0.14	1.2	—	0.01	—	1.1	—	—	0.02	—	—	—	—	—	—	—
Max	0.19	1.5	0.3	0.025	0.025	1.4	0.3	0.08	0.05	0.3	—	0.05	—	—	—	—
Mill Tc Value	0.162	1.223	0.236	0.017	0.01	1.24	0.165	0.056	0.076	0.1	0.0006	0.003	0.0035	0.001	—	—
Spectro Value	0.172	1.273	0.226	0.02	0.011	1.28	0.192	0.056	0.078	0.1	—	—	0.001	—	—	—

(02)	Bar Size	(As per WI...)	Qty : 10 % Of Total Heat										
No of Bar Checked	10												
	Diameter / Section Size (in mm)												
	S.NO.	1	2	3	4	5	6	7	8	9	10	11	12
	75	74.9	74.8	74.6	74.5	74.4	74.5	74.8	74.7	74.6	74.2		

(03)	Gas Content (PPM): As per Mill Tc															
		N2	H2	O2												
	Min	90	—	—												
	Max	—	—	25												
	Value	99	—	17												
	Mill Tc															

(04)	Steel Supply Condition:	As Rolled
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(05)	MACRO	(i)	Internal soundness Sample : (ASTM E381 or as per customer)	S2	R2	C2
		(ii)	Dendrite structure 01 sample :	LS2	LP2	LC2
		(iii)	Step Down Test Sample : (IS4075 or as per customer)	OK		

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

(07)	ULTRASONIC TEST (AS PER ASTM A388) :	Mill Tc	100% OK
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(08)	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	TN	TK	TN	TK	TN	TK			
	Cust Spec. If Any	—	—	2.0	1.0	0.5	0.5	1.0	1.0							
	Mill Tc	—	—	0.5	0.0	0.0	0.0	1.0	0.5							
	SSB	—	—	0.5	0.0	0.0	0.0	1.0	0.5							

(09)	GRAIN SIZE :	Spec. : S-2	Mill Tc	7.0	SSB	6.5
	(ASTM E112 / IS-4748)					

(10)	JOMINY HARDENBILITY	Distance	55	70	75	750										
	IS-3848 / ASTM A255	Specified	79-44	75-40	74-32	74-24										
	(As per required by Customer)	Mill Tc	41.9	36.3	28.7	25.9										
		Observed	40	35	26	24										

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

(12)	VISUAL :								
	(i)	Surface Condition	100 % Bars Checked	OK	No (Crack, Rust, Gas) (Hitting)				
	(ii)	Heat No.	100 % Bars Checked	OK	(K197196)				
	(iii)	Color Code.	100 % Bars Checked	OK	Half Red + yellow				

(13)	REDUCTION RATIO :	Specify	BLOOM SIZE - 240 X 280	REDUCTION RATIO : 1:1.5:21
	(If Required in TDC / Customer)	As Per Mill TC		

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

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

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

(18)	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



Scanned with OKEN Scanner