



RAW MATERIAL INCOMING INSPECTION REPORTS

D.C. No. :- F/05/01
Issue no. :- 01, 01.07.2018
Rev. no. :- 02, 11.05.23

1789	SECTION :-	6mm	HAET NO. :-	54936	INVOICE NO. :-	17541											
310725	STEEL SUPPLIER :-	SIR	REC.QTY :-	5.590	INVOICE DATE :-	25/3/25											
6mm Gr	STEEL TC NO. :-	25021232	NO. OF BARS :-	42													
Process / Mfg Route	MPS - EOP - CRF - VD - CCM - EMS - AMIC - RMR																
%C	%Mn	%Si	%P	%S	%Cr	%Ni	%Mo	%Al	%Cu	%As	%Sb	%V	%Pb	%Ca	%Nb	%Ti	%B
0.130	1.00	0.150	0.015	0.003	0.803	0.300	0.100	0.020	0.300	-	-	-	-	0.010	-	-	0.005
0.150	1.200	0.100	0.030	0.000	1.100	0.300	0.100	0.020	0.300	-	-	-	-	0.010	-	-	0.005
0.160	1.26	0.225	0.024	0.013	1.055	0.019	0.008	0.028	0.015	0.020	0.001	0.006	0.010	0.006	0.002	0.004	0.004
0.178	1.290	0.232	0.024	0.015	1.056	0.024	0.004	0.025	0.011	-	-	0.006	-	0.003	0.004	0.004	0.004

Diameter/Section Size(in mm)												
S.NO.	1	2	3	4	5	6	7	8	9	10	11	12
	60.3	60.0	60.1	60.4	60.6	60.2	60.5	60.1	60.3	60.2	60.5	60.2

Gas Content (PPM): As per Mill Tc			
	N2	H2	O2
Min	60		
Max	180	2.5	20
Value			
Mill Tc	68.2	1.13	15.4

Steel Supply Condition: HOT ROLLED

MACRO (i) Internal soundness Sample : (ASTM E381 or as per customer) S3 R3 C2 MAX
Value Obs. S2 R2 C2

(ii) Dendrite structure 01 sample : OK

(iii) Step Down Test Sample : (IS4075 or as per customer) OK

Micro structure As Rolled : Uniform Ferrite + Pearlite
Micro structure : (or as per customer)
Mill Tc Ferrite + Pearlite
SSB Ferrite + Pearlite

ULTRASONIC TEST (AS PER ASTM A388) : 100% Done OK

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
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	0.5	0.0		
SSB	1.5	0.5	0.5	0.0	0.0	0.0	0.5	0.0		

GRAIN SIZE : (ASTME112 / IS-4748) Spec:- 5-8 Mill Tc 7.5 SSB 6

JOMINY HARDENBILITY IS-3848 / ASTM A255 (As per required by Customer)

Distance	1.5	5	10	15	20	25	30						
Specified	29.44	34.54	40.50	45.55	50.55	55.55	60.55						
Mill Tc	40.6	33	31	25.4	22.5	21	20.4						
Observed	47	37	32	26	24	23	21						

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
	N/mm2 / MPA	/MPA			CHARRY
Specified	1030-1370	735 min	8 min	28%	40 J
Observed	1085-990	1060, 165	28%		

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

1	2	3	4	5
161	162	164	165	165

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 7.21 min BLOOM SIZE 200x200 REDUCTION RATIO : 14:15:1
(If Required in TDC / Customer) As Per Mill Tc

DECARB LEVEL : (AS PER IS 6396 / ASTM E1077)

Specified	<u>0.60 mm max</u>
Observed	PD

UPSETIBILITY TEST (AS PER IS 10167) : OK

Test Certificate verified for Each Heat no :

Available & Ok	Not Available	Not Conforming
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

TDC / Customer STD SSB/TDC/ Mill Tc No. 25021232 Mill Tc Date 25/3/25 Verified By : [Signature]

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

Accepted	<input checked="" type="checkbox"/>	Rejected	<input type="checkbox"/>
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Other Remarks [Signature]

Checked By [Signature] Approved By [Signature]