



RAW MATERIAL INCOMING INSPECTION REPORTS

D.C. Form - 1/00/001
Revision No. - 01, 01.07.2008
Rev. No. - 01, 22.09.08

REPORT NO.	1733	SECTION	70-7	HAET NO.	A3303P	INVOICE NO.	
DATE	11/11/14	STEEL SUPPLIER	AKS	REC. CITY	22130	INVOICE DATE	11/11/14
GRADE	C-40	STEEL TC NO.	2014-25/0022564	NO. OF BARS			
Process/Hot Route							
Chemistry	NC	KMn	KSi	KS	KP	KCr	KNi
Min	0.77	0.5	0.15	0.02	-	0.2	-
Max	0.44	0.8	0.4	0.07	0.05	0.3	0.12
Mill Tc Value	0.43	0.755	0.215	0.017	0.018	0.245	0.05
Spectro Value	0.44	0.772	0.209	0.03	0.018	0.246	0.107

No of Bar Checked	10	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
			70	69.9	69.8	69.7	69.6	69.5	69.4	69.3	69.2	69.1	69.0	68.9

Gas Content (PPM): As per Mill Tc	H2			H2			O2		
	Min			Max			Value		
	76			0.83			11.0		
	Mill Tc								

Steel Supply Condition:	AS Hot Rolled
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MACRO	(i)	Internal soundness Sample : (ASTM E381 or as per customer)	Value Obs.	53	R3	C2
	(ii)	Dendrite structure 01 sample :		251	201	202
	(iii)	Step Down Test Sample : (IS4075 or as per customer)		OK		

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				
	TH	TK	TN	TK	TN	TK	TN	TK	TN	TK	
	Cust Spec. If Any	2.5	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	0.0		

GRAIN SIZE :	Spec.:	5-8	Mill Tc	6-6.5	SSB	6.0
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JOMINY HARDENILITY IS-3848 /ASTMA255 (As per required by Customer)	Distance	75	70	70	70						
	Specified	22-40	26-31	24-28	21-26						
	Mill Tc	29.5	30.5	26	25.5						
	Observed	39	30	27	24						

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		IMPACT VALUE	
	N/mm2 /MPA		N/mm2 /MPA		KEL		CHERRY	
	Specified		720-840		490 Min.		15	
	Observed		774		657		16.2	

As Rolled Hardness (BHN (Max / Min) (If Required in TDC /Customer)	1	2	3	4	5
	179	181	183	185	187

VISUAL :	(i)	Surface Condition	100 % Bars Checked	OK	20 (Rust, Cracks, Gas (HAB))
	(ii)	Heat No.	100 % Bars Checked	OK	(A3303P)
	(iii)	Color Code.	100 % Bars Checked	OK	(White + Red Dot)

REDUCTION RATIO :	Specify	7.1 mm	BLOOM SIZE	250 X 250	REDUCTION RATIO :	16.25%
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DECARB LEVEL : (AS PER IS 6396 / ASTM E1077)	Specified	0.42
(If Required in TDC /Customer)	Observed	PD

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

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