



Since 1992

KISCO
NERVES OF STEEL

Doc.no.:F-QCD-16		<h1>TEST CERTIFICATE</h1> <p>AS PER EN-10204-8.1</p>														
Issue no.:1.0																
Date: 01.08.2013																
Approved By:M.R.																
CUSTOMER:-		S.S.B. ENGINEERS (P) LTD				GRADE :-		S690QL		T.C. NO.:-		RND/25				
										DATE:-		07.04.2025				
P.O. No. & Dt.		2024-25N 81 Dt. 11.03.2025				Inv. No.		SA254-00032		Inv. Dt.		10/04/2025				
Product		ROLLED BAR				Mfg. Route		EF + LRF + VD, Fully Killed Bottom Poured Ingot								
Feasibility No.		KCIL/22-23/1005, Rev. No.3 Dt. 28.08.2023				Supply Conditions		Rolled + Peeled								
ITEM DESCRIPTION																
Heat No.		Size		No. Of Pcs.		Qty In MT.		Remarks								
K24-2138		106 MM DIA		20		9-310										
CHEMICAL ANALYSIS %																
% ELEMENT		C	Mn	Si	S	P	Cr	Mo	Ni	Nb	Ti	Cu	B	V	Zr	N
SPEC.	MIN.
	MAX	0.20	1.70	0.80	0.010	0.025	1.50	0.70	2.00	0.06	0.05	0.50	0.005	0.12	0.15	0.015
Achieved		Chemical Composition confirming to the specification.														
MECHANICAL PROPERTIES (On H&T Sample Only)																
Test piece location 12.5 mm from surface		Tensile Strength (Mpa)		Yield Strength (Mpa)		% Elongation		R.A		Hardness (BHN)		Impact (CVN) Longitudinal @ -40 °C				
SPEC.	MIN.	710		630		14		-		-		30J Min.				
	MAX	900		-		-		-		-		114 116 120 Avg. 116.6J				
Achieved		842.3		746.3		22.8		-		-						
Jominy Hardenability										RAW MATERIAL DETAIL						
Distance in mm		-	-	-	-	-	-	-	-	INGOT SIZE		-				
Spec.	Min.	-	-	-	-	-	-	-	-	REDUCTION RATIO		-				
	MAX	-	-	-	-	-	-	-	-							
Achieved		-	-	-	-	-	-	-	-							
NON DESTRUCTIVE TESTING																
Ultrasonic Testing				Dye Penetrant Testing				Magnetic Particle Inspection				Mixup Test				
Ref. Std.		ASTM A388, Probe: ø24mm, 2MHz				Ref. Std.			Ref. Std.					
Acceptance		4mm FBH on DGS Scale				Acceptance		...		Acceptance					
Result		Found Satisfactory				Result			Result					
Spark test										Mobile Spectro		100% Done & found Satisfactory				
METALLURGICAL TESTING																
INCLUSION RATING (ASTM E45)				GRAIN SIZE (ASTM E112)		MICRO STRUCTURE				MACRO (ASTM E381)		STEP DOWN TEST				
A B C D				6.5-7.0					Better than C2 R2 S2		Decarburization Depth				
THIN 0.5 - - 1.0																
THICK - - - 1.0																
IDENTIFICATION DETAIL		Heat No., Grade, & Size marked on bars/bundles						Colour Code		ORANGE-GREY-PINK						
Result:		The supplied material is free from internal, surface defects & radioactive contamination														
We hereby certify that products has been manufactured,inspected and found acceptable as per customer requirements.																
Prepared By		Reviewed By						KISCO CASTINGS (INDIA) LIMITED		14/4/25		KISCO CASTINGS (INDIA) LIMITED				

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