



## RAW MATERIAL INCOMING INSPECTION REPORTS

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

Report NO.	737	SECTION :-	75	HAET NO :-	K19 667	INVOICE NO.-	670000 5731
DATE :-	7/12/2024	STEEL SUPPLIER :-	Kalyani	REC.QTY :-	8580 kg	INVOICE DATE:-	29/11/2023
GRADE :-	2 F-76	STEEL TC NO :-	K19 6671	NO. OF BARS :-			

Process / Mill Route																		
Chemistry	%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Mo	%Al	%Cu	%As	%Sb	%V	%Pb	%Ca	%Nb	%Ti	%B
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	0.30	—	0.005	—	—	30	—	0.005	10
Mill Tc Value	0.16	1.22	0.25	0.015	0.015	1.13	0.19	0.06	0.03	0.105	0.0007	0.003	0.0038	0.001	110	—	0.002	13
Spectro Value	0.18	1.25	0.22	0.022	0.011	1.2	0.194	0.057	0.028	0.102	—	—	0.002	—	—	0.003	0.003	0.007

Bar Size (As per WL)		Qty : 10 % Of Total Heat																
No of Bar Checked	10	Diameter/Section Size (In mm)																
		1	2	3	4	5	6	7	8	9	10	11	12					
		75	74.5	74.5	74.8	74.6	74.5	74.4	74.5	74.6	74.7							

Gas Content (PPM): As per Mill Tc			
	N2	H2	O2
Min	90	—	—
Max	—	—	25
Value	129	—	18
Mill Tc			

Steel Supply Condition:		AS Rolled	
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MACRO		(i) Internal soundness Sample : (ASTM E381 or as per customer)		S2 R2 C2	
		Value Obs.		C S2 C R2 C C2	
		(ii) Dendrite structure 01 sample :			
		(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	
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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	1.0	0.5	0.5	1.0	1.0		
Mill Tc		—	—	0.5	0.0	0.0	0.0	1.0	2.5		
SSB		—	—	0.5	0.0	0.0	0.0	1.0	0.5		

GRAIN SIZE :		Spec:- 5-8		Mill Tc		7.0		SSB		6.5	
(ASTME112 / IS-4748)											

JOMINY HARDENILITY (IS-3848 /ASTMA255 (As per required by Customer )		Distance		55	510	525	550				
		Specified		29-44	35-40	27-32	24-28				
		Mill Tc		42	38	30	27.4				
		Observed		41	37	29	25				

MECHANICAL PROPERTIES : (If Required in TDC /Customer )		As per IS:1608/ ASTM A 370				As per IS: 1757					
		U.T.S		YS		N/mm2		%EL		IMPACT VALUE	
		N/mm2 /MPA		/MPA						CHARRY	
		Specified		—		—		—		—	
		Observed		—		—		—		—	
As Rolled Hardness (BHN (Max / Min) (If Required in TDC /Customer )		1 2 3 4 5									
		— — — — —									

VISUAL :		(i) Surface Condition		100 % Bars Checked		OK No ( Rust, cracks, etc ) (4 Hrs)	
		(ii) Heat No.		100 % Bars Checked		OK (K19 6671)	
		(iii) Color Code.		100 % Bars Checked		OK BHF ( Red + yellow )	

REDUCTION RATIO :		Specify		BLOOM SIZE - 240 x 280		REDUCTION RATIO : 1.1521	
(If Required in TDC /Customer )		As Per Mill Tc					

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

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							

