



Since 1992

KISCO
NERVES OF STEEL

Doc.no.: F-QCD-16		TEST CERTIFICATE														
Issue no.: 1.0		AS PER EN-10204-3.1														
Date: 01.08.2013																
Approved By: M.R.																
CUSTOMER:-		S.S.B. ENGINEERS (P) LTD			GRADE:-		S690QL		T.C. NO.:-		RND/1166					
									DATE:-		03.01.2025					
P.O. No. & Dt.		2024-25N 55 Dt. 15.11.2024			Inv. No.		SADLY-01291		Inv. Dt.		07/01/2025					
Product		ROLLED BAR			Mfg. Route		EF + LRF + VD, Fully Killed Bottom Poured Ingot									
Feasibility No.		KCL/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								
K24-1447		106 MM DIA		25		9.280										
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		-		-		-		-						
Achieved		842.65		757.13		22.52		-		-		190	188	186	Avg. 188J	
Jominy Hardenability																
Distance in mm		-	-	-	-	-	-	-	-	-	-	RAW MATERIAL DETAIL				
Spec.	Min.	-	-	-	-	-	-	-	-	-	-	INGOT SIZE		-		
	MAX	-	-	-	-	-	-	-	-	-	-	REDUCTION RATIO		-		
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.			Spark test				
Acceptance	4mm FBH on DGS Scale			Acceptance	...			Acceptance			Mobile Spectro				
Result	Found Satisfactory			Result			Result			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																
THICK																
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														

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