

## RAW MATERIAL INCOMING INSPECTION REPORTS

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

1783 20/12/25 SAE8680H	SECTION :- STEEL SUPPLIER :- STEEL TC NO :-	80mm Amh steel 5924	HAET NO :- REC.QTY :- NO. OF BARS :-	8335 29210kg 134	INVOICE NO.- INVOICE DATE:-	5806 20/12/25																																																																																										
Process / Mfg Route EAF + LF + VD + CCM + EMS																																																																																																
<table border="1"> <tr> <th>%C</th> <th>%Mn</th> <th>%Si</th> <th>%S</th> <th>%P</th> <th>%Cr</th> <th>%Ni</th> <th>%Mo</th> <th>%Al</th> <th>%Cu</th> <th>%As</th> <th>%Sb</th> <th>%V</th> <th>%Pb</th> <th>%Ca</th> <th>%Nb</th> <th>%Ti</th> <th>%B</th> </tr> <tr> <td>0.180</td> <td>0.700</td> <td>0.150</td> <td>0.030</td> <td></td> <td>0.400</td> <td>0.400</td> <td>0.150</td> <td>0.020</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.230</td> <td>0.900</td> <td>0.350</td> <td>0.035</td> <td>0.035</td> <td>0.600</td> <td>0.700</td> <td>0.250</td> <td>0.050</td> <td>0.300</td> <td></td> <td></td> <td></td> <td></td> <td>0.001</td> <td></td> <td></td> <td>0.0005</td> </tr> <tr> <td>0.217</td> <td>0.850</td> <td>0.210</td> <td>0.033</td> <td>0.019</td> <td>0.555</td> <td>0.448</td> <td>0.166</td> <td>0.022</td> <td>0.198</td> <td></td> <td></td> <td>0.010</td> <td></td> <td>0.0006</td> <td></td> <td>0.0023</td> <td>0.0004</td> </tr> <tr> <td>0.216</td> <td>0.864</td> <td>0.223</td> <td>0.023</td> <td>0.018</td> <td>0.553</td> <td>0.440</td> <td>0.165</td> <td>0.025</td> <td>0.190</td> <td></td> <td></td> <td>0.015</td> <td></td> <td></td> <td>0.002</td> <td>0.004</td> <td>0.0004</td> </tr> </table>							%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Mo	%Al	%Cu	%As	%Sb	%V	%Pb	%Ca	%Nb	%Ti	%B	0.180	0.700	0.150	0.030		0.400	0.400	0.150	0.020										0.230	0.900	0.350	0.035	0.035	0.600	0.700	0.250	0.050	0.300					0.001			0.0005	0.217	0.850	0.210	0.033	0.019	0.555	0.448	0.166	0.022	0.198			0.010		0.0006		0.0023	0.0004	0.216	0.864	0.223	0.023	0.018	0.553	0.440	0.165	0.025	0.190			0.015			0.002	0.004	0.0004
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Bar Size (As per WI...) Qty : 10 % Of Total Heat																																																																																																
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	80.2	80.5	80.1	80.3	80.0	80.2	80.4	80.1	80.5	80.2	80.4	80.2																																																																																				
Gas Content (PPM): As per Mill Tc																																																																																																
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Steel Supply Condition: Hot Rolled																																																																																																
MACRO (i) Internal soundness Sample : (ASTM E381 or as per customer) S2 R2 C2 mfx																																																																																																
(ii) Dendrite structure 01 sample: Value Obs. S2 R2 C2																																																																																																
(iii) Step Down Test Sample : (IS4075 or as per customer) OK																																																																																																
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SSB																																																																																																
ULTRASONIC TEST (AS PER ASTM A388) : Mill Tc 100% Done OK																																																																																																
INCLUSION RATING ( IS 14163 /ASTM: E45A OR REQUIRED BY CUSTOMER )																																																																																																
<table border="1"> <tr> <th rowspan="2"></th> <th colspan="2">A</th> <th colspan="2">B</th> <th colspan="2">C</th> <th colspan="2">D</th> <th colspan="2">DS</th> </tr> <tr> <th>TN</th> <th>TK</th> <th>TN</th> <th>TK</th> <th>TN</th> <th>TK</th> <th>TN</th> <th>TK</th> <th>TN</th> <th>TK</th> </tr> <tr> <td>Cust Spec. If Any</td> <td>2.0</td> <td>1.5</td> <td>2.0</td> <td>1.0</td> <td>0.5</td> <td>0.5</td> <td>1.0</td> <td>1.0</td> <td></td> <td></td> </tr> <tr> <td>Mill Tc</td> <td>1.5</td> <td>0.5</td> <td>0.5</td> <td>0.0</td> <td>0.0</td> <td>0.0</td> <td>1.0</td> <td>0.0</td> <td></td> <td></td> </tr> <tr> <td>SSB</td> <td>1.5</td> <td>0.5</td> <td>0.5</td> <td>0.0</td> <td>0.0</td> <td>0.0</td> <td>1.0</td> <td>0.0</td> <td></td> <td></td> </tr> </table>								A		B		C		D		DS		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	1.0	0.0			SSB	1.5	0.5	0.5	0.0	0.0	0.0	1.0	0.0																																						
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GRAIN SIZE : Spec:- 6-8 Mill Tc 7 SSB 6																																																																																																
(ASTME112 / IS-4748)																																																																																																
JOMINY HARDENBILITY IS-3848 /ASTMA255 (As per required by Customer)																																																																																																
<table border="1"> <tr> <td>Distance</td> <td>4/16</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Specified</td> <td>24-39</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Mill Tc</td> <td>38</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Observed</td> <td>37</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>							Distance	4/16												Specified	24-39												Mill Tc	38												Observed	37																																																	
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MECHANICAL PROPERTIES : (If Required in TDC /Customer )																																																																																																
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	187	184	190	193	193																																																																																											
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 7.1 min BLOOM SIZE : 200x200 REDUCTION RATIO : 8.0:1																																																																																																
(If Required in TDC /Customer ) As Per Mill TC																																																																																																
DECARB LEVEL : (AS PER IS 6396 / ASTM E1077)																																																																																																
<table border="1"> <tr> <td>Specified</td> <td>0.6 mm</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Observed</td> <td>PD</td> <td>0.12</td> <td>FD</td> <td></td> <td></td> </tr> </table>							Specified	0.6 mm					Observed	PD	0.12	FD																																																																																
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UPSETIBILITY TEST ( AS PER IS 10167 ) : OK																																																																																																
Test Certificate verified for Each Heat no :																																																																																																
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TDC / Customer STD SSB/TDC/ Mill Tc No. 5924 Mill Tc Date 20/12/25 Verified By: [Signature]																																																																																																
(If Required in TDC /Customer ) FAL-MTS-02-04, Rev.06																																																																																																
MIX-UP TEST (If Required in TDC /Customer )																																																																																																
Verified By Mobile Spectro /X-Ray Gun/Spark Test																																																																																																
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