

ARORA IRON & STEEL ROLLING MILLS (P) LTD.

DHANDARI KHURD, NEAR PHASE-VII, FOCAL POINT, LUDHIANA- 141 010.

Website : www.arorairon.com

UNIT-I

TEST CERTIFICATE

TEST CERTIFICATE ACCORDING TO EN10204 TYPE 3.1



THE STEEL MASTERS

ISO 9001:2015



| | | |
|----------------------|---------------|---|
| Customer Address: | | M/S S.S.B. ENGINEERS PVT.LTD. 133, MATSYA INDUSTRIAL AREA ALWAR - RAJASTHAN (INDIA) PIN CODE NO.301030 |
| Material | Process Route | EAF-LRF-VD-CCM-AMLC-EMS-RM |
| Specification | Heat No. | A33266 |
| Grade | Supply Size | 80 MMØ |
| Supply Condition | Colour Code | AS HOT ROLLED YELLOW |
| Test Certificate No. | | 2024-25/0024631 |
| Date | | 05-01-2025 |
| Weight (MT.) | | 33.160 |
| Input/Billet Size | | 250X250 MM |
| Reduction Ratio | | 12.44:1 (Spec-7:1 min) |
| No's of Pcs | | 150 |
| No's of Bundle | | 15 |
| Length | | NA |

CHEMICAL ANALYSIS (ASTM E 415 / IS 8811)

| Element | C% | Mn% | Si% | S% | P% | Cr% | Ni% | Mo% | V% | Al% | Cu% | Ca% | AI/N2 Ratio |
|----------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|--------|-------------|
| Spec. | Min | 0.380 | 0.600 | 0.150 | 0.020 | - | 0.900 | 0.150 | 0.020 | - | - | - | 2.10 |
| Max | 0.450 | 0.900 | 0.400 | 0.040 | 0.035 | 1.200 | 0.300 | 0.250 | 0.010 | 0.050 | 0.300 | 0.0010 | 0.0005 |
| Achieved | 0.415 | 0.830 | 0.280 | 0.025 | 0.014 | 1.055 | 0.110 | 0.185 | 0.005 | 0.025 | 0.100 | 0.0008 | 0.0004 |

JOMINY HARDENABILITY TEST (IS:3848, ASTM A255, SAE J406)

| Distance (MM) | 1.5 | 3 | 5 | 7 | 9 | 11.0 | 13 | 15 | 20 | 25 | 30 |
|----------------|------|------|------|------|------|------|------|------|------|------|------|
| Spec. | Min | 55.5 | 55.5 | 55 | 54 | 53.5 | 49.5 | 48 | 44 | 41 | 39.5 |
| Max | 61 | 61 | 60 | 60 | 60 | 59 | 58 | 56 | 53 | 51 | 46.0 |
| Achieved (HRC) | 59.5 | 58.5 | 57.5 | 57.0 | 56.5 | 55.5 | 54.0 | 53.0 | 50.5 | 47.5 | 46.0 |

Mechanical Properties

| Spec. | | Parameters | | IS:1608 / ASTM A370 | | IS:157 | | ASTM A255 | | Surface Hardness | |
|-------|------|---------------------------------------|-------------------------------------|-----------------------|--------------------|-------------------------|--------|------------|-------|------------------|----------|
| | | | | Test Condition: H & T | | Impact Strength | | D.I. Value | | As Rolled | |
| Min | Max | Tensile Strength (N/mm ²) | Yield Strength (N/mm ²) | Elongation (%) | Reduction Area (%) | Charpy U-notch (Joules) | (Inch) | (mm) | (BHN) | | |
| 1030 | 1230 | 1091 | 929 | 13.2 | - | 25 J min | - | - | - | 269/285 | Achieved |
| | | | | | | | | | | | |

Metallurgical Results

| Parameters | | Inclusion Rating (IS : 4163 / ASTM : E454 / JK Chart) | | | | | | | | | | Worst Field Rating | | DS | (No.) | Grain Size ASTM E112 IS 4748 / Decarburization IS 6396/ASTM E1077 | | Complete | Partial | 0.6% of the nominal diameter with maximum of 0.6 mm | Not Allowed | NIL | Achieved | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|-----------------|-------|--|---|------|------|------|------|------|------|------|------|--------------------|------|------|-------|---|------|----------|---------|---|----------------|------|----------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|-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| | | Type | Series | Min | Max | 1.5 | 0.5 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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