



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	1760	SECTION :-	8mm	HAET NO :-	6638	INVOICE NO.-	5400																																						
DATE :-	20/12/25	STEEL SUPPLIER :-	ANNA STEEL	REC.QTY :-	10.930MT	INVOICE DATE :-	22/12/25																																						
GRADE :-	20MnCr (B)	STEEL TC NO :-	5488	NO. OF BARS :-	53																																								
Process / Mfg Route	EAF + L.F. + V.D. + CCM + EMS																																												
Chemistry	%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Mo	%Al	%Cu	%As	%Sb	%V	%Nb	%Ti	%B																													
Min	0.15	1.00	0.300	0.030	0.005	1.00	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002																													
Max	0.20	1.20	0.350	0.035	0.005	1.30	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002																													
Mill Tc Value	0.163	1.286	0.340	0.033	0.002	1.91	0.103	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002																													
Spectro Value	0.173	1.296	0.328	0.033	0.018	1.192	0.104	0.004	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002																													
Bar Size (As per WI...)	Qty: 10 % Of Total Heat							Diameter/Section Size (in mm)																																					
No of Bar Checked	S.NO.	1	2	3	4	5	6	7	8	9	10	11	12																																
		82.3	82.1	82.4	82.1	82.4	82.0	82.3	82.5	82.1	82.4	82.3	82.1																																
Gas Content (PPM): As per Mill Tc			N2	H2	O2																																								
			Min																																										
			Max																																										
			Value																																										
			Mill Tc	95	0.887	13																																							
Steel Supply Condition:	HOT ROLLED																																												
MACRO (i)	Internal soundness Sample : (ASTM E381 or as per customer)																																												
(ii)	Dendrite structure 01 sample : Value Obs. S R C																																												
(iii)	Step Down Test Sample : (IS4075 or as per customer) OK																																												
Micro structure As Rolled :	Micro structure : (or as per customer)																																												
	Mill Tc P+F																																												
	SSB P+F																																												
ULTRASONIC TEST (AS PER ASTM A388) :	Mill Tc 100% Done																																												
INCLUSION RATING (IS 14163 / ASTM: E454 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	2.0	1.0	2.0	1.0	2.0	1.0	2.0	1.0																																	
Mill Tc			1.5	0.5	1.5	0.5	1.5	0.5	1.5	0.5	1.5	0.5																																	
SSB			1.5	0.5	1.5	0.5	1.5	0.5	1.5	0.5	1.5	0.5																																	
GRAIN SIZE : (ASTM E112 / IS-4748)	Spec.: 5-8 Mill Tc 7 SSB 6.00																																												
JOMINY HARDENILITY IS-3848 / ASTM A255 (As per required by Customer)	Distance		5	10	25																																								
	Specified		39-43	35-39	31-37																																								
	Mill Tc		42	36	28																																								
	Observed		40	35	26																																								
MECHANICAL PROPERTIES : (If Required in TDC / Customer)																																													
					As per IS:1608 / ASTM A 370				As per IS: 1757																																				
					U.T.S	Y.S	N/mm2	%EL	IMPACT VALUE				IMPACT VALUE																																
					N/mm2 / MPA	/MPA			CHARRY				IZOD																																
	Specified																																												
	Observed																																												
As Rolled Hardness (BHN (Max / Min) (If Required in TDC / Customer)			1	2	3	4	5																																						
			228	270	231	233	237																																						
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 BLOOM SIZE : 240x210 REDUCTION RATIO : 11.5:1 (If Required in TDC / Customer) As Per Mill Tc																																													
DECARB LEVEL : (AS PER IS 6396 / ASTM E1077) (If Required in TDC / Customer)	Specified																																												
	Observed		PD	0.10										FD																															
UPSETIBILITY TEST (AS PER IS 10167) :	OK																																												
Test Certificate verified for Each Heat no :			Available & OK	Not Available	Not Conforming																																								
TDC / Customer STD (If Required in TDC / Customer)	SSB/TDC/		Mill Tc No. 5488	Mill Tc Date 22/12/25	Verified By :																																								
			PLS 258.02																																										
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																																													

