



## RAW MATERIAL INCOMING INSPECTION REPORTS

P.C. No. :- 1/05/01  
Issue no. :- 01, 01.07.2018  
Rev. no. :- 02, 11.05.23

15162	SECTION :-	8000	HAUT NO :-	50798	INVOICE NO :-	15613							
251125	STEEL SUPPLIER :-	SLP	REC CITY :-	109019	INVOICE DATE :-	21/12/20							
20100000	STEEL TC NO :-	25021000	NO. OF BARS :-	31									
Process/Ally Route	001F	001F	001F	001F	001F	001F							
Chemistry	%C	%Mn	%Si	%S	%P	%Ni	%Mo	%Al	%Cu	%Nb	%V	%Ti	%H
	0.19	1.1	0.15	0.020	1.0	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
Max	0.28	1.4	0.40	0.035	1.3	0.015	0.015	0.015	0.015	0.015	0.015	0.015	0.015
Min	0.16	0.8	0.08	0.015	0.015	0.015	0.015	0.015	0.015	0.015	0.015	0.015	0.015
Max Value	0.15	1.28	0.25	0.020	1.14	0.013	0.013	0.013	0.013	0.013	0.013	0.013	0.013
Min Value	0.15	1.28	0.25	0.020	1.14	0.013	0.013	0.013	0.013	0.013	0.013	0.013	0.013

Bar Size (As per WT.) : 100mm x 10mm x 10mm  
Qty: 10 % Of Total Heat

S NO	1	2	3	4	5	6	7	8	9	10	11	12
1	80.2	80.1	80.1	80.2	80.4	80.3	80.1	80.4	80.2	80.5	80.1	80.3

Gas Content (PPM): As per Mill Tc	N2	H2	O2
Min	90	2	20
Max	90	2	20
Value	84.1	1.12	15.3

Steel Supply Condition: Hot Rolled

ATACRO	(i)	Internal soundness Sample: (ASTM E381 or as per customer)	S2	R2	C2	Plan
	(ii)	Dendrite structure 01 sample: Value Obs.	S2	R2	C2	
	(iii)	Step Down Test Sample: (IS-4075 or as per customer)	OK			

Micro structure As Rolled:	Micro structure: (or as per customer)
	Mill Tc
	SSB
	F4P
	F4P

ULTRASONIC TEST (AS PER ASTM A388): Mill Tc 100% Done

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	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0		
Mill Tc	1.5	0.0	0.5	0	0	0	0.5	0		
SSB	1.5	0.0	0.5	0	0	0	0.5	0		

GRAIN SIZE: (ASTM E112 / IS-4748) Spec: 500µm Mill Tc 7 SSB 0.5

JOMINY HARDENILITY (IS-3848 / ASTM A255) (As per required by Customer)	Distance	1.5	3	5	7	9	11	13	15	20	25
	Specified	41-46	39-45	38-43	34-41	31-38	29-36	27-34	26-33	23-31	21-30
	Mill Tc	45.5	42.8	41.9	36.9	34.6	33.1	30.8	29.4	25.9	23.4
	Observed	43	43	40	36	34	31	29	28	25	23

112

MECHANICAL PROPERTIES : (If Required in TDC /Customer )

	As per IS:1608/ ASTM A 370				As per IS: 1757	
	U.T.S	YS	N/mm <sup>2</sup>	%EL	IMPACT VALUE	IMPACT VALUE
	N/mm <sup>2</sup> /MPA		MPA		CHERRY	IZOD
Specified	1800-1850	885 min	8 min	25 J min		
Observed	1706.475	1271.237	21.64	30.3		

As Rolled Hardness

1	2	3	4	5
172	174	175	176	178

(BHN (Max / Min)

(If Required in TDC /Customer )

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 - 200x300 REDUCTION RATIO: 7.96%

DECARB LEVEL: (AS PER IS 6396 / ASTM E1077) (If Required in TDC / Customer)	Specified	1.1% of dia mm
	Observed	0.20

UPSETABILITY TEST (AS PER IS 10167): OK

Test Certificate verified for Each Heat no:	Available & OK	Not Available	Not Conforming
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TDC / Customer STD SSB/TDC Mill Tc No. Mill Tc Date Verified By

MIX-UP TEST (If Required in TDC / Customer) Verified By Mobile Spectro / X-Ray Gun / Spark Test

Other Remarks: Accepted

Checked By: Approved By: