



RAW MATERIAL INCOMING INSPECTION REPORTS

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

1783	SECTION :-	70mm	HAET NO. :-	K202254	INVOICE NO. :-	9043036945
51425	STEEL SUPPLIER :-	Kalyani Steel	REC.QTY :-	12970kg	INVOICE DATE :-	21/12/21
1105504	STEEL TC NO. :-	K202254	NO. OF BARS :-	72		
Process / Mfg Route	EoF - V-D - CCM CEMS + FMI (C) - RmZ11					
%C	%Mn	%Si	%S	%P	%Cr	%Ni
0.250	0.600	0.150	0.020	0.000	0.150	0.010
0.150	0.400	0.400	0.040	0.035	1.200	0.300
0.420	0.845	0.184	0.020	0.019	1.149	0.0210
0.440	0.890	0.188	0.008	0.015	1.200	0.003
					0.170	0.024
					0.010	
						0.003
						0.002
						0.005
						0.000

Bar Size (As per WI...)	Qty: 10 % Of Total Heat											
S.NO.	1	2	3	4	5	6	7	8	9	10	11	12
	70.3	70.5	70.1	70.4	70.5	70.3	70.5	70.3	70.1	70.4	70.2	70.5

Gas Content (PPM): As per Mill Tc	N2	H2	O2
Min	60		
Max	120	2.00	1.5
Value			
Mill Tc	90	1.490	11

Steel Supply Condition:	Hot Rolled
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MACRO	(i)	Internal soundness Sample : (ASTM E381 or as per customer)	S3	R3	C2 MAX
	(ii)	Dendrite structure 01 sample :	S3	R3	C2
	(iii)	Step Down Test Sample : (IS4075 or as per customer)			OK

Micro structure As Rolled :	Micro structure : (or as per customer)
Mill Tc	
SSB	P + F + B

ULTRASONIC TEST (AS PER ASTM A388) :	Mill Tc	100% UT OK
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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
Cust Spec. If Any	2.0	1.5	2.0	1.0	0.5	0.5
Mill Tc	1.5	0.5	0.5	0.0	0.0	0.0
SSB	1.5	0.5	0.5	0.0	0.0	0.0

GRAIN SIZE : (ASTME112 / IS-4748)	Spec. :-	5-8	Mill Tc	7.0	SSB	7
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JOMINY HARDENBILITY IS-3848 /ASTMA255 (As per required by Customer)	Distance	1.5	3	5	7	9	11	13	15	20	25	30
	Specified	55-61	55-61	55-61	54-60	53-60	51-59	49-58	48-58	44-56	41-53	39-51
	Mill Tc	59	58	57	56	55	54	53	52	49.5	46	42
	Observed	59	58	57	56	55	54	53	52	47	43	42

MECHANICAL PROPERTIES : (If Required In TDC /Customer)	As per IS:1608/ ASTM A 370	As per IS: 1757			
	U.T.S N/mm2 /MPA	Y.S N/mm2 /MPA	%EL	IMPACT VALUE CHERRY	IMPACT VALUE IZOD
	Specified	1030-1230	835 Min	10 min	25 min
	Observed	1069.104	878.00	28.20%	34 J
As Rolled Hardness (BHN (Max / Min) (If Required In TDC /Customer)	1	2	3	4	5
	258	259	261	263	264

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 : 1:10.39
(If Required In TDC /Customer) As Per Mill TC		

DECARB LEVEL : (AS PER IS 6396 / ASTM E1077)	Specified	0.60 mm MAX
(If Required In TDC /Customer)	Observed	PD

UPSETIBILITY TEST (AS PER IS 10167) :	OK
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Test Certificate verified for Each Heat no :	Available & Ok	Not Available	Not Conforming
	OK		

TDC / Customer STD (If Required In TDC /Customer)	SSB/TDC/	Mill Tc No.	Mill Tc Date	Verified By :
	RF1001 RB	K202254	1.04.25	

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

Other Remarks	
Checked By	Subodh
Approved By	