

RAW MATERIAL INSPECTION

Sl. No.	Lot No. / Heat No.	Drawing No.	Item Description	Qty in Nos.	Material Specification	Form III F TC No / Date	TC Qty in Nos.	Vendor Name
1	F4902	2CG99050 Iss. 1	Body Casting, 10" 300# FF/RF Globe	1	ASTM A216 Gr. WCC	PKC/F4902/SG496/1 24/08/2020	1	Peekay Steel Castings (P) Ltd
2	B7296	108975/600 Iss. 7	25mm 600# Globe Control Valve Body Casting	1	ASTM A216 Gr. WCB	SG/B7296/19 02/08/2020	1	Venkatalakshmi Alloy Casting Pvt. Ltd



Quality Control Engineer
 Severn Glocon India
 Chennai, Tamil Nadu

Inspecting Authority

2012925, 71292501

8058-2-1

PK-QA-02-Rev.0



PEEKAY STEEL CASTINGS (P) LTD

4/242 Chinnamaddampalayam, Billichy Post, Coimbatore - 641 019

Email: info@pkcbe.co.in, Phone: 04254 - 271610

Form III F

Certificate of Manufacture and test of Castings (Regulations 73 to 80)

Customer:	Order No and Date	PO Line No	TCNo	PKC/F4902/SG496/1
Severn Glocon India Pvt Ltd	PO2002101 / 02/06/2020	1	Date	24-Aug-2020
F.P. No	Part Name	Item Code / Part No		
SG496	BODY CASTING, 10" 300# RF/FF	2G99050-C1010-IBR1		
Drawing No	No. of pieces			
2G99050 ISS 1	1			
Specification /Material	No. of pieces			
ASTM A216 Gr.WCB/WCC 2018 & PTS RM001 Iss.1	1			
Poured Date : 30/07/2020				

Heat treatment	Melting Process	State of Delivery
Normalising at 920°C soaked for 6 hours then open air cooled. HT Cycle No:HTF0667 Dt:05/08/2020	INDUCTION	Unmachined

Chemical Composition (%)

Element	C	Mn	Si	P	S	Cr	Ni	Mo	Cu	V	CE	Res				
Min. Specified				
Max. Specified	0.220	1.280	0.600	0.025	0.025	0.500	0.500	0.200	0.300	0.030	0.420	1.000				
Heat No																
F4902	0.198	0.930	0.434	0.012	0.011	0.074	0.081	0.015	0.013	0.002	0.377	0.185				

Heat Sinos: 2

Mechanical Properties	Yield Strength	Tensile Strength	% of Elongation		Reduction of Area	Hardness	Bend Test Angle at 120°	Impact value ISO V at 0°C in Joules			
			GL=50 mm	GL=62.5 mm				Single Value		Average	
Min	275	485	22	...	35	...	D=3t				
Max	...	655	200					
Heat No	Mpa	Mpa	%	%	%	HBW		1	2	3	Avg
F4902	310	522	31.72	-	56.41	163.00	PASSED

Remarks:

Material confirm to :ASTM A216 Gr.WCB/WCC 2018 & PTS RM001 Iss 1 & C1010 & NACE MR0175/ISO 15156/NACE MR0103.

Castings are No major welding carried out.Casting supplied with carbon steel fully killed and fine grained condition .

Test bar as per Specification : ASTM A1067.

Test as per Specification : ASTM A370.

MPI testing carried out as per ASTM E709 & ASME B16.34 App.II,ASME Sec VIII Div.1 App 6 /MSS SP 58.

Visual inspection of casting: Satisfactory According to MSS-SP-55 & SGI/OP/130.

Wall Thickness & Dimensional inspection: Satisfactory According to Approved Drawing .

Certified that the products supplied is free from Radioactive element or contamination

Foundry Identification : PKC

SEVERN REVIEWED & ACCEPTED
GLOCON INDIA
QUALITY
SIGN / DATE
A. THANGAM

We here by declare that the items mentioned above have been tested and inspected in our presence and are found to be in accordance with drawings, specifications and satisfy the requirements of the INDIAN BOILER REGULATIONS 1950

K. Vijaya Kumar
Asst.Manager (QA)

Makers Representative

Peekay Steel Castings (P) Ltd., Coimbatore - 19







Thilagaranjan D
Manager (Production)
Makers

Peekay Steel Castings (P) Ltd., Coimbatore - 19

IBR WELLKNOWN FOUNDRY upto 1500 Kg/piece CBB No.310 Dated 13-Sep-2013, valid upto 10-Jul-2023

Registered office : Nallalam, Calicut, Kerala, India - 673027. Ph: 0495-2422500. Email: info@peekaysteel.com

	VENKATALAKSHMI ALLOY CASTINGS PVT.LTD, 344, Trichy Road, Singanallur, Coimbatore - 641 005 Pin : , Phone :0422 - 257 4480, email :venkatalloy@yahoo.co.in										ISO : 9001 : 2015 Certified Company		
	MATERIAL TEST CERTIFICATE - FORM III F [CERTIFICATE OF MANUFACTURING AND TEST OF CASTINGS REGULATIONS 73 TO 80]												
Customer : M/s SEVERN GLOCON INDIA PRIVATE LIMITED Chennai 602117										T.C. No. : SG/B7296/19 Heat No. : B7296			
P.Order No. : PO1901287 Dt. 20/04/2019										T.C.Date : 02/08/2019 Pouring Date : 13/06/2019			
Specification : ASTM A216 Gr.WCB/WCC-2018										CASTING PROCESSED BY INDUCTION MELTING FOUNDRY IDENTIFICATION : VAC			
CHEMICAL COMPOSITION %													
Element	C	Mn	Si	P	S	Cr	Ni	Mo	Cu	V	Al	TRE	CE
Minimum	---	---	---	---	---	---	---	---	---	---	---	---	---
Maximum	0.220	1.000	0.600	0.030	0.025	0.500	0.500	0.200	0.300	0.030	0.060	1.000	0.420
Actual	0.182	0.846	0.364	0.028	0.012	0.167	0.018	0.040	0.001	0.005	0.057	0.231	0.367
HEAT TREATMENT : Normalising: Temp raised to 920°C Soaked for 2 hrs and then Atmospheric Air Cooled.(Cycle No: 738 - 04.07.2019)													
MECHANICAL PROPERTIES													
Requirments	Yield Strength		Tensile Strength		% Elongation	% Reduction	Hardness	Bend Test D = AT 120°D=3t	Impact Test in (Joules) (10mm X 10mm X 55mm)				
	Kgf/mm²	MPa	Kgf/mm²	MPa	GL :50 mm	of Area	HBW						
	0.2 % Proof Stress												
Minimum	28.05	275.00	49.47	485.00	22.00	35.00	---						
Maximum			66.81	655.00	---	---	200	-	1	2	3	Avg	
Actual	30.72	301.19	58.67	575.24	35.64	58.66	156	PASSED	--	--	--	--	
ITEM DESCRIPTION													
SL.No.	Description					Drawing No.		Part No.		Quantity			
1	BODY CAST 025-600#					108975 ISS 7		108975/600-C1010-IBR1		1			
Remarks : Castings are visually inspected, acceptable as per MSS-SP-55 & SGI/OP/130 MPI Carried out and found Acceptable. Castings are free from Radioactive Contamination Dimension & Wall Thickness verified and found Acceptable. Material accepted as per PTS RM001 ISSUE: 01 & Material code C1010-IBR1 ,NACE MR0175/NACE MR0103-2015. Welding Process not Done. The above Castings are Fully killed & Fine grained.													
We Confirm that the above material was manufactured, sampled, tested and inspected in accordance with the drawings, material specification and customer order requirements. INDIAN BOILER REGULATIONS 1950, ASTM A216 Gr.WCB/WCC-2018 and found to meet the requirements.													
Prepared By  MOHAN.M Quality Assurance Maker's Representative					 Manufacturer Stamp					For VENKATALAKSHMI ALLOY CASTINGS PVT.LTD,  SIDAARTH Joint Managing Director Makers			