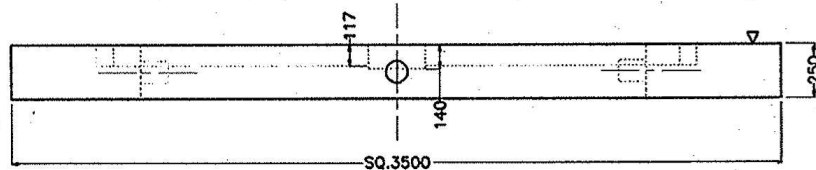


SEC. A-A



TOP & BOTTOM PL. SPECIFICATION	
MATERIAL GREY CAST IRON (IS: 3005 PART - III 1982)	
COMPOSITION	
	%
CARBON EQUIVALENT	4.0 - 4.5
TOTAL CARBON	3.4 - 3.6
COMBINED CARBON	0.10 - 0.30
SILICON	1.4 - 1.8
MANGANESE	0.50 - 0.80
SULPHUR MAX	0.08
PHOSPHORUS MAX	0.3

NOTES :-

1. THE INSIDE SURFACE SHOULD BE CLEAN FROM MOULDING SAND, FREE FROM SEAMS, SAND DEPRESSION, PROJECTIONS, CRACKS, CRUST, CAVITIES, COLD, SHUT, SCRUFF MARKS, FITTINGS, SCABS, RAT TAIL, AND OTHER SIMILAR DEFECTS.
2. NO RECTIFICATION OF INSIDE DEFECTS OR CAVITIES BY WELDING IS PERMITTED, OUTSIDE SURFACE SHALL BE FREE FROM CRACKS, CAVITIES, PROJECTION, FINS AND BURNT SAND.
3. EASY STRIPPING OF INGOT TO BE GUARANTEED.
4. TOP FACE OF BOTTOM PLATE SHOULD BE MACHINED AS TO MAKE IT PERPENDICULAR TO THE AXIS OF INGOT MOULD.
5. DEVIATIONS OF CASTING DIMENSIONS SHALL BE GOVERNED AS PER CL 15 OF IS: 3005 (PART - III) 1982.
6. MATERIAL SHOULD HAVE STRUCTURE OF CAST IRON PEARLITIC - FERRITIC WITH FLAKED GRAPHITE AND WITHOUT PRESENCE OF FREE CEMENTITE.

MATERIAL :- GREY IRON

WEIGHT :- 19T. (APPROX)

S.K. DALAL
20/03/15

HOS - SMR

DRG. PREPARED AS PER SUPPLIED SKETCH VIDE MEMO No. 8403/GENL/SMR/04 DATED 12-03-15

ITEM NO.	DESCRIPTION	NO. OFF	MATERIAL	HARDNESS	REMARKS
AMENDMENTS					
INDEX	DESCRIPTION				DATE NAME ZONE
CLEANING ROUGHING SMOOTHING FINISHING	BOTTOM PLATE FOR 20 TON EAF (Ø420, 20", 23" & 26" MOULD) AT S M R SECTION BASED ON SIMPLEX CASTINGS LTD., BHILAI DRG. No. SCL-15-BP-001 REV NO.- 01			SCALE	DRAWN 13-03-15 S.K.DALAL TRACED CHECKED
				NTS	APPROVED JMM/DO WM/QC
METAL & STEEL FACTORY, ISHAPORE				DRG. NC. 0H - 385	

GUIDE SKETCH



UN CONTROLLED