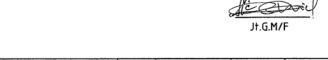


CHEMICAL COMPOSITION	MECHANICAL PROPERTIES	MICRO STRUCTURE		
SG IRON AS PER IS 1865:1991 GR-400/18 CARBON : 3.4-3.8 MANGANESE : 0.2-0.3 SILICON : 2.2-2.4 SULPHUR : 0.03 MAX. PHOSPHORUS : 0.08 MAX. MAGNESIUM : 0.04-0.05	Tensile Strength (MPA) - 400, Min. 0.2% Proof stress (MPa) - 250, Min. Elongation% - 18, Brinell Hardness - 130-180	Predominant constituent of matrix is Frrite with min 80% of graphite nodules in the form of V or VI as specified in IS:7754:1975		

GENERAL PROPERTIES

- THE INSIDE SURFACE SHOULD BE CLEAN FROM MOULDING SAND, FREE FROM SEAMS, SAND DEPRESSIONS, PROJECTIONS, CRACKS, CRUST, CAVITIES, COLD SHUT, SCRUFF MARKS, PITTING, SCARBS, 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, FINES AND BURNT SAND.
- 3. EASY STRIPPING OF INGOT TO BE GUARANTEED.
- 4. BOTTTOM FACE OF INGOT MOULD SHOULD BE CAST TO MAKE IT PERPENDICULAR TO THE AXIS OF INGOT MOULD TOP AND BOTTOM SURFACE SHOULD BE MACHINED.
- 5. DEVIATIONS IN INGOT MOULD DIMENSIONS SHALL BE GOVERNED AS PER IS:8350:1977.
- 6. 02Nos. CAST ON TEST SAMPLE MUST BE PROVIDED AT SUITABLE POSITION.



	20"	20"X2500m.m.LONG INGOT MOULD. AS MENT				D			
	R₁	INGOT MOULD SI	PEC. & GENL. P	ROP. AMENDED VID	E MEMO NO. 84/SMF	8/11-12/PV8	MCO dt. 23	-8-11	WWOO WAN
	B	DIMENSIONS	112.5 , 225	& 275 INCOR	PORATED		Bissel	م م	1
		ИО	1 13-04-09			3	WM/DO	WIL	04.00
		DES	CRIPTION OF	AMENDMENTS.				21	VM/SM
		61140		04110500		SCALE	DRAWN	28-3-08	S.DEBR
		C.I MOULD 20"X2500m.m.				CHECKED			
			MOD	DIFIED		NTS	CHECKED	1 /	
							Nur	15 P	du
1 00							JWM/00	· · ·	DGM/ITC
V CO	PY	METAL &	STEEL F	ACTORY,IS	HAPORE	DRG. N	O. OH	1012/153	3 R ₁