



INGOT MOULD SPECIFICATION

| CHEMICAL COMPOSITION | MECHANICAL PROPERTIES | MICRO STRUCTURE |
|---------------------------------------|--|---|
| SG IRON AS PER IS 1865:1991 GR-400/18 | Tensile Strength (MPa) - 400, Min. 0.2% Proof stress (MPa) - 250, Min. Elongation% - 18, Brinell Hardness - 130-180 | Predominant constituent of matrix is Ferrite with min 80% of graphite nodules in the form of V or VI as specified in IS:7754:1975 |
| 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 | | |

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GENERAL PROPERTIES

1. 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. BOTTOM 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.

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|------------------------------------|---|-------------------------------------|
| 20"X2500m.m.LONG INGOT MOULD. | AS MENTIONED | |
| R ₁ | INGOT MOULD SPEC. & GENL. PROP. AMENDED VIDE MEMO NO. 84/SMR/11-12/PV&MCO dt. 23-8-11 | |
| ② | DIMENSIONS 112.5, 225 & 275 INCORPORATED | |
| | ON 13-04-09 | JWM/DC |
| DESCRIPTION OF AMENDMENTS. | | |
| C.I MOULD 20"X2500m.m. MODIFIED | | SCALE NTS |
| | | DRAWN 28-3-08 S.DEBROY |
| | | TRACED |
| | | CHECKED |
| | | JWM/DC |
| | | DGM/ITC |
| METAL & STEEL FACTORY, ISHAPORE | | DRG. NO. OH 1012/153 R ₁ |

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