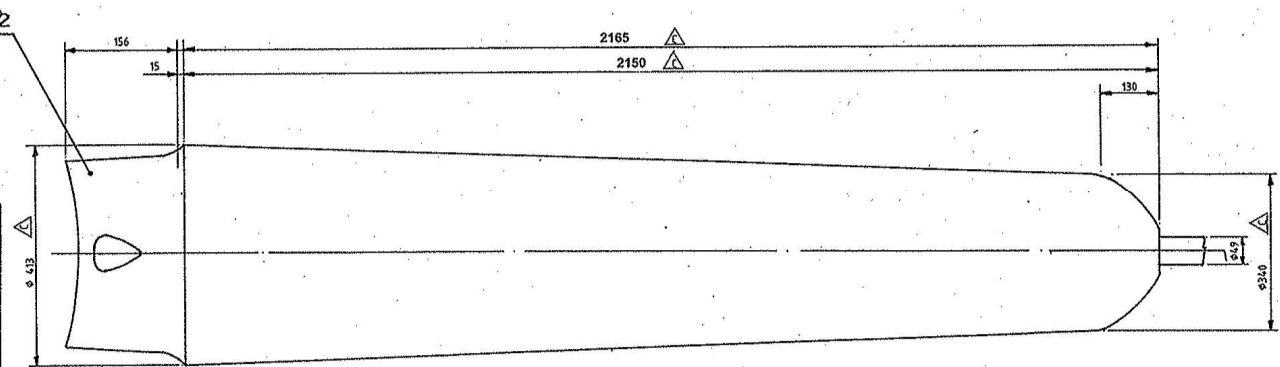


UN CONTROLLED

CHEMICAL COMPOSITION %	
S.G. 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

MECHANICAL PROPERTIES	
TENSILE STRENGTH (MPa) - 400	
MIN. 0.2% PROOF STRESS (MPa) - 250,	
MIN. ELONGATION % - 18,	
BRINELL HARDNESS - 130-180	

MICRO STRUCTURE	
PREDOMINANT CONSTITUTE OF MATRIX IS FERRITE WITH MIN. 80% OF GRAPHITE NODULES IN THE FORM OF V OR VI AS SPECIFIED IN IS: 7754:1975	



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. 02 Nos. CAST ON TEST SAMPLE MUST BE PROVIDED AT SUITABLE POSITION.

14.07.15
AWM/SMR

14/7/15
HOS/SMR

ITEM NO	DESCRIPTION	MATERIAL	NO.OFF	REMARKS
AMENDMENTS				
INDEX NO	DESCRIPTION OF AMENDMENTS		DATE	AMEND. AUTHO. USER SEC.
SCALE: NTS	BOTTOM POURING SG IRON INGOT MOULD TO SIZE		14/7/15	SKP
3RD ANGLE PROJECTION	Ø385 x 2265 mm LG		CHECKED	APPROVED
	REF. MSF DRG. NO. LFVD/1000/23/1		W.M.I.C.C. & A	
	METAL & STEEL F.Y. ISHAPORE		DRG.NO.	0.H-391