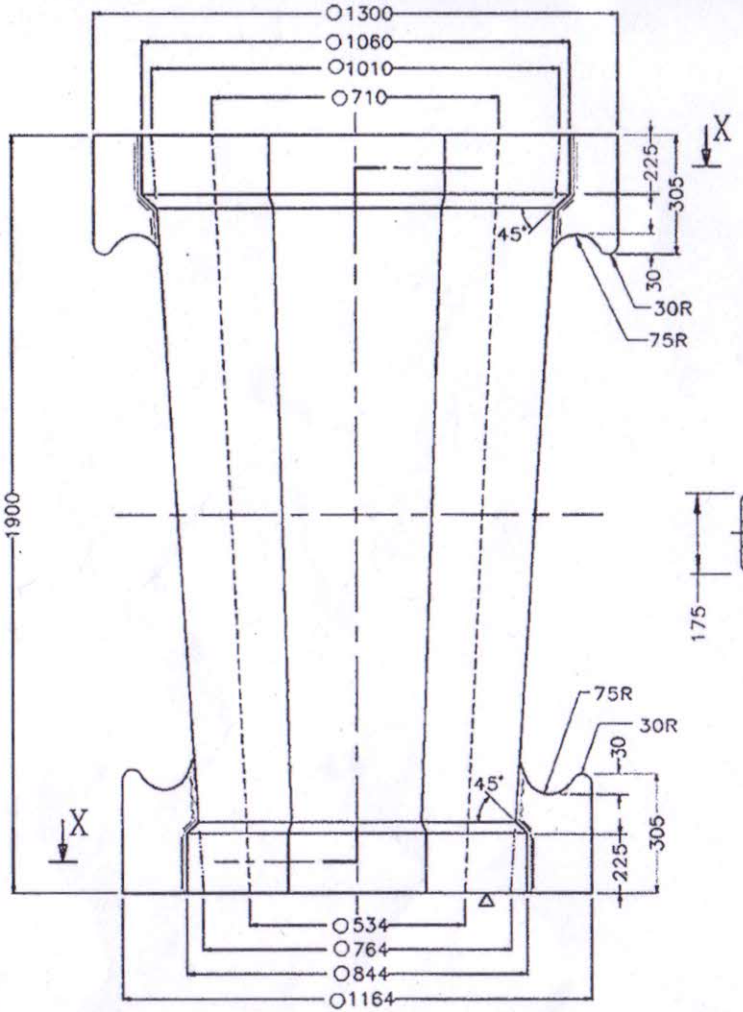
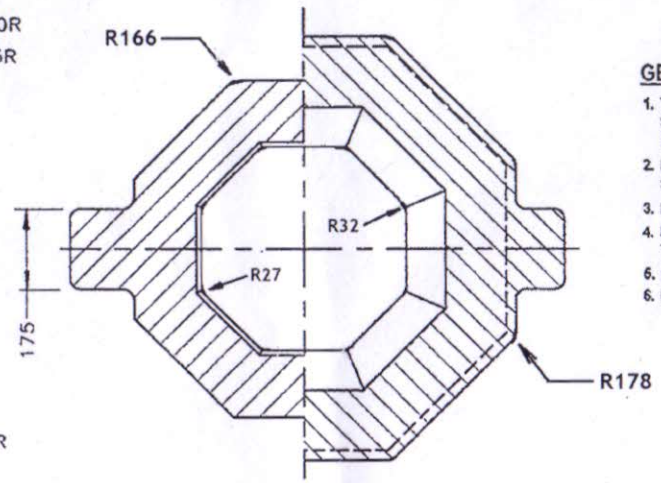
ALL DIMENSIONS ARE IN MM

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 60% 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		





VIEW X-X

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. 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.
6. 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.

WT. OF INGOTS - 4.95T (APPROX)
WT. OF MOULD - 4.8T (APPROX)

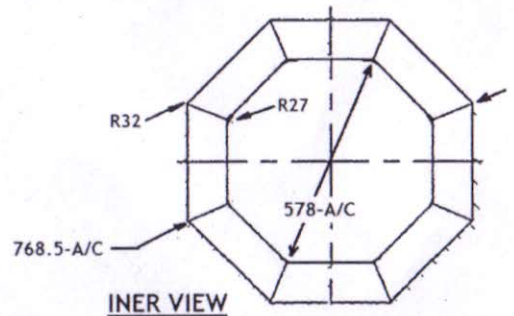
7/5/15
HOS - SMR

DRG. PREPARED AS PER SUPPLIED SKETCH (MEMO No. 6426/SMR/DRG. DATED 09-04-15)

METAL & STEEL FACTORY ISHAPUR JWM/SMR DRAWING OFF.CE 14/10/15

UN CONTROLLED

GUIDE SKETCH



INER VIEW

ITEM NO.	DESCRIPTION	NO. OFF	MATERIAL	HARDNESS	REMARKS
AMENDMENTS					
INDEX	DESCRIPTION			DATE	NAME / ZONE

CLEANING
ROUGHING
SMOOTHING
FINISHING

26"OCTAGONAL S.G. IRON MOULD

FOR 20 TON EAF

AT S M R SECTION

SCALE: NTS

DRAWN 09-04-15 S.K.DALAL

TRACED

CHECKED

APPROVED

JWM/DO JWM/QC

METAL & STEEL FACTORY, ISHAPORE

DRG. NO. O·H·-386