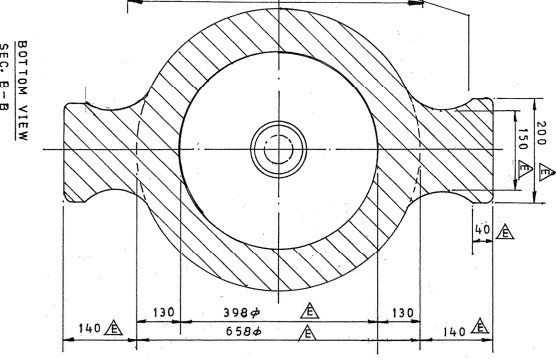


INGOT MOLD SPECIFICATION

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,	Predominant constituent of matrix is Ferrite with min 80% of graphite nodules in the form of V or V as specified in IS : 7754-1975
CARBON : 3.4 - 3.8		
MANGANESE : 0.2 - 0.3	Min. Elongation % - 18,	
SILICON : 2.2 - 2.4	Briell Hardness - 130-180	
SULPHUR : 0.03 Max.		
PHOSPHORUS : 0.08 Max.		
MAGNESIUM : 0.04 - 0.05		

GENERAL PROPERTIES

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



ITEM	DESCRIPTION	QTY	MATERIAL	UNIT
1	MOLD φ420x2150 LG.	1	CARBON & LOW ALLOY STEEL	4.0 TON
2	ELECTRODE	1	GREY IRON	2.3 TON

NO.	DESCRIPTION OF AMENDMENTS	DATE	BY	CHKD
R1	INGOT MOLD SPECIFICATION & GENERAL PROPERTIES AMENDED	14.08.2011
M	VIEW REF. MENC NO. 8/58/1120/RS/DL. 12.8.2011	12.08.2011
MA	DESCRIPTION OF AMENDMENTS	14.08.2011

NO.	DESCRIPTION	DATE	BY	CHKD
1	MOLD & ELECTRODE (TYPE - A) φ420x2150 LG.	14.08.2011
2	Rev. 02: 02 Nos. Cast on test sample must be provided	14.08.2011
3	Rev. 01: 02 Nos. Cast on test sample must be provided	14.08.2011

APPROVED
DATE: 14.08.2011
BY: ...
CHKD: ...
DGM/STEEL