

SPECIFICATION OF STEEL CASTING PRODUCTS

CASTING POWDER (FOR BILETS)

PHYSICAL PROPERTIES		CHEMICAL PROPERTIES	
PARTICLE SIZE:	MORE THAN 80% PARTICLES PASSING THROUGH 90 MICRONS.	SiO ₂ :	30-33 %
		CaO:	27-30 %
		Al ₂ O ₃ :	4-7 %
		Na ₂ O/K ₂ O:	5-8 %
		F:	5-8 %
		MgO:	1-3 %
		Li ₂ O:	0.5-1.5 %
		C FREE:	20-23%
		MELTING POINT:	1050 ± 20 DEG. C.
		VISCOSITY AT 1300 DEG.C. :	4.2 - 4.8 POISE

CASTING POWDER FOR SLAB (LOW CARBON)

PROPERTIES	
CASTING SPEED:	0.7 to 1.1 M/MINUTE & 0.5 TO 0.9 M / MINUTE RESPECTIVELY.
THICKNESS:	200 MM TO 250 MM
CARBON RANGE :	C = 0.01 TO 0.07 & 0.15 TO 0.20

CASTING POWDER FOR SLAB (HIGH CARBON)

PROPERTIES	
CASTING SPEED:	0.7 to 1.1 M/MINUTE & 0.5 TO 0.9 M/MINUTE RESPECTIVELY.
THICKNESS:	200 MM TO 250 MM
CARBON RANGE :	C = 0.21 TO 0.30

IRON CASTING

CAST IRON AS PER IS: 210 – 1978
GREY IRON CASTINGS AS PER IS: 3355: 1974

STEEL CASTINGS

Mn STEEL CASTINGS AS PER IS: 2708: 1993 AND IS : 276: 1978.
CARBON STEEL CASTINGS AS PER IS: 1030-1998
HIGH TENSILE STEEL CASTING AS PER IS: 2644-1979