

Metal Poured At OTPL

PARTICULARS	As per ASTM	As per DIN
Carbon Steel	A216 - WCB	1.0619
	A216 - WCC	-
	A352 - LCC	1.1138
	A352 - LCB	-
Low Alloys Steels	A217 - WC1	1.5419
	A217 - WC4	-
	A217 - WC5	-
	A217 - WC6	1.7356
	A217 - WC9	1.7379
	A217 - WC11	-
	A217 - C5	1.7363
	A217 - C12	-
Martens tic Steels	A297 - HF	1.4825
	A297 - HH	1.4837
	A297 - HI	1.4846
	A297 - HK	1.4848
	-	1.4749
	A297 - HD	1.4823
Austenitic Stainless Steel	A351 - CF8	1.4308
	A351 - CF8M	1.4408
	A351 - CF3	1.4306
	A351 - CF3M	1.4404 / 1.4409
	A351 - CF8C	1.4827
	A351 - CF10	1.4308
	A351 - CK20	1.4843
	A351 - CH20	-
	A351 - CN7M	1.45
	A351 - CG8M	1.4431
Austenitic Ferrite Duplex Steels	A351 - CF3MN	1.4435
	A351 - CD4MCu	-
	A351 - CG6MMN	1.3964
	A351 - CK3MCuN	-

Super Duplex Stainless Steel	A890 - GR1A	-
	A890 - GR2A	-
	A890 - GR3A	-
	A890 - GR4A	-
	A890 - GR5A	-
	A890 - GR6A	-
Nickel Based Super Alloys	A494 - M-35-1	2.4365
	A494 - M-35-2	-
	A494 - M 30 C	-
	A494 - N-12MV	-
	A494 - N-7M	-
	A494 - CY40	2.4816
	A494 - CW12MW	2.4686
	A494 - CW6M	-
	A494 - CW2M	2.461
	A494 - CW6MC	2.4856
	A494 - CX2MW	2.4602
	A494 - Cu5MCuC	2.4858
	A560 - 50Cr50Ni	-
	A560 - 50Cr50Ni-Nb	2.4813
A560 - 60Cr40Ni	-	
Cobalt Based Alloys	STELLITE 3	-
	STELLITE 6	-
	STELLITE 21	-
	STELLITE 23	-
	Triballoy T 400	-

Castings can be supplied as per DIN, JIS, BS and GOST standards. Other than above, in general we can cast any material compositions as per customers specifications meeting international standards.

Investment castings tolerances

Reference international standard: **VDG P690**

Linear Tolerances		
Nominal size mm	D1 Tolerance(general dimensions)	D2 Tolerance(some functional dimensions)
0 to 6	±0.15	±0.12
6 to 10	±0.18	±0.14
10 to 18	±0.22	±0.17
18 to 30	±0.26	±0.20
30 to 50	±0.40	±0.31
50 to 80	±0.45	±0.37
80 to 120	±0.55	±0.44
120 to 180	±0.8	0 ±0.65
180 to 250	±1.20	±0.95
250 to 315	±1.30	±1.10
315 to 400	±1.80	±1.40

Tolerance for straightness, flatness, parallelism, shape			
Precision class	Length of the tolerated element		
		25 to 50 mm	up to 50 mm
	to 25 mm		
	allowed difference		
D1	0.15 mm	0.25 mm	0.60%
D2	0.10 mm	0.20 mm	0.40%

Tolerance for angle values and right angles				
Precision class	Nominal dimensions			
	to 30 mm	30 to 100 mm	100 to 200mm	up to 200mm
D1	allowed deviation			
minute degree	30	30	30	20
mm / 100 mm	0.87	0.87	0.87	0.58
D2	allowed deviation			
minute degree	30	20	15	15
mm / 100 mm	0.87	0.58	0.44	0.44
Surface quality according to ISO R 468, DIN 4769 and VSM10321				
	Ra	Rz	Rt	
N9	6.3	23-32	25-38	
Maximum Casting Size : 700.00 x 700.00 x 500.00				
Weight Range : 0.010 Kilogram to 140.00 Kilograms per piece				