

Burn on

Nature of Defect
This defect occurs locally adhering to the casting. Defect increases irregularly with increased pouring or high pouring temperature.

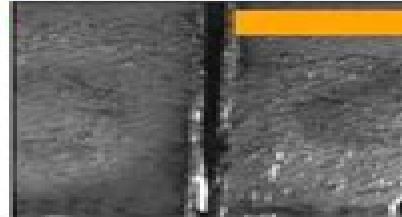
Remedies
Increase amount of furnace carbon (addition and take place) on the moulding sand. Increase amount of new sand of covering part of the sand to low and maintain in high.



Broken Mould

Nature of Defect
This defect occurs when the metal penetrates into the mould cavity, causing the metal to break into pieces. Defect arises on the casting away from the gate.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand.



Erosion

Nature of Defect
The sand is washed away from the surface of the metal, causing the metal to break into pieces. Defect arises on the casting away from the gate.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand. Increase the amount of new sand of covering part of the sand to low and maintain in high.



Explosion Penetration

Nature of Defect
Explosion penetration, when the metal is too hot and the sand is too dry.

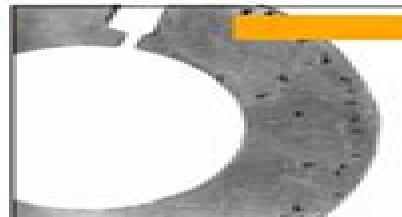
Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Lustrous Carbon Inclusions

Nature of Defect
Penetration of surface irregularities, inclusions and gas bubbles in the metal, causing the metal to break into pieces. Defect arises on the casting away from the gate.

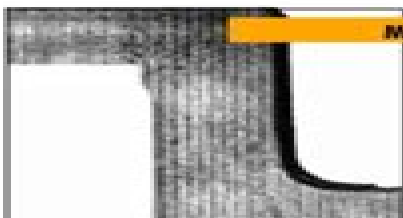
Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Fissure Defect

Nature of Defect
Narrow, parallel cracks, sometimes on the surface. Defect arises on the casting away from the gate.

Remedies
The defect is all in the metal. Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Micro Shrinkage

Nature of Defect
Micro shrinkage occurs in the metal when the metal is too hot and the sand is too dry.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Scarred Surface

Nature of Defect
Scarred surface occurs in the metal when the metal is too hot and the sand is too dry.

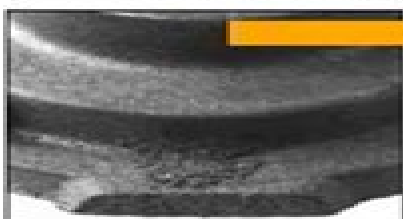
Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Blow Holes

Nature of Defect
Blow holes occur in the metal when the metal is too hot and the sand is too dry.

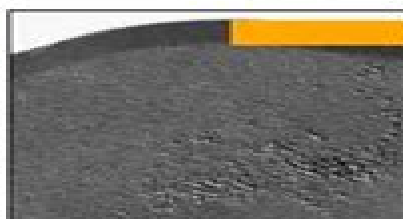
Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Penetration

Nature of Defect
Penetration occurs in the metal when the metal is too hot and the sand is too dry.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Pin Holes

Nature of Defect
Pin holes occur in the metal when the metal is too hot and the sand is too dry.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Roughness

Nature of Defect
Roughness occurs in the metal when the metal is too hot and the sand is too dry.

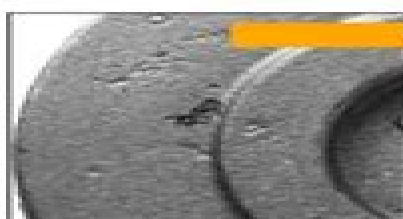
Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Sand Inclusions

Nature of Defect
Sand inclusions occur in the metal when the metal is too hot and the sand is too dry.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Slog Inclusions

Nature of Defect
Slog inclusions occur in the metal when the metal is too hot and the sand is too dry.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Scabs

Nature of Defect
Scabs occur in the metal when the metal is too hot and the sand is too dry.

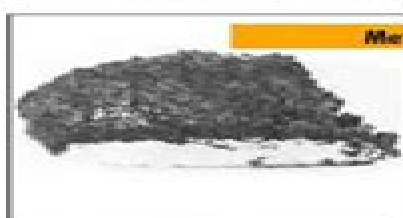
Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Swells

Nature of Defect
Swells occur in the metal when the metal is too hot and the sand is too dry.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Metal Penetration

Nature of Defect
Metal penetration occurs in the metal when the metal is too hot and the sand is too dry.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.



Blow Holes at Angles

Nature of Defect
Blow holes at angles occur in the metal when the metal is too hot and the sand is too dry.

Remedies
Reduce the temperature of the metal. Increase the strength of the moulding sand. Increase the amount of furnace carbon (addition and take place) on the moulding sand.

Manual Of Casting Defects

Kathleen Armour



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