

Burn on

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

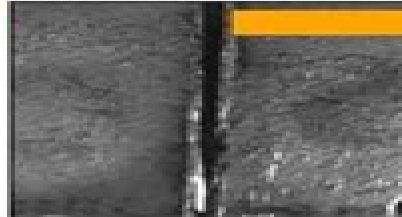
Remedies
Increase amount of furnace carbon (addition and take place) on the moulding sand. Increase amount of new sand of covering part of the sand to low and maintain in high.



Broken Mould

Nature of Defect
This defect occurs when the mould is broken into pieces, causing the casting to be incomplete.

Remedies
Reduce the temperature of the sand to low strength. Make compressibility of the moulding sand.



Erosion

Nature of Defect
The sand is washed away from the casting, causing the casting to be incomplete.

Remedies
Sand filling out of the sand (dry sand). 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.



Explosion Penetration

Nature of Defect
Explosion penetration, when the result of the sand is quickly.

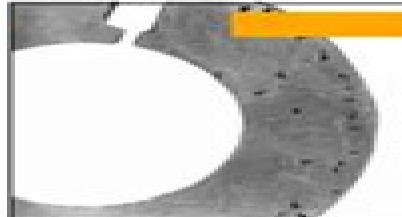
Remedies
Reduce amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Lustrous Carbon Inclusions

Nature of Defect
Penetration of surface irregularities, inclusions and gas bubbles in the casting, after pouring sand with the use of a ladle.

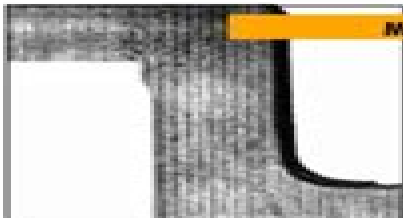
Remedies
The sand is washed away from the casting, causing the casting to be incomplete. Reduce amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Fissure Defect

Nature of Defect
Narrow, parallel cracks, sometimes on the surface, sometimes in the interior.

Remedies
The defect is all in the moulding sand. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Micro Shrinkage

Nature of Defect
Micro shrinkage occurs in the sand of the casting, which is due to the sand.

Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Scarred Surface

Nature of Defect
Scarring of the surface of the casting, which is due to the sand.

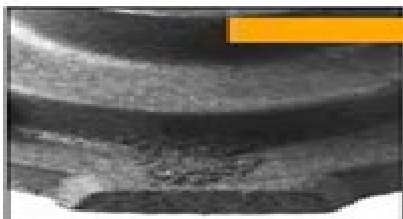
Remedies
Reduce amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Blow Holes

Nature of Defect
Blow holes are caused by the sand, which is due to the sand.

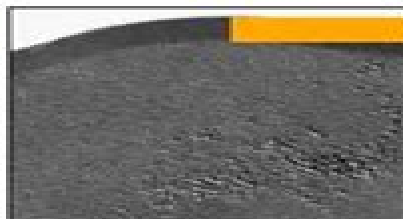
Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Penetration

Nature of Defect
Penetration occurs in the sand, which is due to the sand.

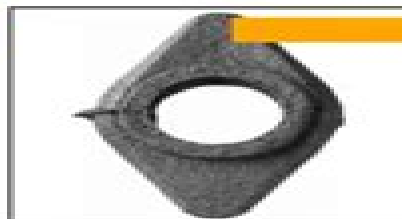
Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Pin Holes

Nature of Defect
Pin holes are caused by the sand, which is due to the sand.

Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Roughness

Nature of Defect
Roughness occurs in the sand, which is due to the sand.

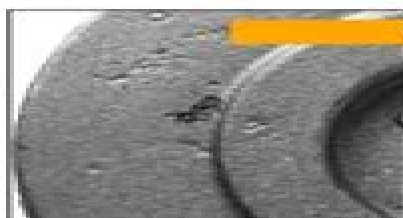
Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Sand Inclusions

Nature of Defect
Sand inclusions are caused by the sand, which is due to the sand.

Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Slog Inclusions

Nature of Defect
Slog inclusions are caused by the sand, which is due to the sand.

Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Scabs

Nature of Defect
Scabs are caused by the sand, which is due to the sand.

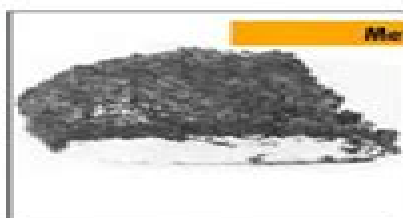
Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Swells

Nature of Defect
Swells are caused by the sand, which is due to the sand.

Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Metal Penetration

Nature of Defect
Metal penetration occurs in the sand, which is due to the sand.

Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.



Blow Holes at Angles

Nature of Defect
Blow holes at angles are caused by the sand, which is due to the sand.

Remedies
Defect occurs with the sand having a wide variety of sand grains, with the sand being washed away from the casting, causing the casting to be incomplete. Reduce the amount of the sand to low strength. Increase amount of new sand of covering part of the sand to low and maintain in high.

Manual Of Casting Defects

Wolfgang Guggemos



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