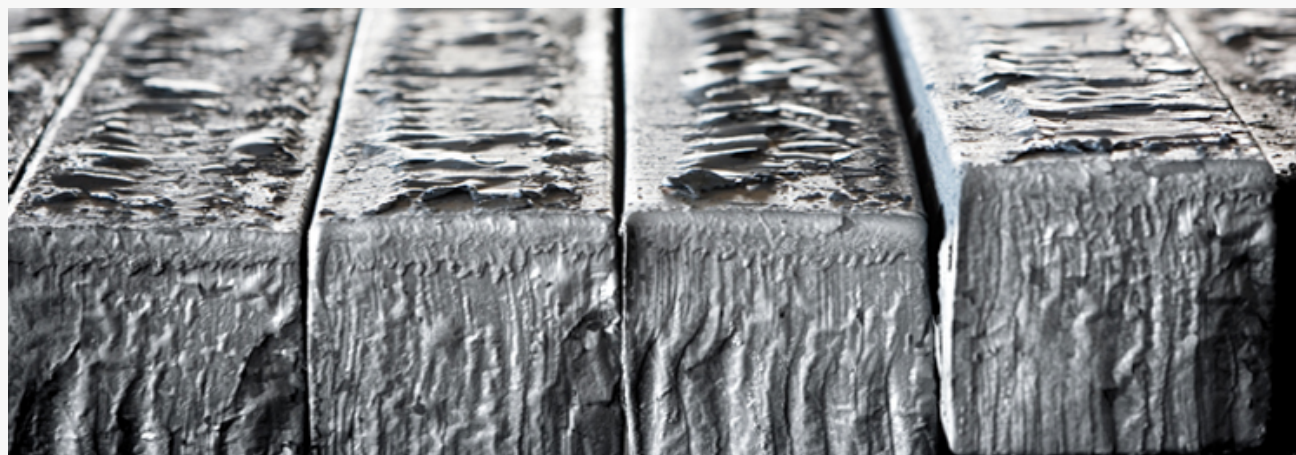


Steel Billets

Although some of the billets produced at Qatar Steel are sold directly to customers, most are processed into bars in our rolling mills. We supply high quality steel billets of various cross-sections and sizes, which enable us to meet the customer requirements and industry specifications.

Permissible variations from specified ranges and maketings are tabulated.



Steel Billet Specification

Chemical Composition

(As per below or as per
customer requirement)

Chemistry	%C	%Si	%Mn	%P	%S	N(ppm)
	0.15~0.25	0.12~0.20	0.60~0.80	0.035max	0.035max	120 max

Note: Tramp

Elements (Ni + Cr + Cu + Mo) = 0.30% max

Physical Parameters

Sr. No.	Item	Acceptance Criteria
1.	LENGTH	3.8 meter to 12 meter ($\pm 50\text{mm}$) for $150 \times 150\text{mm}^2$ section)
		6.0 meter to 12 meter ($\pm 50\text{mm}$) for $130 \times 130 \text{ mm}^2$ section)
2.	SECTION	$150 \times 150\text{mm}^2$ or $130 \times 130\text{mm}^2$
3.	FACE LENGHT	$\pm 3\text{mm}$
4.	RHOMBODITY	5% Max
5.	CORNER RADIUS	8mm
6.	STRAIGHTNESS	Camber 5mm/meter
7.	BENDING	Not more than 5mm in 1 meter
		Not more than 30mm in 6 meter
		Not more than 60mm in 12 meter

8.	ANGULAR TWIST	Not more than 1° / meter and Not more than 6° over 12 meter length.
9.	CUTTING	Both ends will be Gas Cut
10.	IDENTIFICATION	At the end of each billet cast number will be stamped or written by paint
11.	PIPE	No Existence
11.	SURFACE &	The billets will be free from surface imperfections which impair the product quality such as longitudinal cracks, transverse cracks, Deep ripple mark, scab & thick scale, slag patches, surface blow holes & Internal quality should be free from harmful defects such as subsurface pinholes, blow hole, pipes, voids, and internal crack. As Qatar Steel have open casting process, chances of minor surface pinholes is there and it will not impair the product quality.
	INTERNAL QUALITY	

Note: % Rhomboidity = $[(D_{Max} - D_{Min}) /$

$D_{Max}] * 100$