

HP STEEL GRADES

MANUFACTURING SPECIFICATIONS	257	381	460	521	680
Appearance	Bright & Clear	Bright & Clear	Bright & Clear	Bright & Clear	Bright & Clear
Acidity, Inorganic,mg KOH/g, max	Nil	Nil	Nil	Nil	Nil
Acidity, total, mg KOH/g, max	0.25	0.25	0.25	0.25	0.25
Carbion Residue, Conradson, % wt, max	0.2	0.35	0.55	0.55	0.55
Colour, ASTM, max	4.5	4.5	4.5	4.5	4.5
Corrosion, Cu Strip, @ 100°C, 3 hrs,max	1	1	1	1	1
Density at 29.5°C	0.899	0.902	0.904	0.904	0.906
Emulsion characteristics, @ 82°C, 20 mins	40-37-3	40-37-3	40-37-3	40-37-3	40-37-3
Emulsion characteristics, water,ml min	36	36	36	36	36
Flash point, COC, °C, min	226	250	270	270	270
Foaming characteristics Tendency/Stability, ml					
Sequence I	30/Nil	30/Nil	30/Nil	30/Nil	30/Nil
Sequence II	0/Nil	0/Nil	0/Nil	0/Nil	0/Nil
Sequence III	30/Nil	30/Nil	30/Nil	30/Nil	30/Nil
FZG Rig Test, FLS, min	5	6	6	6	6
Pour Point, °C, max	-6	-6	-6	-6	0
Rust Test, 24 hrs, Distilled water	Pass	Pass	Pass	Pass	Pass
Rust Test, 24 hrs,Synthetic sea water	Pass	Pass	Pass	Pass	Pass
Viscosity at 40°C, Kinematic, cSt	245-270	370-400	440-485	500-550	645-715
Viscosity at 100°C, Kinematic, cSt	20.8	25.8	30.4	31.7	39.1
Viscosity Index, min	95	95	95	95	95
Four Ball Weld Load, kgs, max	200	200	200	200	200
MEETS IPSS : 1-09-001-81					