

LIST OF PDA REGULARLY USED STEEL FOUNDRIES WITH DETAILS

CODE NO	NUMBER OF EMPLOYEES	CAPACITY GRADE/TONS/YEAR			TYPICAL CASTINGS			PRODUCTION EQUIPMENT				QUALITY CHECKING		OTHER ACTIVITIES			
		Cast Iron	SG Iron	Steel	Weight	Dimensions	Purpose	Melting	Moulding	Core boxes	Fettling	Metal	Mixture	Patterns	Machining	H Treatment	Coating
	total	tons	tons	tons	kg	mm	specialized	furnaces	method	equipment	equipment	tests	tests	types	types	equipment	method
WX1	23	N/A	N/A	110	0.005-12	300/300/300	precision castingS	induction crucible furnaces, -160 kg, 2 pcs	precision casting with investment patterns	wax method	machine, sand blast type	metallographic analysis, mechanical testing	N/A	manufacturing of dies for precision castings	N/A	N/A	N/A
SH2	30	300	50	500	0.1-40	30-350	fittings production	induction crucible furnaces, type IMSK, 3 pcs	mechanized, type of the machines - Kröning	processing techniques - Hot box	machine, type OWT 1000; OWT 400	metallographic analysis, mechanical testing, flaw detection	compressive strength, tensile strength, gas permeability	metal patterns	multipurpose machines and special purpose machines	furnaces, 3 pcs., tunnel type, maximum temperature 1050° C	manual
ST3	80	410	90	115	0.200-800	130-1200	glass industry, cement industry, machine building	induction crucible furnaces, type PI 600, 3pcs; type PI 250, 2 pcs	manual, moulding boxes clearance from 400x300 mm up to 1500x1400 mm; mechanized, type of the machines - Foromat 20, moulding boxes clearances 500x400 mm	processing techniques - manual; machines for core boxes made of plates sands	machine, type shot blast OWD 100, 2 pcs; shot blast drum - 1 pc	chemical analysis, metallographic analysis, mechanical testing, flaw detection	moisture, compressive strength, tensile strength, gas permeability	wooden patterns, metal patterns, plastic patterns	multipurpose machines and special purpose machines	furnaces, 5 pcs., type PEK 45; PEK 125, maximum temperature 1100 degr. centigrade	manual
ST4	22	640	N/A	110	0.9-960	40-1200	cellulose-paper industry, mining industry, agriculture, machine building, food industry	induction crucible furnaces type: PI1600 - 1pc; PI600 - 1pc; PI160 - 1pc	manual, moulding boxes clearance: 400/600mm; 600/1200mm; 800/1600mm mechanized	processing techniques - manual, on water glass base	machine, type DOZAMET-OML - 1000A - 1pc; type DOZAMET-OWT-400A-1pc; fettling drums Ø 800 - 2pcs	chemical analysis, mechanical testing	moisture, compressive strength, tensile strength, gas permeability	wooden patterns, metal patterns, plastic patterns	multipurpose machines and special purpose machines	ovens - 4 pcs, type PEK-30, PEK-45, PEK-60, SDO-125, maximum temperature 950 degr. centigrade	manual
ST5	180	750	670	2250	5-8000	4000 x 2500 x 1000	energetics, presses, cut-off valves, oven-making industry, crane-making industry, castings for home appliances, general machine building	induction crucible furnaces, type IP 1600 - 2pcs; electric arc ovens /5MT capacity/- 2 pcs	manual, moulding boxes clearance: 4000x4000mm; mechanized - machines type AMDR8; Foromat 40; moulding boxes clearances 1600x1250x300/300mm; 1000x800x250/250mm; 1500x500x240/240mm	processing techniques: manual and mechanical, machines type KS50; KS25; KS125	machines, shot blast type: RT 1800 drum - 2 pcs; VK3 - chamber - 2pcs	chemical analysis, metallographic analysis, mechanical testing, flaw detection	moisture, compressive strength, tensile strength, gas permeability	wooden patterns, metal patterns, plastic patterns	multipurpose machines	ovens - 4 pcs, liquid fuel chamber type and electric heating chamber type; max. temperature - from 900 up to 1050 degr. centigrade	manual
ST6	150	N/A	N/A	25,000	1000-40,000	1200-10,000	ship building, mining, metallurgy, energetics	electric arc furnaces - 60 MT; 25 MT; VAD - installation	manual, moulding boxes clearance 5500x5000 mm; caisson moulding; mechanized, moulding boxes clearances from 1000x1500 mm up to 2500x3000 mm	processing techniques: manual; machines, core boxes production lines	machine - shot blast type	chemical analysis, metallographic analysis, mechanical testing, flaw detection	moisture, compressive strength, tensile strength, gas permeability	wooden patterns	multipurpose machines and special purpose machines	furnaces - 10 pcs, natural gas type, maximum temperature 1200 °C	manual