

FOSECO, INC.

INTER-COMPANY AND INTER-DEPARTMENTAL CORRESPONDENCE

TO: See Distribution

FROM:  G. H. Fitzgerald - Quality Control

DATE: February 28, 1974

SUBJECT: Visit to J&L Aliquippa -
Wednesday, 2/27/74

Purpose:

- (1) Observe setting and pouring of 27 x 34 ingots using asbestos-free Seal-On rings #684 (XS-1580A) - compressibility $3\frac{1}{2}$ to $6\frac{1}{2}$.
- (2) Observe setting and pouring of 27 x 34 ingots using hard Seal-On rings #684 (EP 4651B contaminated) with XS 1580A - compressibility $4\frac{1}{2}$ to $7\frac{1}{2}$.
- (3) Review status of quality of products with mill personnel.

Persons Met: In the company of W. C. Fletcher, G. Soloway and J. Wilton, this writer met with: N. Shayka (Gen. Foreman, Moldyard) and W. Stevens (Met. Dept.)

- (1) Set one-half of drag (12 ingots) with asbestos-free rings and one-half with hard 4651B rings. One asbestos-free was intentionally cracked during setting and the ring still performed satisfactorily. Rings handle well, no damage observed when set by mill personnel. Boards fit casting well except for height of boards. Boards are not extending the desired $1/8$ above casting surface. Some castings were observed to have lost their board seating ledge, causing a poor fit between the gasket and the board.

Internal casting surfaces seem to be clean and relatively free of carbonized debris or steel splashes.

Flashing on rings from overforming seems to be sanded off adequately by Manufacturing. There seems to be no margin for reducing this handwork during packing.

Some evidence of excessive board sanding on bevel edges during the shipping was observed.

- (2) At B.O.F. observed the pouring of heat using the above rings. One leaker was noted on an ingot using the hard 4651B material. The leaker was attributed to a cracked mold and not due to Seal-On system. The 275-ton leaded heat was poured in 28 minutes using Universal 604 topping compound.
- (3) Visited KORON spraying station and reviewed current program with J. Sambles. WCF recommended to GS to discuss with N. Shayka spraying buggy couplings with KORON as parting agent to ease the removal of steel splashes.



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Conclusions:

- (1) The asbestos-free ring material (XS 1580B) performed very satisfactorily. Mill conditions at this account are extremely advantageous and it is still this writer's personal opinion that the XS 1580A recipe must be made more compressible in order to be useable in all applications.
- (2) Mill personnel are very well satisfied with the performance of this Seal-On system and the quality of products received.
- (3) During the next tool repair or modification, the board height should be increased by 1/8 inch.
- (4) Packaging should review the Packing Specification with GHF to see whether any improvements can be made to reduce in transit sanding.
- (5) WCF will return a sample of Universal 604 topping compound for evaluation by Technical Department. This compound is reportedly better than our FERRUX 107.

GHF:mlr

Distribution:

P. A. Partington, W. C. Fletcher, M. S. Wood/J. C. Mohr, S. J. Cinke/R. T. Callat
G. Fenton, J. R. Bailey/Quality Control, N. D. Wilcox, K. Kunz/G. Soloway/J. Wilt
A. Santighian