

# **BILLETS – CAST OR ROLLED (AT MILL’S OPTION)**

## **CONTINUOUS CASTING STANDARD SIZE CONFIGURATIONS**

<b>120 x 120 mm</b>
<b>130 x 130 mm</b>
<b>140 x 140 mm</b>

## **TOLERANCES FOR CAST BILLETS**

<b>Billet size (mm)</b>	<b>120</b>	<b>130</b>	<b>140</b>
<b>Difference across flats</b>	+/-4 mm	+/-4 mm	+/-4 mm
<b>Corner Radius</b>	6 mm	6 mm	10 mm
<b>Rhomboidity maximum</b>	9 mm	10 mm	10 mm
<b>Minimum Length</b>	5 m	5 m	5 m
<b>Maximum Length</b>	12 m	12 m	12 m

**Straightness:** Deviation from a tangential straight line within one metre of ends not to exceed 20 mm. At any other point not to exceed 10 mm per metre along the billet length. A maximum deviation of 100 mm over the full length of the billet, irrespective of the ordered length, is allowed.

**Length:** +/- 100 mm.

**Shorts:** Up to 4% of the tonnage ordered down to 3 metres.

**Twist:** 1° per metre max.

**End Cut:** Sheared or flame cut at Mills option.

## **OTHER DETAILS**

**Quantity:** 5 000 tons minimum per size (+/-5%) rolled or cast at Highveld’s option.

**Invoicing:** Based on “Actual” weighbridge weight per truck load.

**Test Certs.:** Sold to Analysis only.

**Marking:** Cast (heat number) will be stamped on each billet at one end only.  
Billets will be colour coded for shipment identification at one end only

**Bundling/Packing:** Wired or strapped at Mills option in bundles with the following typical Configurations, e.g. 120 mm square x 6 metre lengths - 3 x 2 = 4 tons.  
Normal bundle weight is 5 tons maximum but heavier bundles could be supplied if requested, depending on size and length.

**Note:** When a query arises on the chemical composition of products rolled from Highveld billet, the details as specified in JIS G 0321 Table 1 will govern.