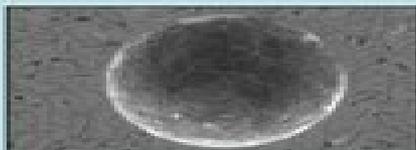


## Hydrogen Blowhole



**Possible causes:**  
 High moisture content in charge or alloy materials  
 Inadequate degassing  
 High content of aluminium or silicon  
 High level of sulphur in moulding sand  
 High level of oil in ladle  
 Wet mould or core casting  
 Poor or worn ladle refractory and/or furnace refractory materials

## Nitrogen Fissure



**Possible causes:**  
 Use of high steel scrap content in melts melted over  
 excessive nitrogen  
 Use of materials with high nitrogen content  
 Use of high nitrogen ladle refractory  
 Use of high nitrogen ladle refractory  
 Use of high nitrogen ladle refractory

## Compaction of Graphite Flakes



**Possible causes:**  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
**Possible cures:**  
 Reduce all nitrogen content in materials melted from  
 with high carbon charges  
 Use of materials with high nitrogen content  
 Use of materials with low nitrogen content  
 Use of materials with low nitrogen content  
 Use of materials with low nitrogen content

## Shrinkage



**Possible causes:**  
 High moisture in hot properly coated sand  
 Excessive sand compaction or overpacking  
 Poor sand resulting from unevenly distributed pattern and  
 hot spots resulting from unevenly distributed pattern and  
 hot spots resulting from unevenly distributed pattern and  
 hot spots resulting from unevenly distributed pattern and

## Slag Entrapment



**Possible causes:**  
 Inadequate slag removal during melting and pouring  
 Inadequate slag removal during melting and pouring  
 Lack of slag traps or filters  
 Use of wet sand and/or wet ladle refractory  
 Excessive oxidation of alloy forming inclusions  
 Excessive iron oxidation

## Carbon Monoxide Blowhole



**Possible causes:**  
 High sulphur in composition with high temperature content  
 High sulphur in composition with high temperature content  
 High sulphur in composition with high temperature content  
 High sulphur in composition with high temperature content

## Intercellular Carbide



**Possible causes:**  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures

## Steadite



**Possible causes:**  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures

## Undercooled Graphite



**Possible causes:**  
 High moisture content  
 High moisture content  
 High moisture content  
 High moisture content

## C Type Graphite



**Possible causes:**  
 High moisture content  
 High moisture content  
 High moisture content  
 High moisture content

## Widmanstätten Graphite



**Possible causes:**  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures

## Ferritic Rim



**Possible causes:**  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures  
 Excessive furnace treatment by heavy oxidation, often in combination with nitrogen fissures

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