FILLET SCAB

Sand Casting

Metallic projection having the form of a thin blade of irregular contour located at reentrant angles along edges or in the vicinity of corners, at a distance of about 2 to 5 millimeters from the mold surface and parallel to it. Whenever it is located on the drag surface of a casting it is always accompanied by ratham (defect D 132).

Possible causes
Formation of an unbroken scale of the base sand due to an irregularity in the expansion of the silica. See also “Scabs” (defect D 230). This defect is less frequent with dried sand and, in this case, it can arise from insufficient baking or reabsorption of moisture where there is a long delay between baking and pouring of the mold.

Remedy
See defect D 230 (Scab).

Formation of a fillet scab.

In a reentrant angle.

Adjacent to a corner.
A 114 - Cast Iron, Green Sand
Test castings showing a corner (fillet) scab.

A 114 - Aluminum, Dried Sand
Aluminum alloy cylinder head cover.
Formation of a fillet scab due to cracking of the mold during baking.