Ductile iron and nonferrous alloys.

Non-metallic inclusions in the form of skins which cause localized discontinuities in the casting. The color corresponds to the type of oxide which comprises the inclusions.

Possible Cause
Formation of oxide skins during the filling of the ladle or pouring the mold. These skins remain trapped in the liquid metal because of the effects of metal turbulence.

Remedies
— Avoid oxidation of the stream of metal.
— Pour with as little pressure as possible, using bottom-gating.
— Use flat, extended runners and gates.
— For nonferrous alloys, pour without turbulence (tilt-pour if possible).
— In the case of ductile iron, keep the magnesium content of the iron as low as possible.
— In general, observe the same precautions as for defect G 121 (slag or dross inclusions).