Surface Folds, Gas Runs

D 111 - Steel, Dry Sand

Caswell gave the following: "Surface folds resulting from use of a mold with too much gas during pouring."

Figure 133

Irregular fold marks distributed across a surface of the casting. For cast steel, the defect most often occurs on thin, horizontal surfaces.

Possible Causes

- High viscosity of the liquid metal.
- Low pouring temperature and slow pouring.
- Gates formed by reaction between the metal and the mold wall.
- Formation of (oxide) skin during pouring.
- For permanent moldings, mold too cold.

Figure 134

Cross-beam support cast in steel (cement, mold, oil-sand core). Folds are caused by gases released from the pouring coin and from use of a low pouring temperature. Elsewhere on the casting may be seen defects C 311 - cold shot."

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