A 112

VEINING OR FINNING

Projections in the form of veins which are generally perpendicular to the casting surface, occurring either singly or in networks. Not situated along parting lines. In green sand molding, they often appear at fillets in conjunction with defect D 230 (seabs) or A 211 (swells).

Possible Causes

— Mold surface cracks occurring during drying when there is excessive shrinkage tendency of the sand due to:
  • too rapid heating,
  • too high a baking temperature, or
  • too much sand binder or moisture.
— Surface cracking occurring at the time of pouring in a sand which is too dense or too high in silica: initiation of formation of seabs - see defect D 230.
— Mold fissures accompanying swells (defect A 211).

Remedies

Depending upon the assumed cause:

— Regulate sand composition and baking: seal mold cracks.
— Note measures for avoiding seabs (defect D 230).
— Increase mold rigidity: reduce metallocratic pressure.

See bibliography for A 112 and D 230.