

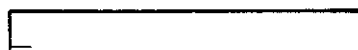
Table 1 Chemical composition of 13Cr-3.5Ni cast steel used (%)

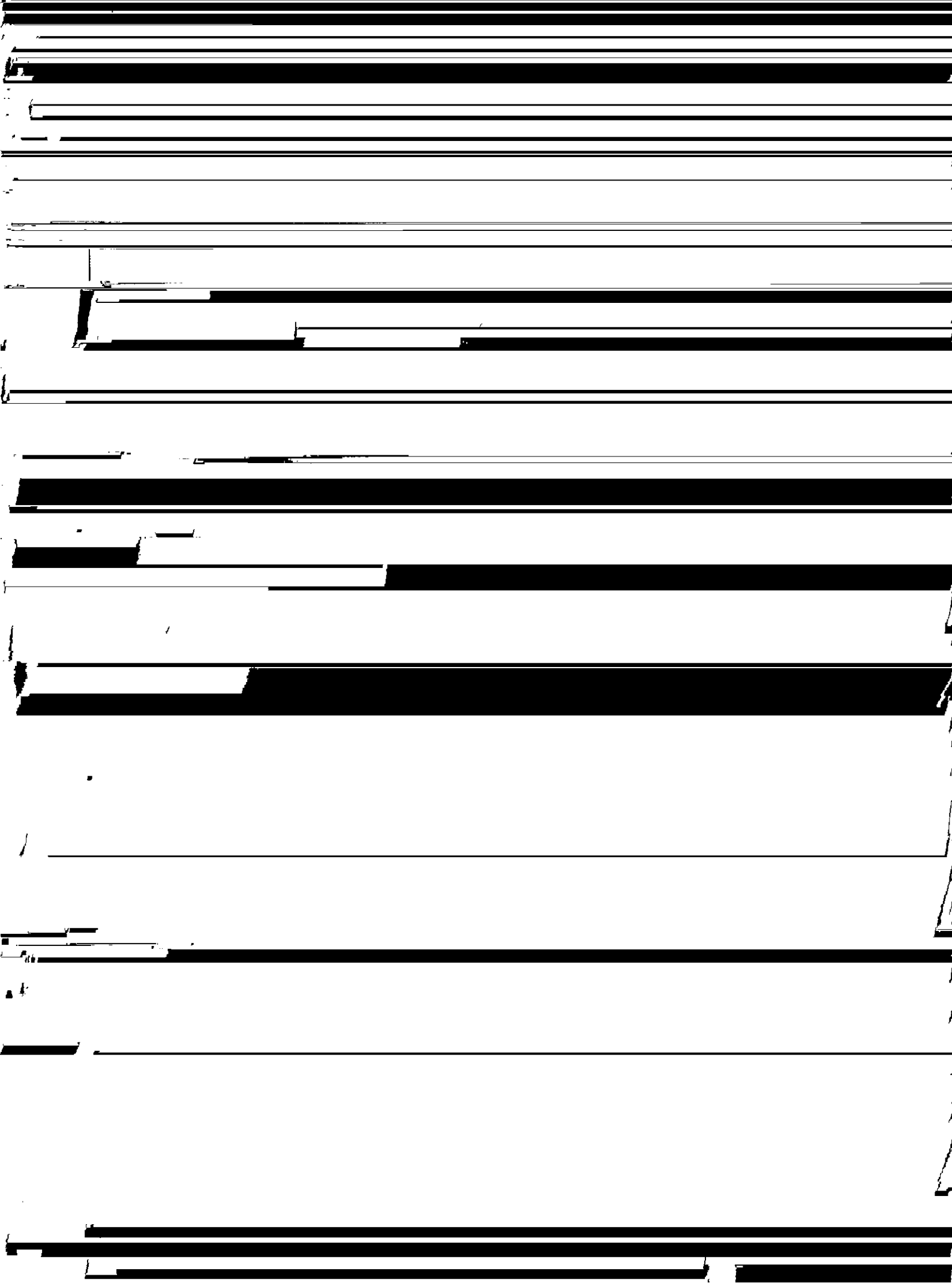
	C	Si	Mn	P	S	Ni	Cr	Mo
ASTM CA- 6NM*	≤0.06	≤1.00	≤1.00	≤0.040	≤0.030	3.5~ 4.5	11.5~ 14.0	0.40~ 1.0
13Cr-	0.04~	0.35~	0.65~	<0.020	<0.010	3.60~	11.70~	0.20~



Tempering temp. at the holding time of 2 h (°C)

25





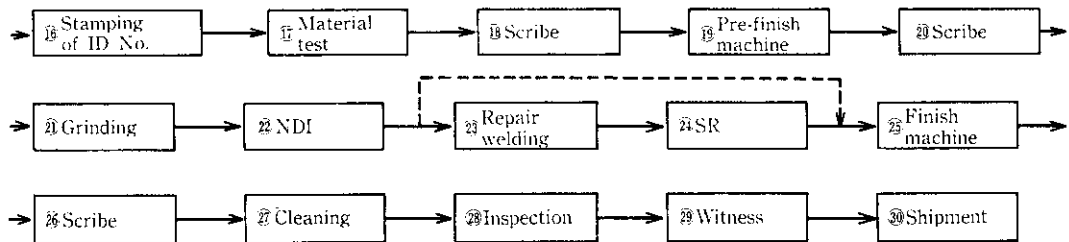
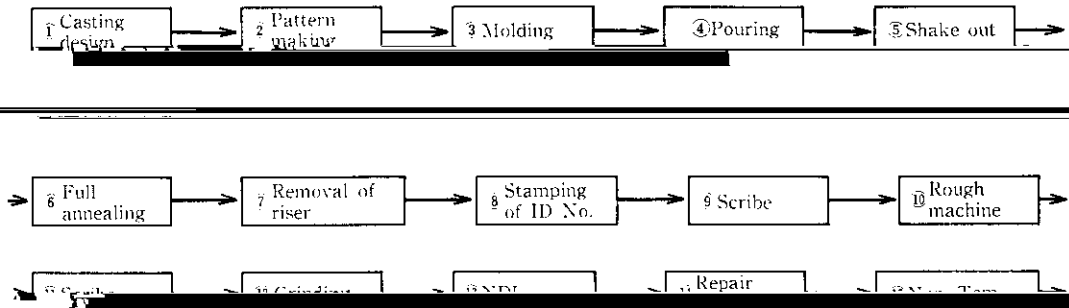


Fig. 14 Manufacturing flow chart of Francis runner

