

TUNNELLING DEEP TO  
REACH NEW HEIGHTS.



**NMDC  
STEEL  
LIMITED**



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PRODUCT CATALOGUE

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# NMDC STEEL LTD., NAGARNAR

NMDC Steel Limited was formed under Ministry of Steel for setting up a 3 MTPA capacity greenfield Integrated Steel Plant based on Hi-Smelt technology in Nagarnar, located 16 km from Jagdalpur, Chhattisgarh.

It is strategically located near NMDC's Bailadila mines consisting of high-grade iron ores. It is connected to Visakhapatnam seaport via rail & road and is around 300 km away from the capital of Chhattisgarh state, Raipur. Special care and focus have been maintained for making sure that every possible unit of energy could be saved by utilizing energy-efficient technologies such as Pulverized Coal Injection, Coke Dry Quenching, and Top Recovery Turbine. Recycling blast furnace slag, waste heat recovery options, effective alternate fuel resources are other such options that are being implemented in the plant.

The plant is envisaged with techno-economic parameters comparable to global benchmark and consideration for environment protection by adopting a zero discharge system. The plant is highly efficient from energy consumption, process, and operations point of view.



# NAGARNAR WORKS

## SALIENT FEATURES OF THE INTEGRATED STEEL PLANT :

- Capacity (Liquid Steel) : 3 MTPA
- Capacity (HR Coils/Sheets/Plates) : 2.89 MTPA
- Coke Oven and CDCP : 7m Tall Batteries, 2 Nos.
- Sinter Plant : 460 m<sup>2</sup> , 1 No.
- Blast Furnace : 4500 m<sup>3</sup> with capacity 3.3 MT per annum
- Pig Casting Machine : 1700 tpd, 3 machines
- Steel Melting Shop : 2 x 175 T BOF Converters
- Thin Slab Caster : 2 Strand CC & HSM
- HSM : 2RM + 4FM + 2 Down Colfer, 2,9 MT capacity
- Other Units : By Product Plant, RHMS

Other Units : By Product Plant, RHMS



# PLANT CAPABILITIES

## BLAST FURNACE :

- One of the Largest Blast Furnace in India with 4500 m<sup>3</sup> volume.
- Top pressure recovery turbine of the BF to generate about 15 MW of power, utilizing the high pressure of the process gasses coming out of the furnace.
- Pulverized coal injections of 150 kg/tonne of hot metal average & 200 kg/tonne of hot metal maximum.
- Blast furnace is designed to take pellets up to 40%.

## THIN SLAB CASTER :

### BLAST FURNACE :

- Continuous Thin Slab Caster of 50-90 mm thickness with continuous hot rolling to produce coils of 1 to 16 mm thickness, which could substitute cold rolled coils of the same thickness range and could be used directly for hot galvanizing.
- Continuous nature of hot rolled casting to coil stage saves energy up to 40% in comparison to conventional slab casting & hot strip mill.



# PRODUCTION CAPABILITIES

## I. PRODUCTION :

SI. NO	DESCRIPTION	Quantity, t/yr.
1	Annual production of liquid steel	3,000,000
2	Liquid steel for casting through - Thin slab caster	3,000,000
3	Annual coil Production	2,900,000



## PRODUCT MIX

ITEMS	SIZE (Thickness x Width) (mm x mm)	Annual Production (tonnes)
<b>HR COILS</b>		
Boiler low/moderate temperature pressure vessels/quality plates (IS : 2002:1992, reaffirmed 2007, ASTM- A285 & IS : 2041:1995, reaffirmed 2000)	3.0- 16 x 1000-1650	3,00,000
HR Coils/sheets/plates up to 550 MPa yield strength (IS 2062, IS 5986, IS 3039, IS 3196, IS 8500)	1.0- 16 x 1000-1650	5,00,000
API- 5L quality pipes up to X-80 ( X-80 is for a limited thickness & width)	6.0- 16x1650	5,00,000
LPG Cylinders (IS: 6240:1999 reaffirmed 2004, G3116)	2.0- 3.15x 900-1450	3,00,000
<b>HR Coils for Cold Rolling and Commercial</b>		
Purposes Commercial (IS: 10748:2004, BS-1449, ASTM-A569)	1.0- 6.0x 1000-1650	1,50,000
Draw Quality (D) DD & EDD Quality (IS: 1079:1994, reaffirmed 1998)	1.0-4.8x 900-1650	9,20,000
	<b>SUB TOTAL</b>	<b>2,67,000</b>
HR Coils- Auto Grades E34/E38/BSK46/ Fe 410, E55, Dual Phase, IF, TRIP, Silicon Steel (IS: 3024:2006, DIN: 46400-part1,part2, part3)	1.6- 5.0x 1000-1650	2,30,000
	<b>SUB TOTAL</b>	<b>2,900,000</b>

# PRODUCT SIZES & SPECIFICATIONS

## 1. HR COILS :

THICKNESS	1.0–16 mm
WIDTH	900–1650 mm
COIL ID	762 mm
COIL OD	2100 mm
COIL WEIGHT	35t (max)

## 2. HR SHEETS/ PLATES :

Production capacity of 4,00,000 t/yr. of HR Sheets/Plates in thickness range 1.8 to 12 mm and width from 900 to 1650 mm.

THICKNESS	1.8–12 mm
WIDTH	900-1650 mm
LENGTH	2000-12000 mm
PACK WEIGHT	10t (max)
PACK HEIGHT	500 mm
PILE WEIGHT	20t (max)
PILE HEIGHT	1200 mm (max)

## Grade wise size mix of Hot Rolled Coils produced at NSL

QUALITY/GRADE	THICKNESS(mm)		WIDTH(mm)	
	Min.	Max.	Min.	Max.
IS 2002 1/2/3	3.0	16	1000	1650
ASTM-A285 A/B/C	3.0	16	1000	1650
IS 2041 R220/260/275/355	3.0	16	1000	1650
IS 2041 H235/265/295/355	3.0	16	1000	1650
IS 2062 A/B/C	1.0	16	1000	1650
IS 5986 Fe330/360/410/510	1.0	16	1000	1650
IS 3039 1/2/3	1.0	16	1000	1650
IS 8500 Fe 540B/570/570B/590/590B	1.0	16	1000	1650
API 5L Gr BM/X 42M/X 46M/ X 52M/X 56M/X 60M/X 65M/X70M /X80M	6.0	16	1650	1650
IS 10748 1/2/3/4/5	1.0	6.0	1000	1650
BS 1449 4/10/12/17/20/22/30/40/50/60/70/80/95	1.0	6.0	1000	1650
ASTM-A569	1.0	6.0	1000	1650
IS 1079 O/D/DD/EDD	1.0	4.8	900	1650
IS 6240	2.0	3.15	900	1450
JIS 3116 SG255/ SG295/SG325/ SG365	2.0	3.15	900	1450
EN 10149 E34/ E38/ BSK 46	1.6	5.0	1000	1650
ASTM A572 E55 CLASS 1/2	1.6	5.0	1000	1650
EN 10338 HDF450F/HDF560F/ HDT580X/HDT750C/ HDT780C/ HDT950C/ HDT1200M	1.0	5.0	1000	1650
IS 3024 23CG110/23CG120/ 23CG127	1.0	5.0	1000	1650
IS 3024 27CG120/27CG130/27CG140	1.0	5.0	1000	1650
IS 3024 30CG130/30CG140/30CG150	1.0	5.0	1000	1650
IS 3024 35CG145/35CG155/35CG165	1.0	5.0	1000	1650

# PRODUCT TOLERANCE

## THICKNESS TOLERANCE :

SI NO.	TOLERANCE (mm)	TOLERANCE
1	1.0 < t < 2.00	(+)-25 $\mu$ m on 90 % of strip length (+ -30 ) $\mu$ m on 95.4 % of strip length
2	2.00 < t < 4.0	(+ -)34 $\mu$ m on 95.4 % of
3	> 4.0	(+)-0.80 % * T limited to 60 $\mu$ m on 95.4 % of strip

## WIDTH TOLERANCE :

SI NO.	TOLERANCE PARAMETER	TOLERANCE (2 $\sigma$ = 95.4 % of strip length)
1	WIDTH	-0, +8 mm

## PROFILE TOLERANCE :

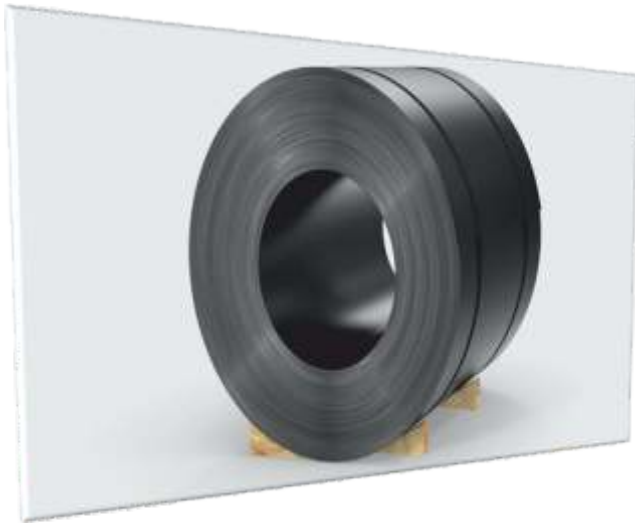
SI NO.	THICKNESS (mm)	TOLERANCE (C40 Value) (2 $\sigma$ = 95.4 % of strip length)
1	< =2.00	(+)-18 $\mu$ m
2	2.00 < t <= 5.00	(+ -)25 $\mu$ m
3	> 5.00	(+ -)40 $\mu$ m

## FLATNESS TOLERANCE :

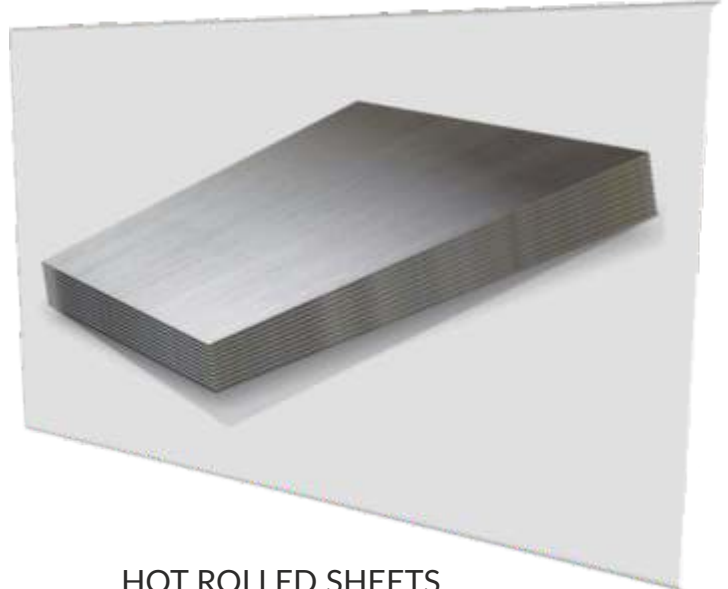
SI NO.	THICKNESS (mm)	WIDTH (mm)	TOLERANCE (C40 Value) (2 $\sigma$ = 95.4 % of strip length)
1	< =2.00	< 1200 > 1200	32 I-Units 37 I-Units
2	2.00 < t <= 5.00	<1200 >1200	30 I-Units 35 I-Units
3	> 5.00		25 I-Units



# PRODUCT GRADES



HOT ROLLED COILS



HOT ROLLED SHEETS

## BOILER MODERATE TEMPERATURE PRESSURE VESSELS/QUALITY PLATES

STANDARD SPECIFICATION		CHEMICAL COMPOSITION							MECHANICAL PROPERTIES			APPLICATIONS
Specification	Grade	C % Max	Mn % Max	Si % Max	S% Max	P% Max	Al%	N % Max	Yield Strength (Mpa) Min	Tensile Strength (Mpa) Min	%El (Min)	
IS 2002	1	0.18	0.5-1.2	0.15-0.35	0.040	0.035			235	360-480	24	BOILER
IS 2002	2	0.20	0.5-1.2	0.15-0.35	0.040	0.035			265	410-510	22	
IS 2002	3	0.22	0.5-1.2	0.15-0.35	0.040	0.035			290	460-560	21	
ASTM- A285	A	0.17	0.90		0.035	0.035			165	310-450	30	PRESSURE VESSELS
ASTM- A285	B	0.22	0.90		0.035	0.035			185	345-485	28	
ASTM- A285	C	0.28	0.90		0.035	0.035			205	380-515	27	
IS 2041	R220	0.21	0.60-1.50	0.15-0.35	0.035	0.035	0.020	0.0	220	415-540	21	STEEL PLATES FOR PRESSURE VESSELS
IS 2041	R260	0.25	0.85-1.50	0.15-0.35	0.035	0.035	0.020	0.01	260	490-620	21	
IS 2041	R275	0.16	0.80-1.50	0.40	0.015	0.025	0.020	0.0	235-275	390-510	23	
IS 2041	R355	0.18	1.10-1.70	0.50	0.015	0.025	0.020	0.01	315-355	490-640	21	
IS 2041	H235	0.16	0.60-1.20	0.35	0.015	0.025	0.020	0.0	200-235	360-480	24	
IS 2041	H265	0.20	0.80-1.40	0.40	0.015	0.025	0.020	0.01	215-265	410-530	22	
IS 2041	H295	0.20	0.90-1.50	0.40	0.015	0.025	0.020	0.0	260-295	460-580	21	
IS 2041	H355	0.22	1.10-1.70	0.60	0.015	0.025	0.020	0.01	315-355	510-650	20	

## HR COILS/SHEETS/PLATES UPTO 550 MPa YEILD STRENGTH

STANDARD SPECIFICATION		CHEMICAL COMPOSITION							MECHANICAL PROPERTIES			APPLICATIONS
Specification	Grade	C % Max	Mn % Max	Si % Max	S% Max	P% Max	Al%	N % Max	Yield Strength (Mpa) Min	Tensile Strength (Mpa) Min	%El (Min)	
IS 2062	A	0.23	1.6	0.40	0.050	0.050		0.012	250	410	23	HIGH TENSILE STRUCTURES
IS 2062	B	0.22	1.5	0.40	0.045	0.045		0.012	250	410	23	
IS 2062	C	0.20	1.5	0.40	0.040	0.040		0.012	250	410	23	
IS 5986	Fe 330	0.17	1.0		0.045	0.045		205	330-440	181/252		STRUCTURAL FORMING & FLANGING
IS 5986	Fe 360	0.17	1.2		0.045	0.045			235	360-470	181/252	
IS 5986	Fe 410	0.20	1.3		0.045	0.045			255	410-520	171/232	
IS 5986	Fe 510	0.20	1.5		0.045	0.045			355	510-620	161/202	
IS 3039	1	0.23			0.040	0.040	0.01		400-490	220-230	22	SHIP BUILDING
IS 3039	2	0.21	0.70-1.40	0.10-0.35	0.040	0.040			400-490	235	22	
IS 3039	3	0.18	0.70-1.50	0.19-0.50	0.040	0.040	0.015		400-490	235	22	
IS 8500	Fe 540B	0.20	1.6	0.45	0.04	0.04			410	540	20	HIGH STRENGTH PLATES
IS 8500	Fe 570	0.22	1.6	0.45	0.04	0.04			450	570	20	
IS 8500	Fe 570B	0.22	1.6	0.45	0.04	0.04			450	570	20	
IS 8500	Fe 590	0.22	1.8	0.45	0.04	0.04			450	590	20	
IS 8500	Fe 590B	0.22	1.8	0.45	0.04	0.04			450	590	20	

## API-5L QUALITY PIPES UPTO X-80

STANDARD SPECIFICATION		CHEMICAL COMPOSITION							MECHANICAL PROPERTIES			APPLICATIONS
Specification	Grade	C % Max	Mn % Max	Si % Max	S% Max	P% Max	Al%	N % Max	Yield Strength (Mpa) Min	Tensile Strength (Mpa) Min	%El (Min)	
API 5L	Gr BM	0.22	1.2	0.45	0.015	0.025			245-450	415-655		LINE PIPES FOR OIL & GAS
API 5L	X 42M	0.22	1.3	0.45	0.015	0.025			290-495	415-655		
API 5L	X 46M	0.22	1.3	0.45	0.015	0.025			320-525	435-655		
API 5L	X 52M	0.22	1.4	0.45	0.015	0.025			360-530	460-760		
API 5L	X 56M	0.22	1.4	0.45	0.015	0.025			390-545	490-760		
API 5L	X 60M	0.12	1.6	0.45	0.015	0.025			415-565	520-760		
API 5L	X 65M	0.12	1.6	0.45	0.015	0.025			450-600	535-760		
API 5L	X 70M	0.12	1.7	0.45	0.015	0.025			485-635	570-760		
API 5L	X 80M	0.12	1.85	0.45	0.015	0.025			555-705	625-825		



## HOT ROLLED COILS FOR COMMERCIAL PURPOSES AND COLD ROLLING

STANDARD SPECIFICATION		CHEMICAL COMPOSITION							MECHANICAL PROPERTIES			APPLICATIONS
Specification	Grade	C % Max	Mn % Max	Si % Max	S% Max	P% Max	Al%	N % Max	Yield Strength (Mpa) Min	Tensile Strength (Mpa) Min	%El (Min)	
IS 10748	1	0.10	0.50			0.05	0.05		170	290		<b>COMMERCIAL QUALITY</b>
IS 10748	2	0.12	0.60			0.05	0.05		210	330		
IS 10748	3	0.16	1.20			0.05	0.05		240	410		
IS 10748	4	0.20	1.30			0.05	0.05		275	430		
IS 10748	5	0.25	1.30			0.05	0.05		310	490		
BS 1449	4					0.050	0.050		170	280	25	
BS 1449	10	0.08	0.60	0.10		0.045	0.045					
BS 1449	12	0.10	0.40			0.050	0.050		170	310	25	
BS 1449	17	0.15	0.40			0.050	0.050		200	350	25	
BS 1449	20	0.15	1.30	0.05		0.045	0.045		350	540	18	
BS 1449	22	0.20	0.40			0.050	0.050		230	400	24	
BS 1449	30	0.25	0.50	0.05		0.045	0.045		280	500	18	
BS 1449	40	0.35	0.50	0.05		0.045	0.045		300	540	16	
BS 1449	50	0.45	0.50	0.05		0.045	0.045					
BS 1449	60	0.55	0.50	0.05		0.045	0.045					
BS 1449	70	0.65	0.50	0.05		0.045	0.045					
BS 1449	80	0.75	0.50	0.05		0.045	0.045					
BS 1449	95	0.90	0.30	0.05		0.040	0.040					
ASTM-A569		0.15	0.60			0.040	0.035					

## HOT ROLLED COILS FOR COMMERCIAL PURPOSES AND COLD ROLLING

STANDARD SPECIFICATION		CHEMICAL COMPOSITION							MECHANICAL PROPERTIES			APPLICATIONS
Specification	Grade	C % Max	Mn % Max	Si % Max	S% Max	P% Max	Al%	N % Max	Yield Strength (Mpa) Min	Tensile Strength (Mpa) Min	%El (Min)	
IS 1079	0	0.15	0.60			0.055	0.055					<b>DRAW QUALITY</b>
IS 1079	D	0.12	0.50			0.040	0.040			28		
IS 1079	DD	0.10	0.45			0.035	0.035		260-390	32		
IS 1079	EDD	0.08	0.40			0.030	0.030		260-380	36		



## LPG GRADES

STANDARD SPECIFICATION		CHEMICAL COMPOSITION							MECHANICAL PROPERTIES			APPLICATIONS
Specification	Grade	C % Max	Mn % Max	Si % Max	S% Max	P% Max	Al%	N % Max	Yield Strength (Mpa) Min	Tensile Strength (Mpa) Min	%El (Min)	
IS 6240		0.16	0.30	0.25	0.030	0.030	0.02		240	350-450	25	LPG CYLINDERS
JIS 3116	SG255	0.20	0.30		0.040	0.040			255	400	26	
JIS 3116	SG295	0.20	1.00	0.35	0.040	0.040			295	400	26	
JIS 3116	SG325	0.20	1.50	0.55	0.040	0.040			325	490	22	
JIS 3116	SG365	0.20	1.50	0.55	0.040	0.040			365	540	20	

## AUTO GRADES

STANDARD SPECIFICATION		CHEMICAL COMPOSITION							MECHANICAL PROPERTIES			APPLICATIONS
Specification	Grade	C % Max	Mn % Max	Si % Max	S% Max	P% Max	Al%	N % Max	Yield Strength (Mpa) Min	Tensile Strength (Mpa) Min	%El (Min)	
EN 10149	E34	0.12	1.30	0.50	0.020	0.025	0.015 min		315	390	20-24	AUTO GRADE
EN 10149	E38	0.12	1.50	0.50	0.020	0.025	0.015 min		355	430	19-23	
EN 10149	BSK 46	0.12	1.00	0.10	0.025	0.025	0.02		460	500	21	
ASTM A572	E55 CLASS 1	0.25	1.50		0.040	0.040			380	480	18	
ASTM A572	E55 CLASS 2	0.15	1.50		0.040	0.040			380	450	20	
EN 10338	HDF450F	0.18	1.2	0.5	0.01	0.03	0.015			320-420	45023	
EN10338	HDF560F	0,18	1.8	0.5	0.01	0.025	0.015			460-570	56016	
EN10338	HDT580X	0.17	2.2	0.8	0.015	0.080	2.00 max		330-460	580	19	
EN10338	HDT750C	0.18	2.2	0.8	0.015	0.080	2.00 max		620-760	750	10	
EN10338	HDT780C	0.18	2.2	0.8	0.015	0.080	2.00 max		680-830	780	10	
EN10338	HDT950C	0.23	2.2	0.8	0.015	0.080	2.00 max		720-920	950	9	
EN10338	HDT1200M	0.25	2.0	0.8	0.015	0.060	2.00 max		900-1150	1200	5	



## SILICON STEEL

STANDARD SPECIFICATION			CHEMICAL COMPOSITION			APPLICATIONS
Specification	Grade	NOMINAL THICKNESS	MAXIMUM SPECIFIC CORE LOSS (W/KG) 50 HZ/KG at 1.5 T	Minimum Polarization at a Field Strength 800 A/m	Minimum Stacking Factor	
IS 3024	23CG110	0.23	0.73	1.78	0.945	SILICON/ELECTRICAL STEEL FOR MOTORS, GENERATOR & TRANSFORMERS
IS 3024	23CG120	0.23	0.77	1.78	0.945	
IS 3024	23CG127	0.23	0.80	1.75	0.945	
IS 3024	27CG120	0.27	0.80	1.78	0.950	
IS 3024	27CG130	0.27	0.85	1.78	0.950	
IS 3024	27CG140	0.27	0.89	1.75	0.950	
IS 3024	30CG130	0.30	0.85	1.78	0.955	
IS 3024	30CG140	0.30	0.92	1.78	0.955	
IS 3024	30CG150	0.30	0.97	1.75	0.955	
IS 3024	35CG145	0.35	1.03	1.78	0.960	
IS 3024	35CG155	0.35	1.07	1.78	0.960	
IS 3024	35CG165	0.35	1.11	1.75	0.960	

- A Sample Public Standard for Electrical Steel.
- DIN : 46400 –part1, part2, part3 and IS 3024:2006 for various weight & field strength can also be produced.

## PIG IRON AND BY-PRODUCTS

### 1. PIG IRON :

GRADE	IS : 13502
C	4-4.7 %
Mn	Max 0.05%- 0.1%
Sulphur & Phosphorus	Max 0.15%
Silicon	Max 0.6-1.5%

### 2. BY-PRODUCTS:

• CRUDETAR
• NAPHATELENE
• SULPHUR

### 3. BF GRANULATED SLAG



# RATIONALIZED SIZES OF HR COILS

THICKNESS (mm)	WIDTH (mm)
1.5	950
1.8	950, 1030
2.0	950, 1070, 1250, 1310, 1400
2.5	950, 1070, 1250, 1310, 1400, 1420
2.8	950, 1070, 1250, 1310, 1400, 1420
2.9	950, 1090, 1130, 1155, 1160, 1250, 1280, 1310, 1400, 1420
3.15	950, 1130, 1150, 1250, 1310, 1400, 1420
3,5	950, 1030, 1250, 1310, 1360, 1400, 1420, 1500, 1550
3.9	950, 1030, 1250, 1310, 1400, 1420, 1500, 1550
4	950, 1250, 1270, 1310, 1400, 1420, 1500, 1550
4.50	950, 1030, 1100, 1250, 1310, 1360, 1400, 1420, 1500, 1530
5.0	950, 1030, 1250, 1310, 1400, 1420, 1500, 1550
6.0	950, 1030, 1250, 1310, 1400, 1420, 1550
7.0	950, 1030, 1250, 1310, 1360, 1400, 1420, 1500, 1550
8.0	950, 1030, 1250, 1310, 1360, 1400, 1420, 1500, 1550
9.2, 10.0, 12.0	950, 1030, 1150, 1250, 1310, 1400, 1420, 1500, 1550
16	1250, 1310, 1400, 1420, 1500, 1550

## HR Sheet for Conventional LPG Cylinders ( IS 6240/2008)

Thickness (mm)	Width (mm)	Length (mm)
2.9	1240	2480
2.8	1250	2500

## HR Coils for LPG Cylinders ( IS 6240/2008)

Thickness (mm)	Width (mm)
2.9	1090, 1160, 1250



# RATIONALIZED SIZES OF HR SHEETS

THICKNESS (mm) (gauge)	WIDTH (mm)	LENGTH (mm)
1.8 (18)	950, 1000, 1100, 1250, 1310	2500
2.0 (14)	950, 1000, 1100, 1250, 1310	2500
2.5 (12)	950, 1000, 1100, 1250, 1310, 1400	2500, 4000
2.9	1000, 1100, 1250, 1400	2500, 4000, 4500
3.15 (10)	1000, 1100, 1250, 1400	2500, 4000, 4500
3.55 (9)	1000, 1100, 1250, 1400	2500, 4000, 4500
4.0 (8)	1000, 1100, 1250, 1400	2500, 4000, 4500
4.65 (7)	1000, 1100, 1250, 1400	2500, 4000, 4500

# RATIONALIZED SIZES OF HR PLATES

THICKNESS (mm) (gauge)	WIDTH (mm)	LENGTH (mm)
5	1000, 1250, 1400, 1500, 1600	4500, 5000, 6300, 8000
6	1000, 1250, 1400, 1500, 1600	4500, 5000, 6300, 8000
7	1000, 1250, 1400, 1500, 1600	4500, 5000, 6300, 8000
8	1000, 1250, 1400, 1500, 1600	4500, 5000, 6300, 8000
10	1000, 1250, 1400, 1500, 1600	4500, 5000, 6300, 8000
12	1000, 1250, 1400, 1500, 1600	4500, 5000, 6300, 8000



# NMDC Steel Limited

(A Government of India Enterprise)

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