FORGING, MACHINING AND FABRICATION

COMPANY PROFILE

KAYON FORGING CORPORATION LLP

Flanges, fittings, outlets and fasteners. Spools, vessels, tanks and skids.

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SUPERSEDES	**Company Profile 2024**
ISSUED BY	**Chief Executive Officer**

FORGE SHOP	8th KM Stone, Meerut Road, Ghaziabad 201 009, Uttar Pradesh, India	FABRICATION	Nalasopara, Maharashtra and Ankleshwar, Gujarat, India
MACHINING	18, Phase 4, Parmar Techno Center, Vasai Phata, Wakanpada, Vasai (E), Palghar - 401208, India	OFFICE	519, Panchratna, Opera House, Charni Road, Mumbai - 400004

1 WHAT KAFCO DOES

COMPONENTS

FORGED AND MACHINED IN HOUSE

Flanges 1/2 in to 60 in, class 150 to 2500
Buttweld fittings 1/2 in to 48 in, Sch 5 to XXS
Forged fittings 1/8 in to 4 in, class 2000 to 9000
Outlets 1/8 in to 24 in
Fasteners M10 to M100, to 5 m
Pipe, plate and bar Held in stock

ASSEMBLIES

BUILT TO THE CLIENT DRAWING

Piping spools 1/2 in to 48 in, ASME B31.3
Pressure vessels To 120 in dia, ASME VIII Div 1
Storage tanks To 1,000,000 gallons, API 650
Modular skids Frame, piping, vessels, instruments
Complete machines Fabricated, assembled and tested
Rolling To 20 mm thickness by 2.5 m

99%
OF TURNOVER IS EXPORT

100%
OF CLIENTS PLACED A REPEAT ORDER

THREE REASONS AN ORDER MOVES HERE

One source for the flange, the fitting, the outlet and the stud bolt in the same joint, on one certificate package.
Forging, heat treatment and machining owned, so a delivery date is a commitment and not a forecast.
Typically 10 to 30 per cent below European supply on the same specification.

FINISHED FLANGES AWAITING MARKING

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2 FROM BAR TO CRATE

01 FORGE

FORGING EQUIPMENT	CAPACITY	QTY
Steam hammer	12 tonne	3
Ring forging hammer	Up to 2.5 metre outside diameter	1
Steam boiler		3
Oil fired furnace		4
Water tank	40 kilolitre	1
Furnace oil tank	20 kilolitre	1

A RING LEAVES THE FURNACE

FORGED RINGS, COOLING

BLANKS OFF THE HAMMER

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02 HEAT TREATMENT

HEAT TREATMENT	CAPACITY	QTY
Heat treatment furnace, oil fired	2 tonne charge, chamber 8 ft by 11 ft by 16 ft	1
Normalising, hardening and tempering, annealing	Carried out in the above furnace	
Water quenching tank		1
Oil quenching tank		1

NORMALISED, AWAITING MACHINING

HEAT TREATMENT SHOP

CHARGE UNDER THE CRANE

Carried out on site	A formed fitting or a forged flange does not leave the works to be normalised or solution annealed
Cycles	Normalising, hardening and tempering, annealing, water and oil quenching

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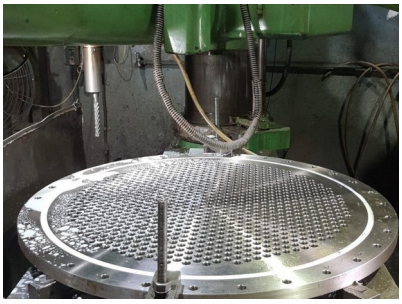
03 MACHINING

MACHINING	CAPACITY	QTY
Lathe, 18 ft	Maximum turning 2200 mm outside diameter by 6000 mm length	2
Lathe, 16 ft		3
Lathe, 12 ft		3
Lathe, 10 ft		1
Lathe, 8 ft		2
Vertical turning lathe	Maximum swing 1800 mm	4
Drilling machine		2
Band saw	Raw material cutting	3
Welding machine and gas cutter		3

VERTICAL TURNING

TURNING



DRILLING

MACHINE SHOP UNDER THE CRANE

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04 MARKING AND DESPATCH

MARKED TO MSS SP-25

WRAPPED AND BOXED

Marked with	Size and rating, schedule, specification and grade, heat number
Traceability	Heat number carried from the mill certificate to the despatch documents
Certificate	EN 10204 3.1 as standard, 3.2 with a nominated third party

CRATED FOR EXPORT

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3 THE WORKS

MACHINING AND STOCK WORKS, RAJKOT

UNDER THE CRANE

SET OUT FOR INSPECTION

BAR AND PIPE STOCK

POWER AND HANDLING	CAPACITY	QTY
Overhead crane	20 tonne	2
Overhead crane	10 tonne	2
Mobile crane	10 tonne	1
Generator	125 kVA	2

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3.1 FABRICATION CAPACITY

	UNIT 1	UNIT 2
Location	Nalasopara, Maharashtra	Ankleshwar, Gujarat
Area under shed	2,500 sq ft	9,000 sq ft
Open area	500 sq ft	8,000 sq ft
Total area	3,000 sq ft	17,000 sq ft
Manpower	10 workmen	20 workmen
Welders	4	7
Quality and production engineers	1 and 1	1 and 1
Crane capacity	Gantry crane, 6 tonne	Overhead crane, 10 tonne
Other lifting		Hydra, 12 tonne
Rolling machine	10 mm thickness by 2 m width	20 mm thickness by 2.5 m width
Electrode welding machines	4	10
TIG welding machines	2	5
CO2 welding machines	2	
Radial drilling	1, to 40 mm	1, to 50 mm
Lathe machines	2, to 200 mm diameter	
Welding capacity	100 mm thickness, joints to 100 per cent radiography	100 mm thickness, joints to 100 per cent radiography
Cutting sets	2	3
Hydrotesting	2 sets, to 400 kg/cm2	2 sets, to 500 kg/cm2
Dye and liquid penetrant	In house	In house
Ultrasonic and radiography	Approved vendor, on premises	Approved vendor, on premises

FABRICATION SHOP

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3.2 SITES

SITE	LOCATION	ADDRESS	WORK
Forge shop	Ghaziabad, Uttar Pradesh	8th KM Stone, Meerut Road, opposite Manan Dham Shiv Mandir, Ghaziabad 201 009	Open die forging, ring rolling, heat treatment
Machining, stock and despatch	Vasai East, Palghar, Maharashtra	Parmar Industrial Estate, Phase II, Unit 72, Pelhar Village, near Vasai Phata, W. E. Highway, Vasai East 401 208	Turning, drilling, marking, inspection, packing and despatch
Fabrication, Unit 1	Nalasopara, Maharashtra	Nalasopara, District Palghar, Maharashtra	Vessels and spools to 10 mm plate, gantry crane 6 tonne
Fabrication, Unit 2	Ankleshwar, Gujarat	Ankleshwar, District Bharuch, Gujarat	Vessels, tanks and skids to 20 mm plate, overhead crane 10 tonne
Administrative office	Opera House, Mumbai	519, Panchratna, Opera House, Charni Road, Mumbai - 400004	Commercial, procurement and documentation
Registered office	Borivali West, Mumbai	C/31 Aashiyana, Sodawala Lane, Borivali West, Mumbai 400 092	Registered address of the LLP
Overseas office	Dubai, United Arab Emirates	AG Silver Tower, Jumeirah Lakes Towers, Dubai	Gulf enquiries and follow up

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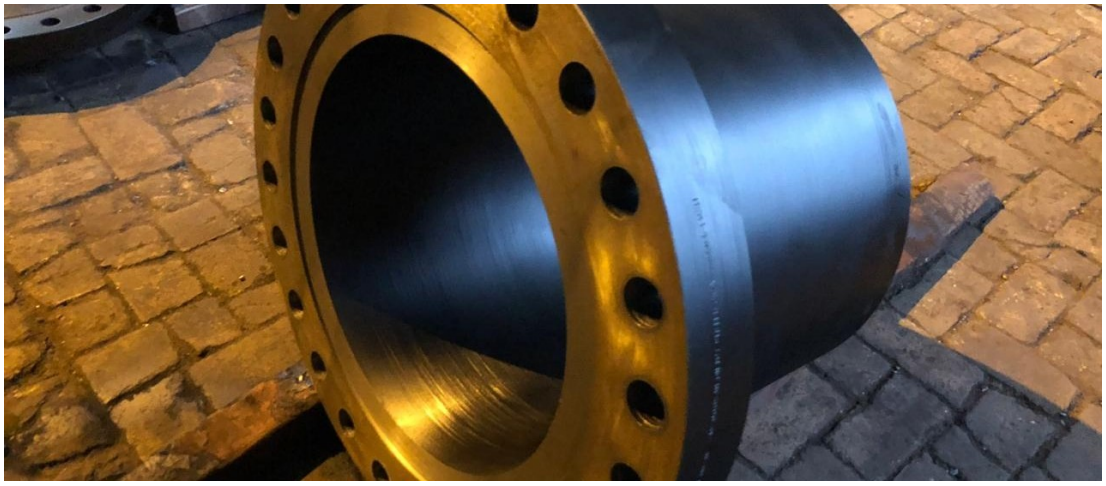
4 WHAT IT MAKES

4.1 FLANGES

Forged on the hammers, heat treated, turned and drilled in house.



Range	1/2 in to 60 in
Dimensional standard	ASME B16.5 and ASME B16.47 Series A and B
Pressure class	150, 300, 600, 900, 1500 and 2500
Other tables	ASA 150 and ASA 300, tables D, E, F and H. DIN ND 6, 10, 16, 25 and 40
Types	Weld neck, socket weld, slip on, blind, screwed, long weld neck, lapped joint, reducing, spectacle blind
Facings	Raised face, flat face, ring type joint
Specifications	ASTM, ASME, API, AISI, BS, ANSI, DIN, JIS, MSS SP, NACE
Further work	Hot dip galvanising, heat treatment, CNC machining, threading
Speciality	IBR flanges, long weld neck, spectacle blinds

WELD NECK FLANGES, MACHINED

LARGE BLIND FLANGE, WRAPPED

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4.2 BUTTWELD FITTINGS

Seamless and welded. Solution annealed after forming where the specification calls for it.

Range	1/2 in to 48 in, seamless and welded
Thickness	Sch 5, 10, 20, 30, 40, 60, 80, 100, 120, 140, 160, STD, XS and XXS
Dimensional standard	ASME B16.9 and MSS SP-43
Types	Elbow long and short radius, 45, 90 and 180 degree. Tee barred, equal and reducing. Reducer concentric and eccentric. Nipple swage and barrel. Stub end long and short. U bend, end cap, laterals
Further work	Hot dip galvanising, polishing, heat treatment, sand blasting
Speciality	IBR fittings, barred tees, fittings to drawing

STAINLESS ELBOWS

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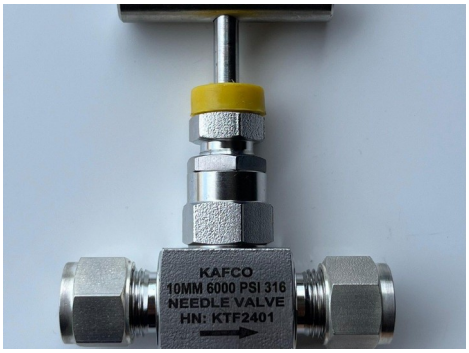
4.3 FORGED FITTINGS

Socket weld and threaded, forged and machined at the flange works.

Range	1/8 in to 4 in
Pressure class	2000, 3000, 6000 and 9000
Dimensional standard	ASME B16.11
Ends	Socket weld and threaded
Types	Elbow, tee, union, cross, swage nipple, coupling, cap, plug, bushing, boss, insert
Instrumentation and tube fittings	Adapter, tee, coupling, connector, cross. Compression, instrumentation and hydraulic patterns, and to drawing
Further work	Hot dip galvanising, heat treatment, sand blasting, machining, threading
Speciality	IBR fittings, swage nipples, fittings to drawing

FORGED TEE, MARKED KAFCO



INSTRUMENTATION VALVE

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4.4 OUTLETS

Branch connections forged from bar and machined to the run pipe.

Range	1/8 in to 24 in
Pressure class	3000 and 6000, and to schedule
Types	Weldolet, sockolet, elbolet, thredolet, nipolet, latrolet, sweepolet
Speciality	Outlets in duplex and nickel alloys

4.5 FASTENERS

Supplied against the same certification as the flanges they secure.

Range	M10 to M100, length to 5 metres
Types	Stud bolts, hexagon, eye, square, friction grip, structural, foundation, U and J. Nuts, nylock and lock. Washers, star and plain. Allen caps and screws, countersunk, pan head and cross recessed
Coatings	Hot dip galvanising, phosphate, PTFE, Xylan, zinc and cadmium plating
Speciality	Copper, brass and stainless steel washers and stud bolts

SUPPLIED TOGETHER

The flange, the outlet and the stud bolt that go into one joint are quoted on one line, certified in one package and despatched in one crate.

PACKED FOR DESPATCH

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4.6 MATERIALS OF CONSTRUCTION

MATERIAL GROUP	FLANGES	FORGED FITTINGS AND OUTLETS	BUTTWELD FITTINGS	FASTENERS
Carbon steel	ASTM A105, ASTM A694 F42 to F70	ASTM A105	ASTM A234 WPB	ASTM A193 and A194 B7, B7M, 2H, 2HM
Low temperature carbon steel	ASTM A350 LF2, ASTM A516 Gr. 70	ASTM A350 LF2	ASTM A420 WPL6	ASTM A320 L7, L43
Alloy steel	ASTM A182 F5, F9, F11, F12, F21, F22, F91	ASTM A182 F5 to F91	ASTM A234 WP5, WP9, WP11, WP12, WP22, WP91	ASTM A193 B16
Stainless steel	ASTM A182 and A240 F304, 304H, 304L, 316, 316H, 316L, 316Ti, 309, 310, 317L, 321, 347, 904L	ASTM A182 F304 to F904L	ASTM A403 WP304, 304H, 304L, 316, 316H, 316L, 316Ti, 309, 310, 317L, 321, 347, 904L	ASTM A193 and A194 B8, B8M, B8C, 8, 8M, 8C
Duplex and super duplex	ASTM A182 F51, F53, F55, UNS S31803, S32750, S31500	ASTM A182 F51, F53, F55	ASTM A815 UNS S31803, S32760, S31500, S32550	To order
Nickel and Monel	UNS N02200, N02201, N04400, N05500	UNS N02200 to N05500	UNS N02200 to N05500	UNS N04400, N05500
Inconel and Incoloy	UNS N06600, N06601, N06625, N08800, N08810, N08825	UNS N06600 to N08825	UNS N06600 to N08825	UNS N06600 to N08825
Hastelloy	UNS N10276, N06022, N10665, N06455	UNS N10276 to N06455	UNS N10276 to N06455	UNS N10276 to N06455
Alloy 20	UNS N08020	UNS N08020	UNS N08020	UNS N08020
Titanium	Gr. 1, 2 and 3, DIN 3.7025, 3.7035, 3.7055	Gr. 1, 2 and 3	Gr. 1, 2 and 3	Gr. 1, 2 and 3
Copper alloys and cupronickel	C70400, C70600 (90:10), C71000, C71500 (70:30), C71640, C2800, C36500, C46400	C70400 to C46400	C70400 to C46400	C70400 to C46400
Aluminium	ASTM 6061, 6063, 6351	ASTM 6061, 6063, 6351	ASTM 6061, 6063, 6351	ASTM 6061, 6063, 6351

Where a family shows a range, every grade between the two named is available.

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4.7 PIPE AND TUBE

ALLOY PIPE AND TUBE	SIZE	TYPICAL SERVICE
Stainless steel 304, 304L, 316, 316L, 321, 347, 410, 430	1/4 in to 24 in	Food processing, architectural, chemical processing, marine, petroleum refining
Stainless steel 409, 439, 441	1/4 in to 24 in	Automotive exhaust systems, heat exchangers, furnace components
Duplex steel 2205	1/8 in to 24 in	Chemical processing, oil and gas, pulp and paper, marine
Super duplex steel 2507	1/8 in to 24 in	Chemical processing, oil and gas, pulp and paper, marine
Stainless steel 904L	1/4 in to 24 in	Chemical processing, petrochemical, pharmaceuticals
Inconel 600, 625, 718	1/4 in to 24 in	Aerospace, chemical processing, nuclear, marine, oil and gas
Incoloy 800, 825	1/4 in to 24 in	Chemical processing, acid production, oil and gas, marine
Hastelloy C-276, C-22, B-2	1/4 in to 24 in	Chemical processing, pulp and paper, pollution control, waste treatment
SMO 254	1/4 in to 24 in	Chemical processing, desalination, power generation, marine

CARBON AND ALLOY STEEL PIPE	SIZE	SCHEDULE
ASTM A106 Gr. B, ASTM A333 Gr. 6, ASTM A53 Gr. B	1/2 in to 48 in	Sch 10, 20, 30, 40, 60, 80, 100, 120, 140, 160, XXS
ASTM A671, ASTM A672	1/2 in to 48 in	Sch 10, 20, 30, 40, 60, 80, 100, 120, 140, 160, XXS
ASTM A335 Gr. P11, ASTM A335 Gr. P22	1/2 in to 48 in	Sch 20, 30, 40, 80, 120, 140, 160, XXS
ASTM A234 WP5	1/2 in to 48 in	Sch 5S, 10S, 40S, 80S, 160

4.8 PLATE AND BAR

Plate forms	Standard plate, shims, circular plates
Bar forms	Round, hexagon, flat and square bar, welding wire
Grades	Carbon, stainless, alloy, duplex and super duplex, Inconel, Incoloy, Hastelloy, Monel, titanium, tantalum, 904L, 254 SMO, Alloy 20, Nitronic and cupronickel
Value added	Cut to length, polishing or mill black finish, heat treatment, threading in NPT, BSPT and BSPP
Identification	In house positive material identification before release

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5 WHEN THE ORDER IS A DRAWING

Rolled, fitted, welded, tested and painted at the fabrication units, and despatched as one assembly. Welding qualified to ASME Section IX, joints radiographed to 100 per cent where the code calls for it.

5.1 PIPING SPOOLS

Size range	1/2 in to 48 in, to the client isometric
Design and fabrication code	ASME B31.3
Pipe specification	ASTM A53, ASTM A106, ASTM A312
Service	Gas, oil and hydraulic
Features	Welded or threaded connections, flanged, insulated to requirement. Tested and marked as one assembly

5.2 STORAGE TANKS

Size range	1 gallon to 1,000,000 gallons and above
Design code	API 650, API 620, AWWA D100, ASME RTP-1
Pressure	Atmospheric to 5,000 psi and above
Applications	Chemical storage, oil and gas production, water storage
Features	External insulation, internal coatings, agitators

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5.3 PRESSURE VESSELS

Size range	To 120 inch diameter, to 200,000 lb and above
Design code	ASME Section VIII Division 1, PED 2014/68/EU, CRN
Pressure	Full vacuum to 10,000 psi and above
Applications	Chemical processing, oil and gas refining, power generation
Features	Nozzles, supports, manways, internals to drawing

5.4 MODULAR SKIDS

Size range	To drawing
Scope	Frame, piping, vessels, instruments and valves assembled, tested and despatched as one unit
Applications	Oil and gas production, chemical processing, power generation
Features	Pre-fabricated modules for short site installation time

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5.5 DELIVERED

Shell and tube heat exchanger
Tube bundle and shell under assembly

Pressure vessel
Nozzles, manway and saddle supports set

Limpet coil vessel
Coil wound and welded, ready for hydrotest

Vertical vessel
Cage ladder and platform fitted before despatch

Horizontal vessel
Shell rolled and seam welded in house

Process skid
Filter, valves and piping on one frame

Valve assembly
Body, bonnet and flanges fitted

Heat exchanger
Nozzles and channel cover set

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6 HOW IT IS PROVEN

Quality management system	Documented in KAFCO/QM/2026, written to the structure of ISO 9001:2015, issued on request
Material certification	EN 10204 3.1 as standard. EN 10204 3.2 with a nominated third party agency
Marking	MSS SP-25. Hard stamped or vibro etched to the client instruction
Traceability	Heat number from the mill certificate through forging, heat treatment, machining and marking
Welding	Welder performance qualification to ASME Section IX, records issued with the assembly
Corrosion service	NACE MR0175 where the order specifies it
Material identification	In house, on plate, bar and finished items before release

6.1 TEST FACILITIES

IN HOUSE

- Chemical laboratory
- Universal testing machine, tensile
- Impact testing machine
- Hardness testing machine
- Ultrasonic testing
- Magnetic particle inspection
- Dye and liquid penetrant testing
- Bend test
- Heat treatment simulation furnace

BY APPROVED LABORATORY

- Spectrographic analysis
- Intergranular corrosion test
- Micro examination
- Macro etch test
- Hydrogen induced cracking test

POSITIVE MATERIAL IDENTIFICATION

MECHANICAL TESTING

CERTIFICATION STATUS

Third party certification of the management system is under recertification. The current status, and the certificate once issued, are given to any client who asks.

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7 CONTACT

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