



Broken Mold	103	35.52%
Broken Core	50	17.24%
Mold Shift	47	16.21%
Shrinkage	40	13.79%
Porosity	28	9.66%
Hot Tear	11	3.79%
Slag	8	2.76%
Metal Temp	2	0.69%
Drawn	1	0.34%
Miscellaneous	0	0.00%
Total:	290	100.00%

