

CONTINUOUS CAST BILLETS AND BLOOMS

	Dimensions (mm)	min - max Length (mm)
Square	135x135	3.000 - 12.000
Square	160x160	3.000 - 12.000
Square	240x240	2.500 - 6.000
Rectangular	280x300	2.500 - 6.000
Round	300	2.500 - 6.000
Round	310	3.000 - 12.000
Round	406	2.000 - 6.000
Round	500	2.000 - 6.000
Round	600	2.000 - 6.000

INGOT

	Dimensions (mm)	Height (mm)	Weight (kg)
Square	480X480	1.510	2.250
Square	550X550	1.730	2.800
Polygonal	710	1.500	5.000

WEIGHT PER METER FORMULAS

$$\text{weight per meter} = \frac{d \times 0.616}{100} \text{ kg}$$

$$\text{weight per meter} = \frac{a^2 \times 0.785}{100} \text{ kg}$$

$$\text{weight per meter} = \frac{a \times b \times 0.785}{100} \text{ kg}$$

$$\text{weight per meter} = \frac{a^2 \times 0.68}{100} \text{ kg}$$

$$\text{weight per meter} = 0.0076495 a^2 - 0.0059579 r^2 \text{ kg}$$

STEEL GRADES PRODUCED

CARBON STEELS	
BS 080A42	S 35 C
C 45	SAE 1040
C 60 R	SAE 1050
CF 53	

HEAT TREATABLE STEELS	
34 CrNiMo 6	AISI 4145
39 NiCrMo 3 Pb	BS 605M36
41 Cr 4	BS 817M40
42 CrMo 4	SAE 4150
AISI 4130	SCM 440H
AISI 4140	

BEARING STEELS	
100 Cr 6	100 CrMo 7-3
100 CrMnSi 6-4	AISI 52100
(100 CrMn 6)	SUJ 3
100 CrMo 7	

BORON STEELS	
20 MnB 4	ZF 6
33 MnCrB 5-2	ZF 7
SAE 51B60	ZF 7B

CONSTRUCTIONAL STEELS	
BS 150M19	
St 37-2, St 60-2, St 44-2	
S355J2 (S355J2G3, St 52-3)	

STAINLESS STEELS	
AISI 410	X 17 CrNi 16-2
AISI 431	X 20 Cr 13
BS 420S29	X 46 Cr 13

HIGH TEMPERATURE RESISTANT STEELS	
10 CrMo 9-10	16 Mo 3
13 CrMo 4-5	X 20 CrMoV 12-1
32 CrMoV12-10	

MICROALLOYED STEELS	
(High Strength Low Alloy (HSLA) Steels)	
19 MnVS 6	38 MnVS6
30 MnVS 6	ZF 59
38 MnSiVS 5	AMC ® 1200

COLD AND HOT WORKING TOOL STEELS	
1.2208 (31CrV 3)	1.2842 (90 MnCrV 8)
1.2714 (56 NiCrMoV 7)	1.2127 (105MnCr 4)
1.2344 (X 40 CrMoV 5-1)	

CASE HARDENING STEELS	
16/20 MnCr(S) 5	BS 655M13
18 CrNiMo 7-6	SAE 8620H
18 NiCrMo 5	SCM 420
25 MoCr4	ZF1
AISI 5120	ZF1A

FREE CUTTING STEELS	
11 SMn 30 (9 SMn 28)	
11 SMn 37 (9 SMn 36)	
11 SMnPb 30 (9 SMnPb 28)	
11 SMnPb 37 (9 SMnPb 36)	
35 S 20	
AISI C12L14	
BS 220M07	
EN 8M	
SAE 1117	

SPRING STEELS	
55 Cr 3	AISI 9260
51 CrV 4	52 CrMoV4
60 SiCr 8	SUP 9
60 SiMn 5	SUP9A

WEAR RESISTANT STEELS	
90 Mn 4	
X 100 CrMoV 5-1	
X 120 Mn 12	
60 SiMn 5	


NITRIDING STEELS	
8 CrMo 16	
15 CrMoV 5-9	
31 CrMo 12	
31 CrMoV 9	
BS 150M36	

HOT ROLLED PRODUCTS


ROUNDS  19 mm - 250 mm							
Medium Section Sizes				Large Section Sizes			
mm	inch	mm	inch	mm	inch	mm	inch
19	0.75	47	1.85	74	2.91	101.5	4.00
20	0.79	48	1.89	75	2.95	102.4	4.03
21	0.83	49	1.93	76	2.99	105	4.13
22	0.87	50	1.97	77	3.03	108.75	4.28
23	0.91	51	2.01	78	3.07	110	4.33
24	0.94	52	2.05	79	3.11	111.5	4.39
25	0.98	53	2.09	80	3.15	115	4.53
26	1.02	54	2.13	81	3.19	115.1	4.53
27	1.06	55	2.17	82	3.23	120	4.72
28	1.10	56	2.20	83	3.27	121.65	4.79
29	1.14	57	2.24	84	3.31	125	4.92
30	1.18	58	2.28	85	3.35	128	5.04
31	1.22	59	2.32	86	3.39	130	5.12
32	1.26	60	2.36	87	3.43	134.35	5.29
33	1.30	61	2.40	88	3.46	135	5.31
34	1.34	62	2.44	89	3.50	140	5.51
35	1.38	63	2.48	90	3.54	140.7	5.54
36	1.42	64	2.52	91	3.58	145	5.71
37	1.46	65	2.56	92	3.62	147.65	5.81
38	1.50	66	2.60	93	3.66	150	5.91
39	1.54	67	2.64	94	3.70	154	6.06
40	1.57	68	2.68	95	3.74	160	6.30
41	1.61	69	2.72	96	3.78	166.7	6.56
42	1.65	70	2.76	97	3.82	170	6.69
43	1.69	71	2.80	98	3.86	173.45	6.83
44	1.73	72	2.83	99	3.90	180	7.09
45	1.77	73	2.87	100	3.94	186.15	7.33
46	1.81			190	7.48		
				192.5	7.58		
				198.86	7.83		
				200	7.87		
				205.2	8.08		
				210	8.27		
				211.55	8.33		
				217.9	8.58		
				220	8.66		
				230	9.06		
				240	9.45		
				250	9.84		

Ability to produce by 0,1 mm intervals with Kocks Block Technology (3-Roll Block)

According to DIN EN 10060

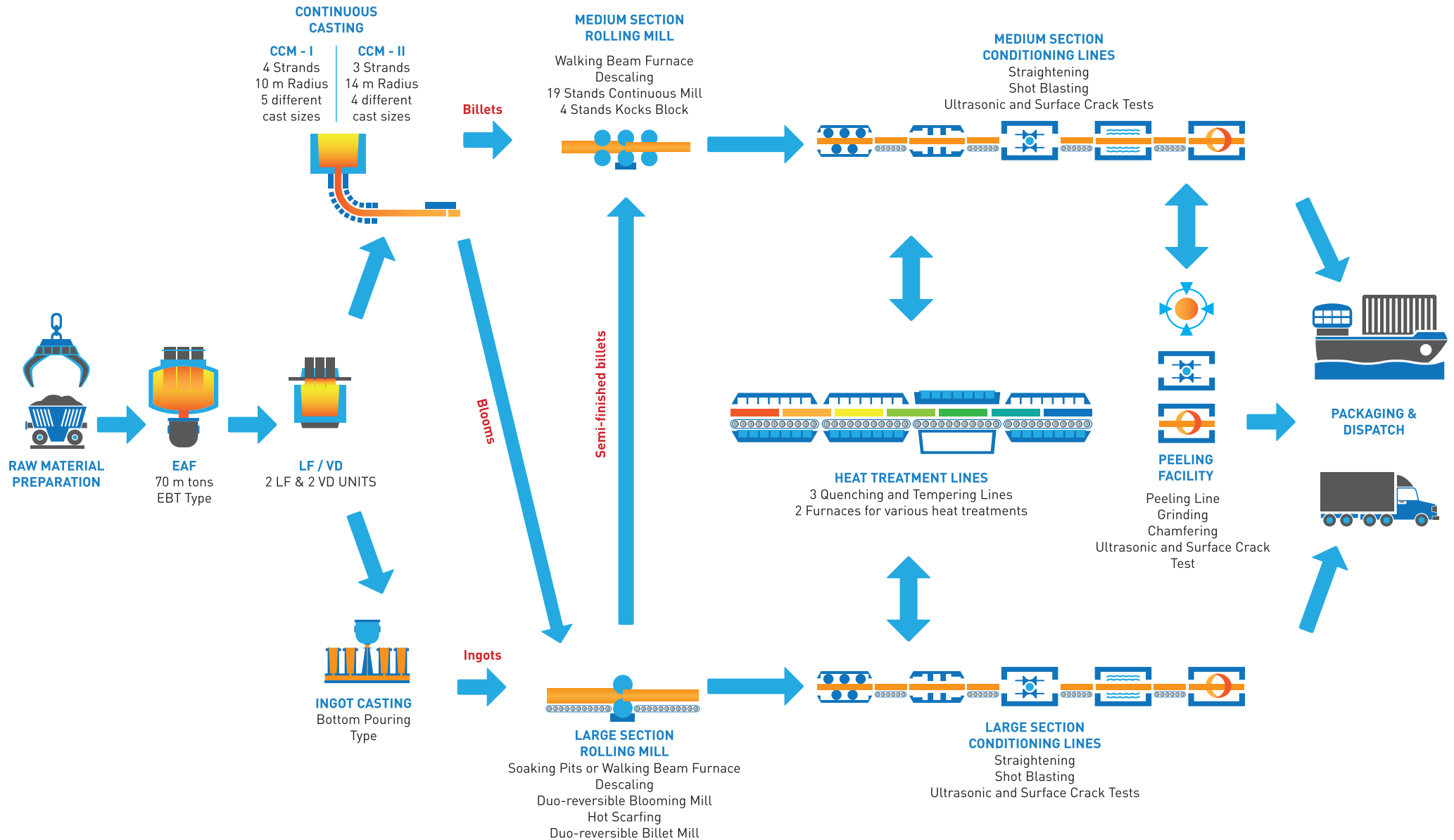
HEXAGONALS  18 mm - 71 mm	
mm	inch
18	0,71
20,5	0,81
23,5	0,93
25,5	1,00
28,5	1,12
31,5	1,24
33,5	1,32
37,5	1,48
39,5	1,56
42,5	1,67
47,5	1,87
52	2,05
57	2,24
62	2,44
67	2,64
71	2,80

According to DIN EN 10061

ROUND CORNER SQUARE  50 mm - 245 mm							
Size mm	Radius mm	Size inch	Radius inch	Size mm	Radius mm	Size inch	Radius inch
50	10	1,97	0,39	150	10	5,91	0,39
55	10	2,17	0,39	150	26	5,91	1,02
60	10	2,36	0,39	155	10	6,10	0,39
65	10	2,56	0,39	155	26	6,10	1,02
70	13	2,76	0,51	155	33	6,10	1,30
75	14	2,95	0,55	160	33	6,30	1,30
80	14	3,15	0,55	170	33	6,69	1,30
85	15	3,35	0,59	175	33	6,89	1,30
90	17	3,54	0,67	180	33	7,09	1,30
95	17	3,74	0,67	185	33	7,28	1,30
100	18	3,94	0,71	190	33	7,48	1,30
105	18	4,13	0,71	190	24	7,48	0,95
110	20	4,33	0,79	200	24	7,87	0,95
115	20	4,53	0,79	200	45	7,87	1,77
120	22	4,72	0,87	225	45	8,86	1,77
125	22	4,92	0,87	245	45	9,65	1,77
130	22	5,12	0,87	250	45	9,84	1,77
135	22	5,32	0,87	300	8 - 12	11,81	
140	22	5,51	0,87				
145	10	5,71	0,39				
145	26	5,71	1,02				

According to DIN EN 10059

PRODUCTION PROCESS



FLAT BARS SIZE TABLE

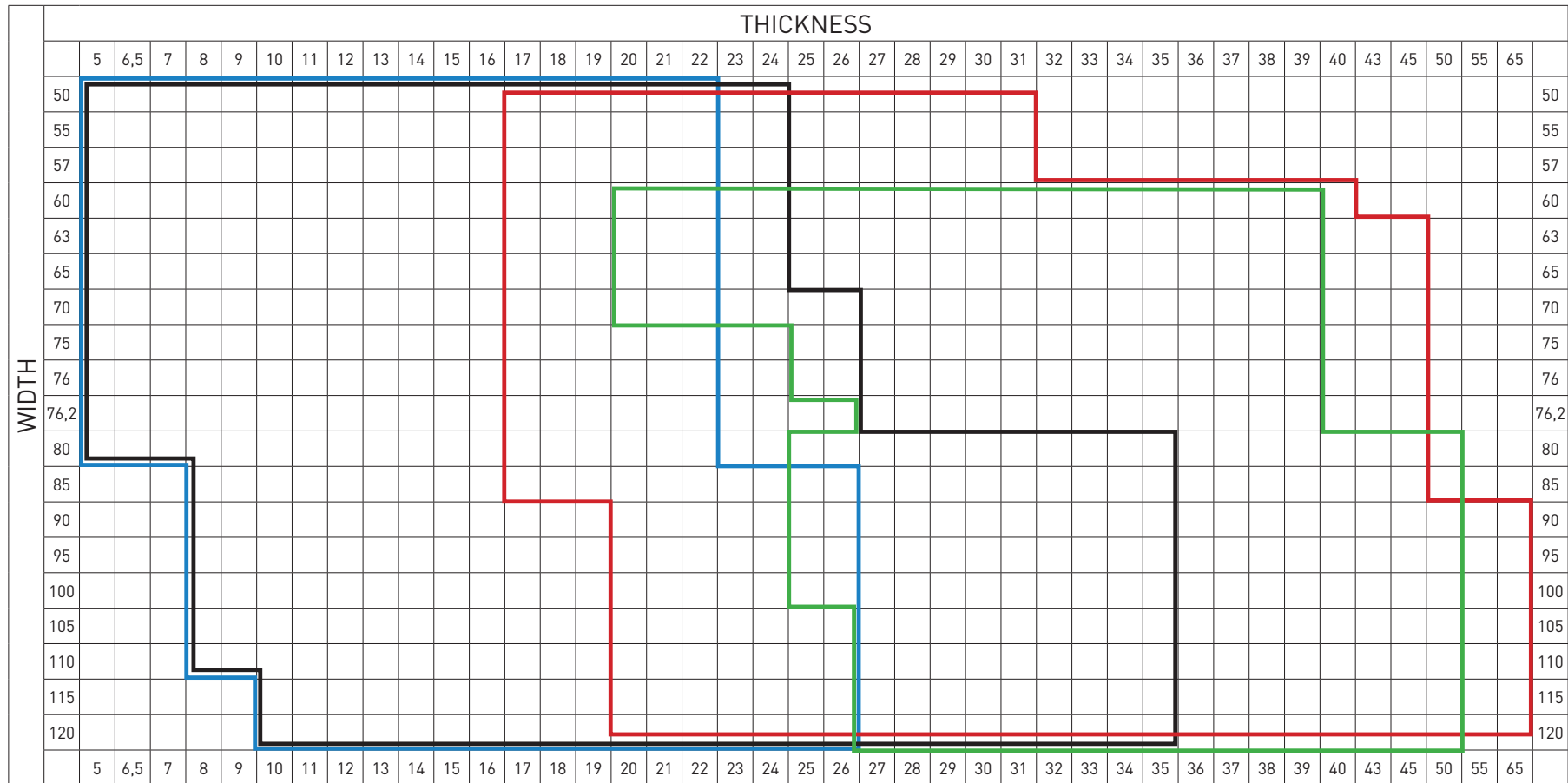
Width range: 50 - 120 mm
Thickness range: 6 - 60 mm

Continuous Casting Billet Size

- 240 x 240 mm
- 160 x 160 mm

LARGE FLATS SIZE RANGE

Width range: 135 - 400 mm
Thickness range: 50 - 200 mm



EN 10058
B-1017

EN 10092-1A
D-59145

EN 10092-1B
C-4620

EN 10092-1C
A-59146