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

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

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

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

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

gJ

weight per meter = 0.0076495 a^2 - 0.0059579 r^2 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

Abilitiy 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

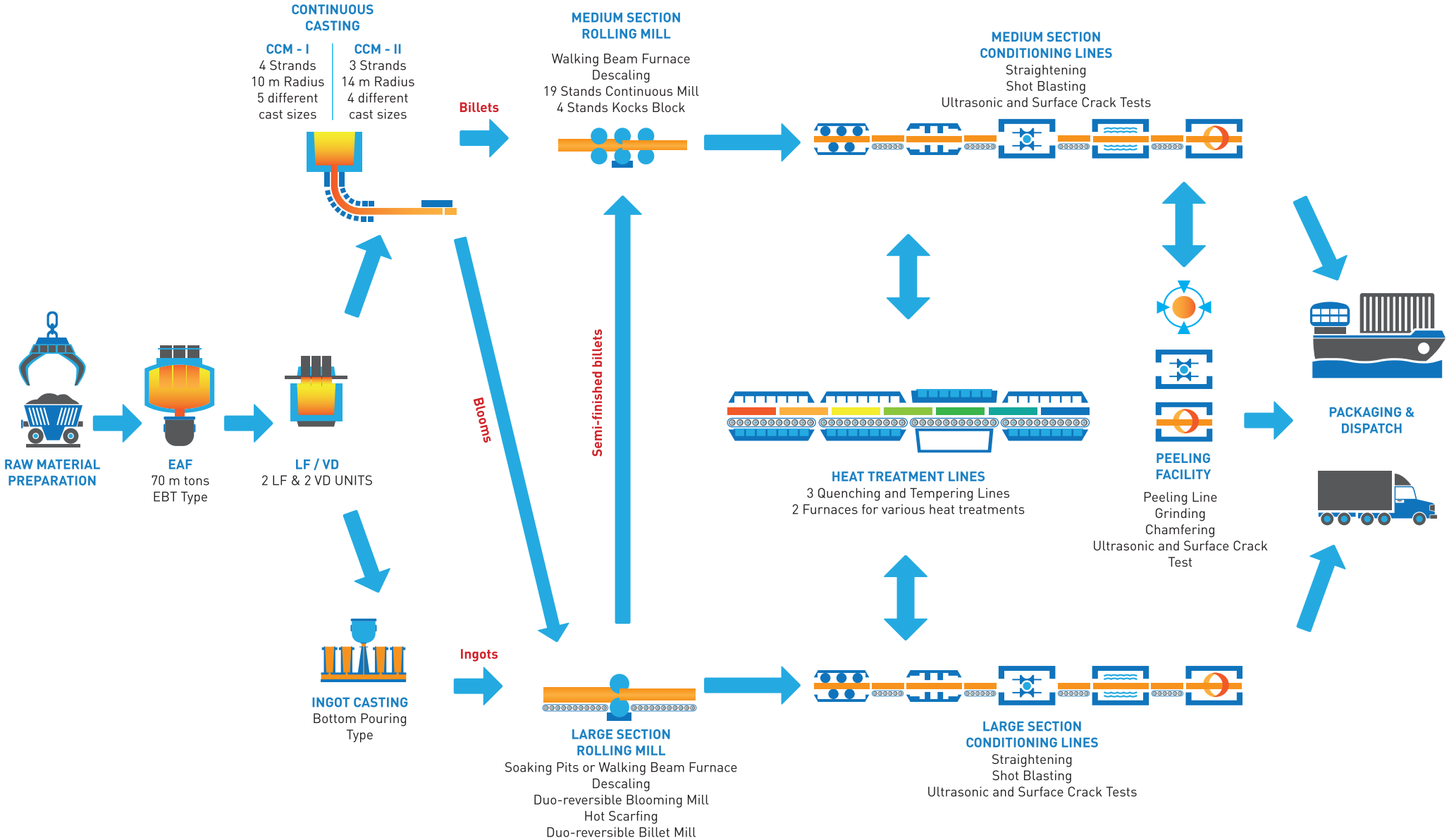
ROUND CORNER SQUARE

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

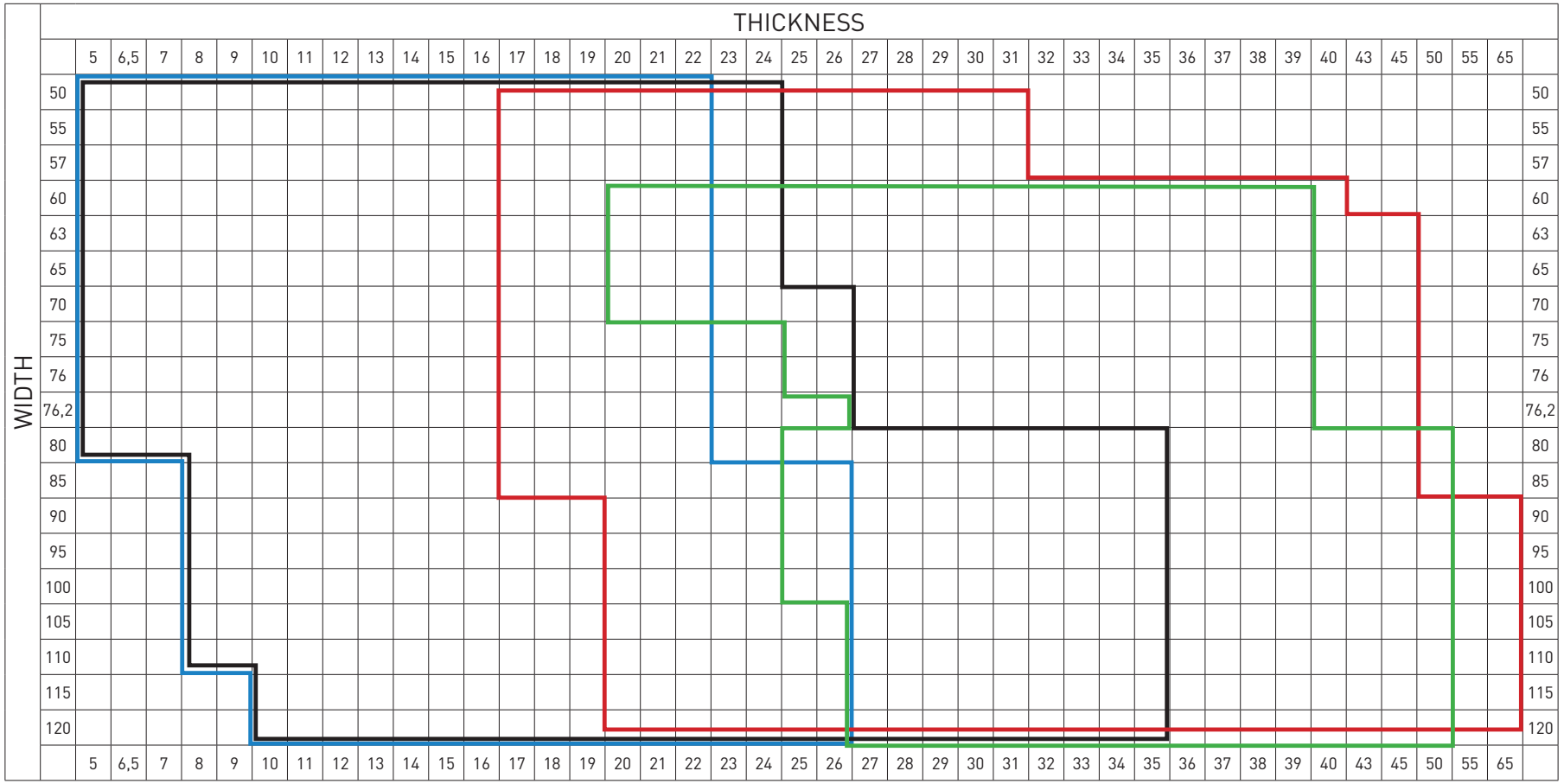


FLAT BARS SIZE TABLE

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