

HOT ROLLED PRODUCTS

	Section (mm)
Round Bars	19 - 280
Round Corner Square Bars	50 - 245
Hexagonal Bars	18 - 81
Large Flat Bars	80 - 200 x 200 - 400
Flat Bars	8 - 60 x 60 - 130

WEIGHT PER METER FORMULAS

	weight per meter = $\frac{d^2 \times 0.616}{100}$ 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
	weight per meter = $0.0076495 a^2 - 0.0059579 r^2$ kg

STEEL GRADES PRODUCED

CARBON STEELS	
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	605M36
41 Cr 4	817M40
42 CrMo 4	SAE 4150
AISI 4130	SCM 440H
AISI 4140	31 CrMoV 9

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

STAINLESS STEELS	
AISI 410	X 17 CrNi 16-2
AISI 431	X 20 Cr 13
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 (Bainitic Steels)

COLD AND HOT WORKING TOOL STEELS	
1.2343 (X 37 CrMoV 5-1)	1.2714 (55 NiCrMoV 7)
1.2344 (X 40 CrMoV 5-1)	1.2842 (90 MnCrV 8)


CASE HARDENING STEELS	
16/20 MnCr(S) 5	SAE 8620H
18 CrNiMo 7-6	SCM 420
18 NiCrMo 5	ZF1
25 MoCr4	ZF1A
AISI 5120	19 CN 5
655M13	

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
220M07
EN 8M
SAE 1117

SPRING STEELS	
55 Cr 3	52 CrMoV4
51 CrV4	31 CrV3
60 SiCr 8	SUP 9
60 SiMn 5	SUP9A
AISI 9260	


WEAR RESISTANT STEELS
X 90 Mn 18
15 NiMoCrB 4-5
X 120 Mn 12
GS-60 CrSi 5

HOT ROLLED PRODUCTS


ROUNDS  19 mm - 280 mm									
Medium Section Sizes						Large Section Sizes			
mm	inch	mm	inch	mm	inch	mm	inch	mm	inch
19	0,75	47	1,85	75	2,95	101,5	4,00	192,5	7,58
20	0,79	48	1,89	76	2,99	102,4	4,03	198,86	7,83
21	0,83	49	1,93	77	3,03	105	4,13	200	7,87
22	0,87	50	1,97	78	3,07	108,75	4,28	205,2	8,08
23	0,91	51	2,01	79	3,11	110	4,33	210	8,27
24	0,94	52	2,05	80	3,15	111,5	4,39	211,55	8,33
25	0,98	53	2,09	81	3,19	115	4,53	217,9	8,58
26	1,02	54	2,13	82	3,23	115,1	4,53	220	8,66
27	1,06	55	2,17	83	3,27	120	4,72	230	9,06
28	1,10	56	2,20	84	3,31	121,65	4,79	240	9,45
29	1,14	57	2,24	85	3,35	125	4,92	250	9,84
30	1,18	58	2,28	86	3,39	128	5,04	260	10,23
31	1,22	59	2,32	87	3,43	130	5,12	270	10,62
32	1,26	60	2,36	88	3,46	134,35	5,29	280	11,02
33	1,30	61	2,40	89	3,50	135	5,31		
34	1,34	62	2,44	90	3,54	140	5,51		
35	1,38	63	2,48	91	3,58	140,7	5,54		
36	1,42	64	2,52	92	3,62	145	5,71		
37	1,46	65	2,56	93	3,66	147,65	5,81		
38	1,50	66	2,60	94	3,70	150	5,91		
39	1,54	67	2,64	95	3,74	154	6,06		
40	1,57	68	2,68	96	3,78	160	6,30		
41	1,61	69	2,72	97	3,82	166,7	6,56		
42	1,65	70	2,76	98	3,86	170	6,69		
43	1,69	71	2,80	99	3,90	173,45	6,83		
44	1,73	72	2,83	100	3,94	180	7,09		
45	1,77	73	2,87			186,15	7,33		
46	1,81	74	2,91			190	7,48		

According to DIN EN 10060

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

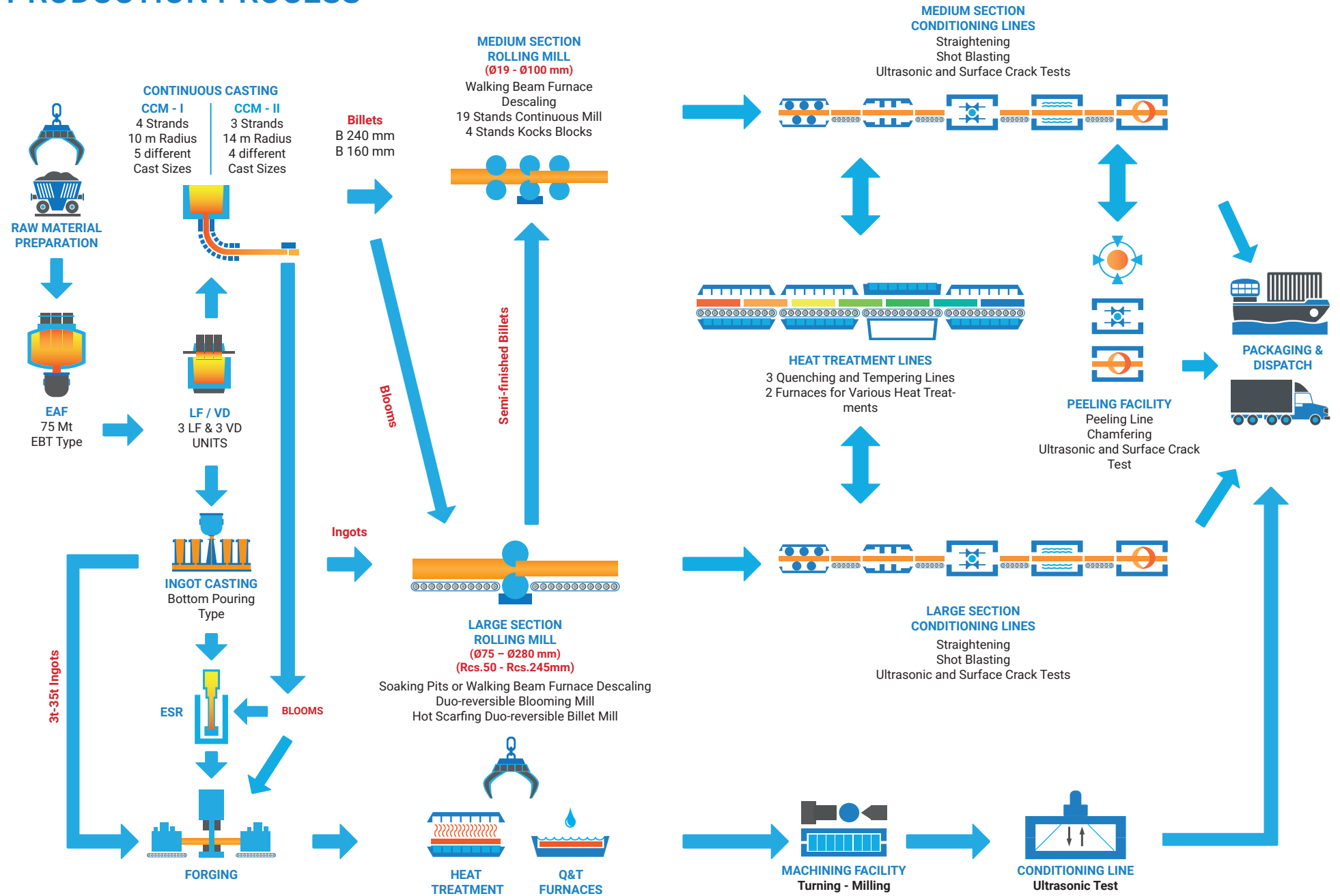
HEXAGONALS  18 mm - 81 mm				
mm	inch	mm	inch	
18	0,71	42,5	1,67	
20,5	0,81	47,5	1,87	
23,5	0,93	52	2,05	
25,5	1,00	57	2,24	
28,5	1,12	62	2,44	
31,5	1,24	67	2,64	
33,5	1,32	71	2,80	
37,5	1,48	80	3,10	
39,5	1,56	81	3,18	

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

According to DIN EN 10059

PRODUCTION PROCESS



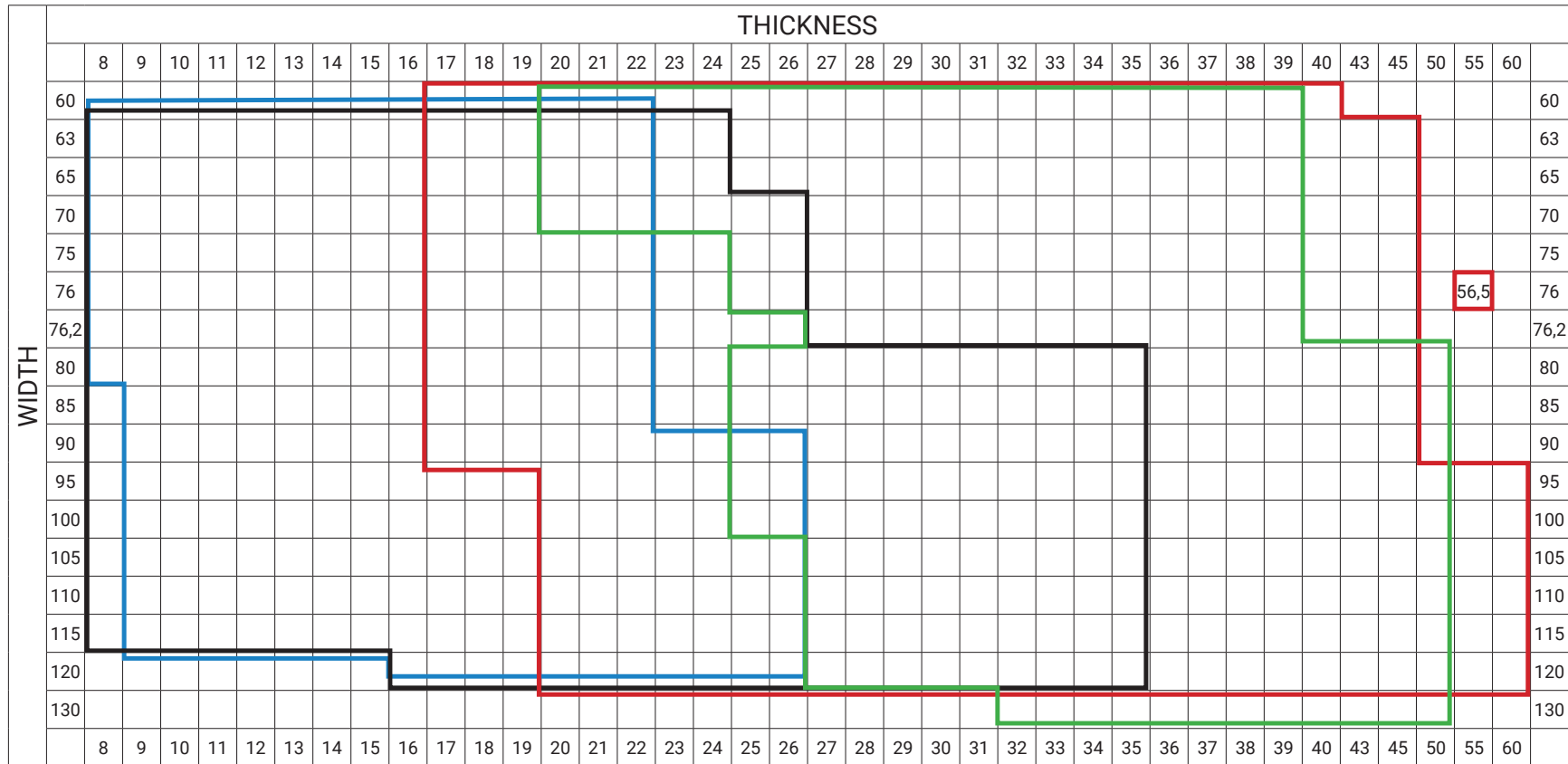
FLAT BARS SIZE TABLE

FLATS SIZE RANGE

Width Range : 60 - 130 mm
Thickness Range : 8 - 60 mm

LARGE FLATS SIZE RANGE

Width Range : 200 - 400 mm
Thickness Range : 80 - 200 mm



EN 10058
B-1017

EN 10092-1A
D-59145

EN 10092-1B
C-4620

EN 10092-1C
A-59146