

FORGED / MACHINED RINGS



PRODUCT RANGE

- Ring weight up to 2.000 kg
- Ring rolled / forged
- Heat treated
- Turning, drilling, milling possible
- max. outside dimension d max = 1.900 mm
- min. inside dimension d min = 250 mm
- min. wall thickness s min = 40 mm
- max. wall thickness s max = 300 mm
- min. height h min = 38 mm
- max. height h max = 320 mm

QUALITY INSPECTIONS

- Hot tensile test (up to 600°C)
- Impact test (down to -196°C)
- Chemical product analysis
- Ultrasonic test (UT)
- Determination of grain size
- Intergranular corrosion test
- Dye penetrant inspection (PT)
- Check of radioactive contamination
- Magnetic particle inspection (MT)
- Positive material identification (PMI)
- Measurement of ferrite content with Fisher Scope
- Mobile hardness test on finished products

MATERIAL GRADES

- Carbon Steel:

DIN/EN	C 21, C 22.8, C45/Ck45, St 52-3, TStE 355, WStE 355, TStE 420, WStE 420, P250GH, P280GH, P355NH, P420NH, P420QH
ASTM/ASME	A 105, A 350 LF2, A 350 LF6, A694 F42, A694 F52, A694 F60, A694 F65, A694 F70
- Alloy Steel:

DIN/EN	16Mo3, X12CrMo9-1, 12CrMo19-5, 13CrMo4-5, 10CrMo9-10, 42CrMo4, 100CrMn6, 100CrMo7-3, 100CrMnMoSi8-4-6
ASTM/ASME	A 182 F1, A 182 F9, A 182 F5, A 182 F11 Cl. 1-3, A 182 F12 Cl. 1-2, A 182 F22 Cl. 1, A 182 F22 Cl. 3
- Stainless Steel:

DIN/EN	1.4301, 1.4948, 1.4306, 1.4304, 1.4404, 1.4449, 1.4438, 1.4541, 1.4878, 1.4462, 1.4410, 1.4501, 1.4547, 2.4856, 2.4858
ASTM/ASME	A182 F304, A182 F304H, A 182 F304L, A 182 F316, A 182 F316L, A 182 F317, A 182 F317L, A 182 F321, A 182 F321H, A 182 F51, A 182 F53, A 182 F55, F44, Alloy 625, Alloy 825



FORGED RINGS



RING ROLLING PROCESS



PROFILED AND MACHINED RING