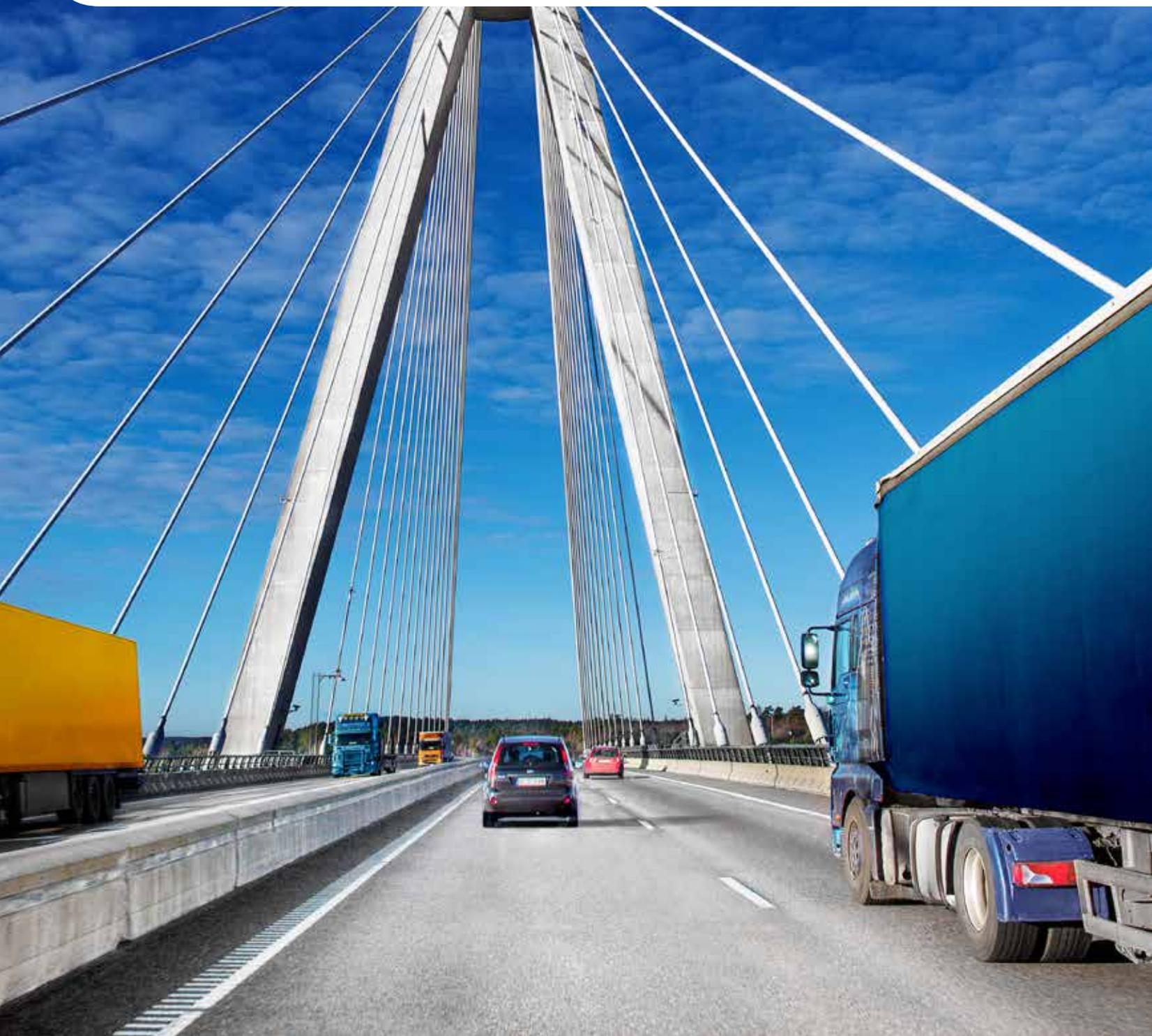
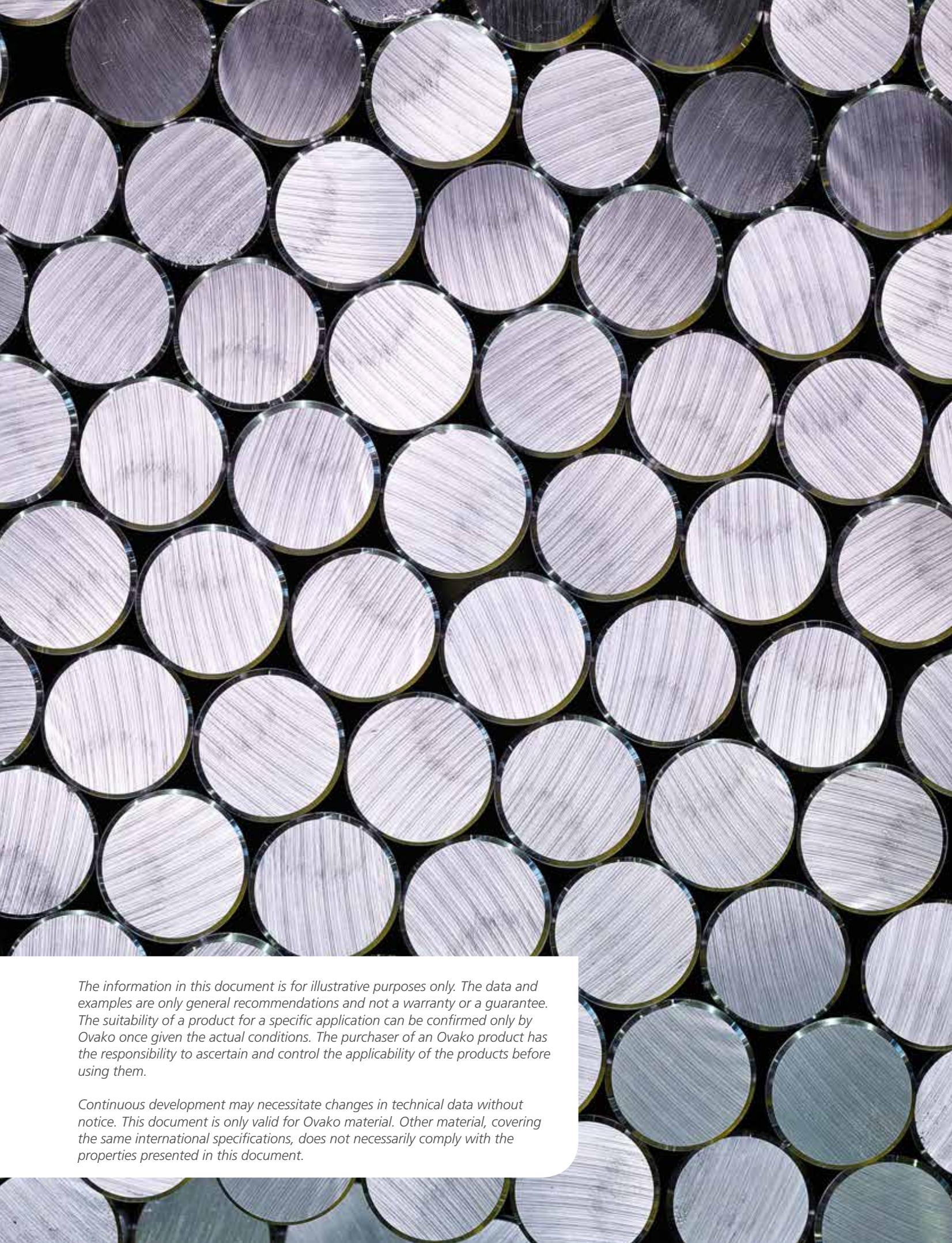


OVAKO

OVAKO **PRODUCTS**





The information in this document is for illustrative purposes only. The data and examples are only general recommendations and not a warranty or a guarantee. The suitability of a product for a specific application can be confirmed only by Ovako once given the actual conditions. The purchaser of an Ovako product has the responsibility to ascertain and control the applicability of the products before using them.

Continuous development may necessitate changes in technical data without notice. This document is only valid for Ovako material. Other material, covering the same international specifications, does not necessarily comply with the properties presented in this document.

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OUR INDUSTRIAL EXPERIENCE

Ovako has extensive experience in supplying steel for an array of demanding applications in a wide range of industrial segments. We maintain and develop solutions through a direct presence. As a result, we are able to apply our knowledge from each field to benefit customer and end-user needs.

Agriculture

Ovako supplies different grades of boron steel for agricultural machines, such as plows and many other products where wear resistance is a critical issue.



Bearings

Bearings have a service life bordering on the infinite. Ovako provides this clean steel to the largest bearing manufacturers in the world.

Powertrain

Increased power density, space under hood and energy efficiency is supported by the properties of BQ-Steel and IQ-Steel from Ovako.



General Engineering

This is where our knowledge from all industrial segments is condensed into a tailor-made solution for each customer, supported by dimension ranges and product formats.

Hydraulics

The excellent performance of the Cromax and Nikrom products is widely known among the producers of hydraulic pistons.



Automotive

The ambition to achieve lighter and stronger systems is supported by our clean steels.

Mining

Rock drilling and processing require steels that can withstand the toughest environments. With a strong tradition in this field, we supply products with superior fatigue and wear resistance.



Oil and Gas

The oil and gas market is no stranger to hard conditions. When combining our portfolio, the oil and gas business can benefit from improvements to critical components.

Railway

Our wide range of products supports applications from track to train. Strict demands, whether for railway clips or high speed train bearings, are met.



Windpower

Ovako's steel cleanliness meets the demands of wind turbine applications such as gearboxes, transmissions, fasteners and bearings. Fatigue life is essential for low maintenance cost.

OUR HIGH PERFORMANCE STEELS

As the leading provider of the highest quality engineering steel, customers around the world depend on Ovako for a high degree of operational reliability and efficiency. We are dedicated to providing outstanding know-how and support, and to developing steels that can give you a real competitive edge. Furthermore, we have now made it easier for our customers to match the right Ovako product to their unique requirements. We have classified our steel performance into straightforward groups to make it simpler for you to navigate our offering, and therefore make it easier for you to do business with Ovako. This is where our five attribute brands come into play:



BQ-Steel
Bearing Quality

IQ-Steel
Isotropic Quality

M-Steel
Machinability

WR-Steel
Wear Resistant

SZ-Steel
SubZero Steel



W 20 P

SWEDEN

PURITY CREATES DESIGN OPPORTUNITIES BQ-STEEL® AND IQ-STEEL®

BQ-Steel (Bearing Quality) is a bearing quality clean steel whereas IQ-Steel (Isotropic Quality) is an isotropic quality ultra clean steel. They are both optimized for fatigue strength by a strict control of steel cleanliness. BQ-Steel is also ideal for new design solutions in a wide array of demanding applications outside the bearing industry that require longer performance and higher loads. IQ-Steel is a smart solution for designing reliable components that can take the strain from higher and more complex loads. It offers uniform and excellent properties in all loading directions.

The extended performance, higher loads and high cleanliness of BQ-Steel are a result of the Ovako clean steel program. Purity of production means that the material has significantly smaller inclusions compared to conventional steel and, as a result, the fatigue strength of the steel is increased dramatically. Use of the material allows components to be manufactured in smaller sizes.

IQ-Steel, a further development of BQ-Steel, is an isotropic and ultra clean steel with properties that match remelted steels. Based on thousands of examinations by Ovako into the effects of defects on fatigue performance, the metallurgy of IQ-Steel is purer and far more consistent than conventional grades, and designed specifically to perform well in multiaxial loading. This enables the manufacturing of lighter, slimmed down components like gears, bearings and other critical parts. The steels are helping our customers to achieve new design solutions and implement higher standards of finished product performance.

Key to these practical advantages are Ovako's own unique, clean and consistent modern steelmaking processes that remove harmful inclusions and impurities from within the steel. IQ-Steels contain smaller and more fragmented inclusions and can handle much higher mechanical forces in all directions than conventional steels.

Enhancing processes and saving costs

BQ-Steel has, for decades, been the problem-solver in the bearing industries. The same approach to fatigue performance is now being applied in many other applications. IQ-Steels are newer, but already now well-established in high pressure automotive applications. Modern diesel engines, with high and cyclic injection pressures, have proven to be an ideal application. Transmission components are another emerging area of strong interest.



BQ-STEEL® – BEARING GREATER LOADS, REDUCING COSTS

Component downsizing and increased loading are both issues facing manufacturers today as space restrictions and lower operating weight are driven by energy conservation. Ovako's new generation of bearing quality steel, BQ-Steel, is optimised and well-proven in applications where fatigue strength is critical, allowing component manufacturers to rethink their design solutions.

High strength through hardening and high fatigue resistance through steel cleanliness facilitate the manufacture of components to meet the requirements of today and tomorrow. This is true for a wide range of industries where high cyclical loading is an issue.

Factors affecting fatigue

Steel quality can have a tremendous impact on the fatigue life of a component. This is brought about by the distribution and size of non-metallic inclusions within the steel. In the case of conventional steel these inclusions can be as large as 100 µm and quite densely packed. As varying loads are applied these large inclusions initiate fatigue cracks, leading to material failure. Continuous research and development by Ovako over many years saw the introduction of a clean, bearing quality steel with inclusions typically less than 20 µm. Correspondingly, the fatigue strength of BQ-Steel falls between 600 to over 800 MPa, depending on loading direction, while that of conventional steels falls between 300 to 500 MPa, see Figure 1.

The rolling direction has a strong influence on fatigue properties for most steels. BQ-Steel is no exception, see Figure 2. For an improved isotropic performance we recommend IQ-Steel instead.

For the development of these steels, it has been critical to develop the methodology for qualifying steel cleanliness. One useful approach is immersed ultrasonic testing, which very visibly and quickly can show material defects within the tested material, see Figure 3.

New design opportunities

Unique analysis of the influences of defects in steel utilising scanning electron microscopes has allowed Ovako to build an extensive database invaluable in the development of clean steel. The resulting fatigue performance provides opportunities for manufacturers to rethink design solutions, allowing weight reductions of a component through an increased power density.

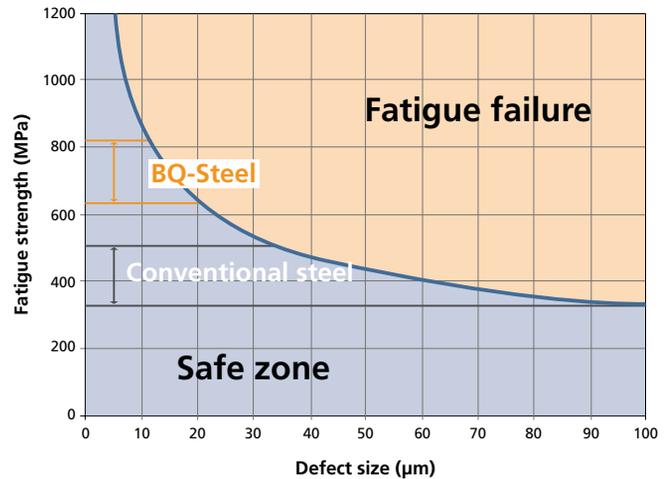


Figure 1. Fatigue strength of engineering steels vs. defect size.

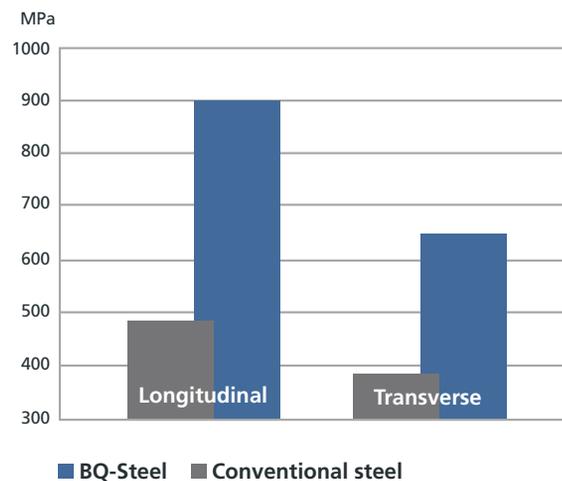


Figure 2. Rotating bending fatigue results longitudinal and transverse to rolling direction. Conventional steel vs. BQ-Steel.

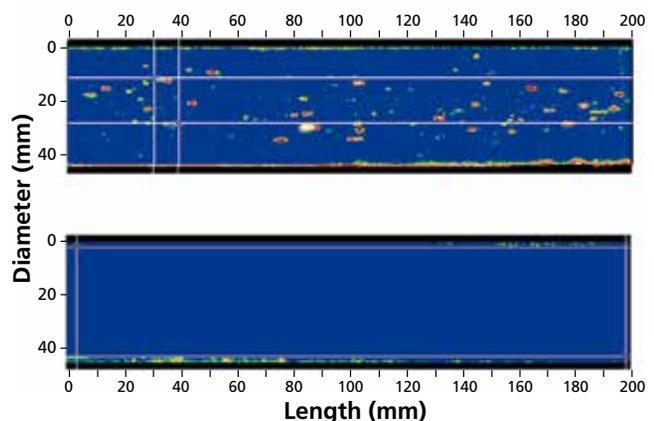


Figure 3. Immersed ultrasonic testing at 10 MHz of 65-mm bars in conventional steel. The coloured areas are material defects within the assessed volume.

IQ-STEEL® – UNIFORM AND EXCELLENT MULTIDIRECTIONAL PROPERTIES

Ovako is increasingly hearing from our customers that conventional steels are no longer suitable for tougher jobs. Fatigue strength is severely limited in conventional steels, see Figure 4. A specific problem is that many steel components are not able to handle cyclical loading in multi-axial directions well enough. The solution, so far, has been to increase dimensions. Further downsizing and increased stresses will accentuate these problems even more in the future, along with the need to handle the strain of even higher and more complex loads.

The reason for this over-sizing is the production of conventional steels in processes where non-metallic inclusions are stretched and elongated in the rolling direction. Based on decades of continual fatigue research and an extensive database of compiled fatigue data, Ovako has developed a detailed understanding of the correlation between defect size and fatigue strength performance. The elongated inclusions have an important impact on the mechanical properties of any component by destabilising the steel metallurgy, compromising fatigue strength and initiating cracking. Inclusions must therefore be minimised.

In contrast, IQ-Steels, with exceptional cleanliness, are designed to perform differently to conventional steels. With a higher degree of purity, smaller and much less elongated inclusions, IQ-Steels exhibit better isotropic behaviour after rolling, see Figure 5. They can be used to manufacture more reliable components with uniform and excellent properties, which handle movement in all directions, not only in the rolling direction.

Increased lifetime of the component

Fatigue and its effects on the lifecycles of steel components are pressing concerns for Ovako customers. The accelerating drive for improved performance must be matched by the properties of the material. IQ-Steel provides opportunities because, in contrast to conventional grades, it can handle higher and more complex strains and loads over longer periods. This is a further reason why some of the world's most quality-oriented original equipment manufacturers already use IQ-Steel. In fact, through the combination of the IQ-Steel properties and an alloying to optimise surface structure after carburising, see Figure 6, it is often possible to eliminate processes such as shot peening.

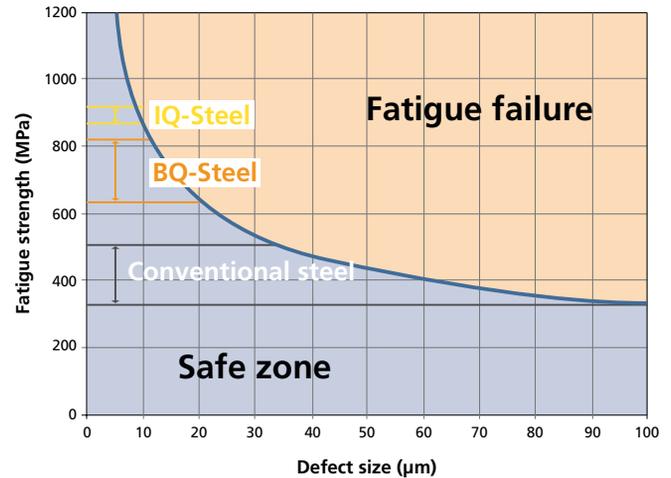


Figure 4. Fatigue strength of engineering steels vs. defect size.

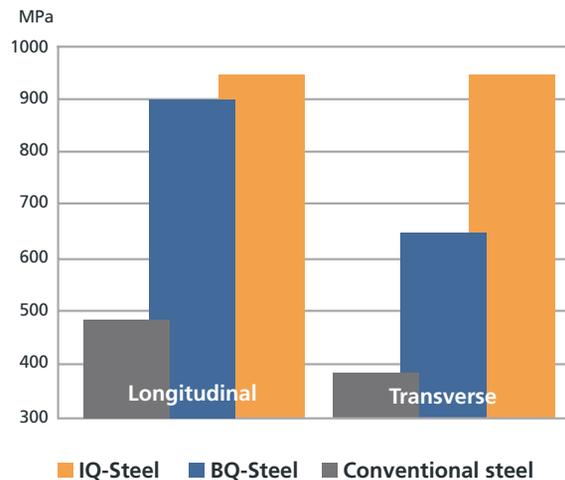


Figure 5. Rotating bending fatigue results longitudinal and transverse to rolling direction. Conventional steel vs. BQ-Steel vs. IQ-Steel.

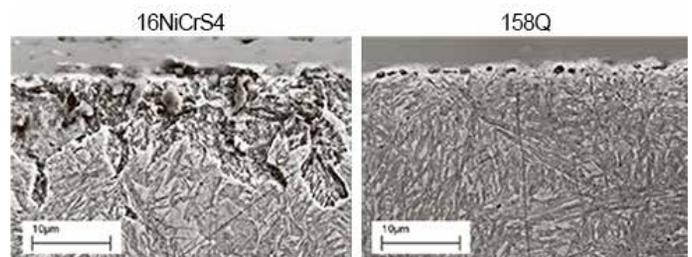


Figure 6. Surface structure of standard steel 16NiCrS4 (Ovako 146) compared to Ovako 158Q after gas carburising.

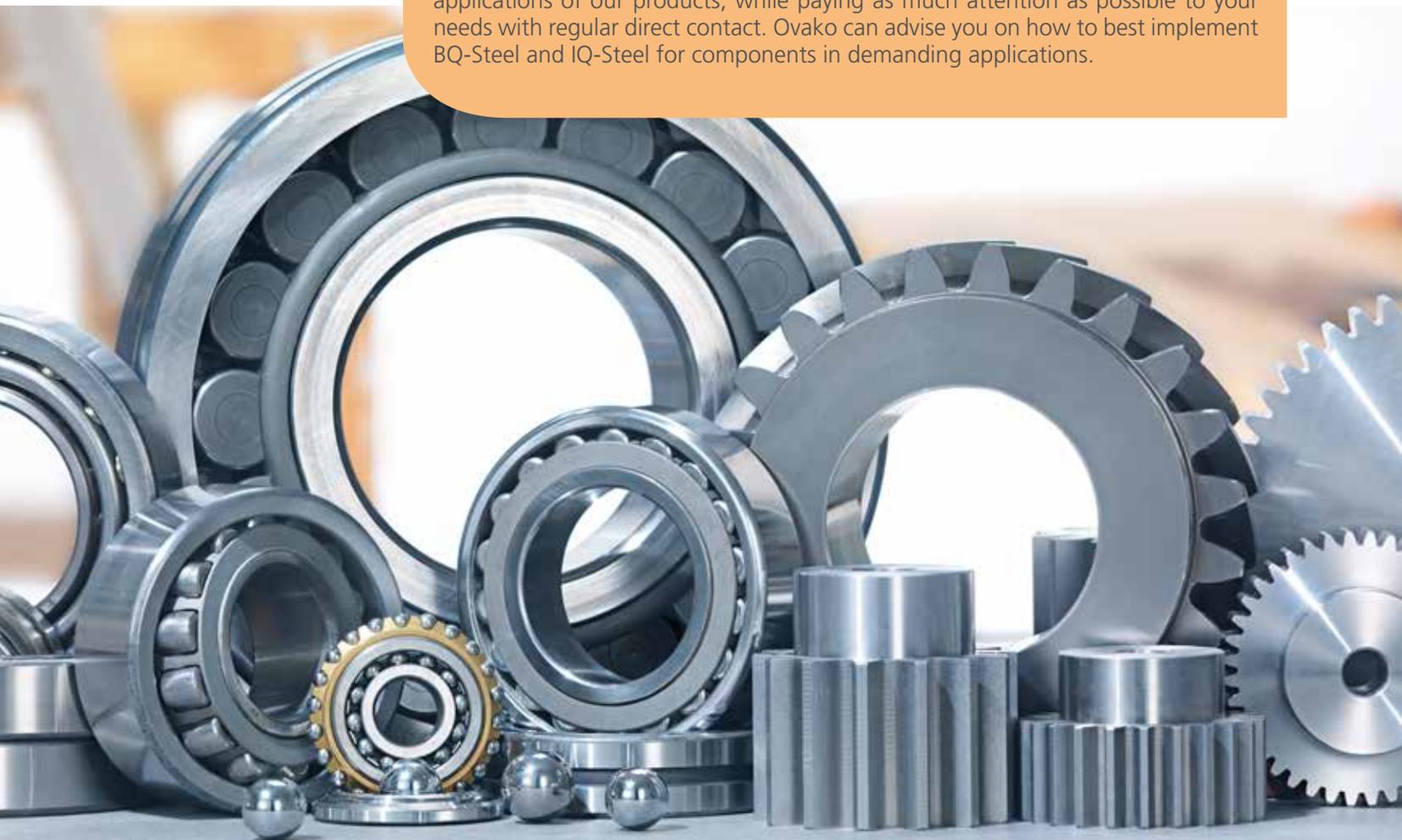
Advantages of BQ-Steel and IQ-Steel vs. conventional steel

Advantages	BQ-Steel typical effects	IQ-Steel typical effects
Improved bending fatigue strength in simple load cases	30–90% stronger depending on steel used today	40–100% stronger depending on steel used today
Improved bending fatigue strength in multiaxial load cases	Up to 70% stronger depending on steel used today	Up to 130% stronger depending on steel used today
Typical application of weight reduction	Existing generations of end-user systems	Next-generation end-user systems
Typical design change possibilities	Moderate design adjustments on existing generations of end-user systems	Facilitates major design changes on next-generation end-user systems
Enhanced macroscopic defect control via immersion ultrasonic testing	Secures consistent quality level for end-user products	Secures consistent quality level for end-user products

Ovako customer service

The BQ and IQ processes can be applied to all our steel grades. We can work closely with customers to optimise the steel supply chain to meet your requirements, including multiple product packages. The material is available in tubes, bars and rings.

All of our services are underpinned by a detailed understanding of the industrial applications of our products, while paying as much attention as possible to your needs with regular direct contact. Ovako can advise you on how to best implement BQ-Steel and IQ-Steel for components in demanding applications.



TYPICAL BQ-STEEL GRADES

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
Ovako 152	20NiCrMo2-2		0.2	0.3	0.9	0.6	0.2	0.5	
Ovako 245	12NiCr14-6F		0.1	0.3	0.5	1.5	0.1	3.3	
Ovako 326	42CrMo4		0.4	0.3	0.8	1.1	0.2		
Ovako 355	40NiCrMo7-3F	SAE 4340 modified with V	0.4	0.3	0.7	0.8	0.3	1.8	V
Ovako 677	67SiMnCrMo6-6-4F	Bearing steel suitable for gas/air hardening	1.0	1.5	1.4	1.0	0.2		
Ovako 803	100Cr6	The most widely used bearing steel with a hardenability for small components (wall thickness 17 mm)	1.0	0.3	0.3	1.4			
Ovako 824	100CrMo7	Increased hardenability with Cr and Mo for small- and medium-sized components (wall thickness 20 mm)	1.0	0.3	0.3	1.7	0.2		
Ovako 825	100CrMo7-3	Increased hardenability with Cr and Mo for medium-sized components (wall thickness 30 mm)	1.0	0.3	0.7	1.7	0.2		
Ovako 826	100CrMo7-4	Increased hardenability with Cr and Mo for medium- and large-sized components (wall thickness 50 mm)	1.0	0.3	0.6	1.7	0.4		
Ovako 827	100CrMnMoSi8-4-6	Increased hardenability with Cr, Mo and Si for large-sized components (wall thickness 75 mm)	1.0	0.5	0.9	1.9	0.6		
Ovako 831	100CrMnSi4-4	Increased hardenability with Cr, Mn and Si for small- and medium-sized components (wall thickness 20 mm)	1.0	0.6	1.1	1.0			
Ovako 832	100CrMnSi6-6	Increased hardenability with Cr, Mn and Si for medium-sized components (wall thickness 40 mm)	0.9	0.7	1.5	1.4			
Ovako 837	100CrMnSi6-4	Increased hardenability with Cr, Mn and Si for small- and medium-sized components (wall thickness 30 mm)	1.0	0.6	1.0	1.4			

TYPICAL IQ-STEEL GRADES

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
Ovako 158	20NiMo9-7F	Steel giving reduced surface oxidation after gas carburising	0.2	0.1	0.3	0.4	0.7	2.3	
Ovako 159	18CrNiMo7-6	Carburising steel used for bearing and transmission components	0.2	0.2	0.7	1.7	0.3	1.6	
Ovako 255	18NiCrMo14-6	High hardenability carburising steel	0.2	0.3	0.5	1.4	0.2	3.3	
Ovako 277	16CrMnNiMo9-5-2F	Steel suitable for carburising and nitriding. Possible to gas/air harden	0.2	0.2	1.3	2.1	0.5	0.5	V
Ovako 398	32CrMoV12-10	Steel suitable for deep nitriding	0.3	0.3	0.5	3.0	1.0	0.3	
Ovako 499	30MoCrV20-7F	Temperature resistant carburising steel	0.3	0.2	0.3	1.7	1.8		V
Ovako 497	42NiSiCrMo8-7-3F	High-strength, high-toughness steel known as 300M	0.4	1.6	0.6	0.7	0.3	1.7	V
Ovako 498	30NiCrMo16-6	High-strength, high-toughness steel	0.3	0.3	0.5	1.4	0.2	4.0	
Ovako 528	50CrMo4		0.5	0.2	0.7	1.0	0.2		
Ovako 593	51CrV4		0.5	0.3	0.9	1.1			V
Ovako 677	67SiMnCrMo6-6-4F	Bearing steel suitable for gas/air hardening	1.0	1.5	1.4	1.0	0.2		
Ovako 803	100Cr6	The most widely used bearing steel with a hardenability for small components (wall thickness 17 mm)	1.0	0.3	0.3	1.4			
Ovako 824	100CrMo7	Increased hardenability with Cr and Mo for small- and medium-sized components (wall thickness 20 mm)	1.0	0.3	0.3	1.7	0.2		
Ovako 825	100CrMo7-3	Increased hardenability with Cr and Mo for medium-sized components (wall thickness 30 mm)	1.0	0.3	0.7	1.7	0.2		

This is a selection of our standard program. IQ-Steel can be applied to all our steel grades.

* Designation followed by "F" is not an official EN standard grade but named according to the rules in EN 10027.



M-STEEL® MACHINE LESS, MAKE MORE

M-Steel is a low alloyed, or non-alloyed, M-treated steel that is the ultimate choice when you need superior machinability combined with exceptional toughness and fatigue strength. It has proven its ability to achieve significant reductions in machining costs for component manufacturers which have replaced conventional steel with M-Steel. M-Steel enables higher cutting speeds and improved efficiency. Tests show that M-Steel can reduce machining costs by 30–40 %, significantly boosting profitability.

In a highly competitive world, maximum utilisation of machining equipment is vitally important as is the time taken to produce each single component. Tool life and operational efficiency are also factors that have an impact on a business's profitability. With cutting speeds up to 30% faster than conventional steel, M-Steel meets market demands for lower processing costs. In many circumstances the tool life span can be more than doubled when machining components from M-Steel. This not only saves on the actual machining time, but also reduces the true cost per component.

The M-Steel concept

Our M-Steel treatment can be applied to any steel grade. The basis for the concept is that non-metallic inclusions are modified and controlled with calcium treatment. These inclusions are modified in a way to maximise machinability and to improve transverse fatigue strength. In this way, a protective layer is formed on the cutting tool during machining that very significantly reduces the wear on the tool and increases the tool life. At every stage of the M-Steel production process the material is optimised to improve machinability, from raw material through melt, to casting, hot rolling and the final heat treatment. Individual delivery requirements can be met to supply your material in the best form for your machines in compliance with tight straightness and dimensional tolerances. M-Steel has a consistent machinability from cast to cast, meaning that machines can be run with fixed high cutting rates and predictable tool change intervals from one production run to another.

Advantages of M-Steel

- Reduced machining costs
- Faster throughput by up to 30%
- Zero production interruptions
- Less resetting – fewer tool changes
- Longer tool life
- Increased production capacity

How much can you save?

By replacing conventional steel with M-Steel it is possible to lower machining costs by 30–40%, boosting both your productivity and profitability. This is down to M-Steel's ability to facilitate faster run times through higher cutting speeds, more predictable and longer tool lives, and easier chip formation. More than 400 customers have already proven the manufacturing advantages of M-Steel, achieving significant reductions in machining costs for component manufacture.

Recent findings also show that the M-Steel effect is particularly pronounced in turning in very hard condition using Cubic Boron Nitride (CBN) inserts. Replacing traditional grinding of case- or induction-hardened surfaces with Hard Part Turning can mean very large cost savings, together with production lead time and quality improvements.

M-STEEL® – DURABILITY YOU CAN COUNT ON

A key part of the M-Steel process is the modification and control of non-metallic inclusions with calcium treatment, important steps in secondary metallurgy which affect the composition and inclusion structure, as well as heat treatment.

Fine-tuning the process

Hard, non-metallic inclusions in conventional steel cause considerable wear of the machine tool, but in M-Steel these are transformed into safer, calcium-contained inclusions that are softer. They even create a beneficial protective layer between the tool and the chip interface during machining. Additionally, the sulphur content is optimised to achieve the best possible machinability. All of this is done in a way to balance performance vs. other properties, such as hardenability, impact toughness, tensile and fatigue strength.

Figure 1 illustrates how M-Steel compares with two conventional steels with regard to the life of inserts used at the same machining parameters. Figure 2 shows a customer example of a number of items completed with the same insert, comparing M-Steel with three conventional steels. Figure 3 shows the remarkable difference in tool wear between M-Steel and conventional steel.

Tailored to your requirements

M-Steel is available in a wide range of standard dimensions as round and square bars. Alternatively the material can be supplied to customers' requirements, even with tight dimensional tolerances. It can be supplied cut-to-length to fit the specific needs of individual machining centres.

Select your M-Steel

M-Steel high-quality, low-alloy engineering steels with improved machinability are available in a range of steel grades with bars sizes from 20 mm up to 200 mm and square bars up to 150 mm. A selection of popular grades is given in the table on the next page.

Test of wear on turning inserts

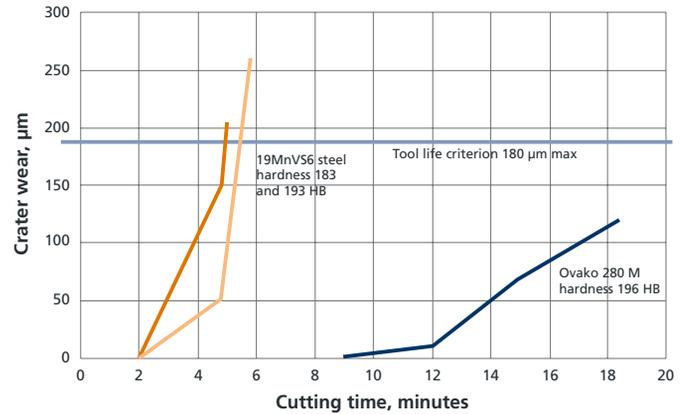


Figure 1. Wear on turning inserts when comparing M-Steel with two conventional steels of the same steel grade. Cutting speed 380 m/min.

Shaft turning: single insert

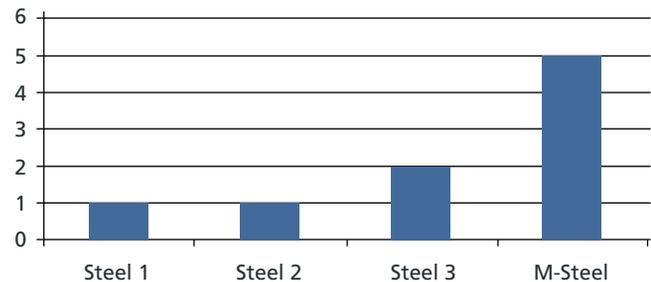
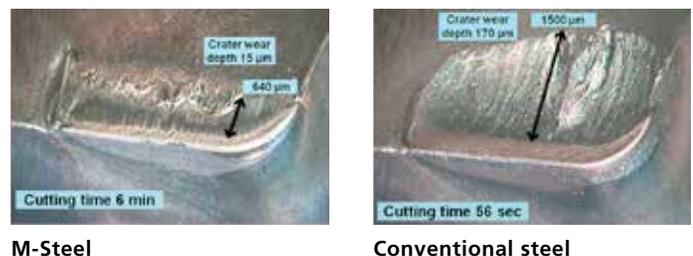


Figure 2. Number of machined items using the same insert, comparing M-Steel with three conventional steels.

Crater wear comparison



M-Steel

Conventional steel

Figure 3. Crater wear comparison between M-Steel and a conventional steel.

TYPICAL M-STEEL GRADES

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
CN 110 M	16NiCrS4	Good toughness, controlled hardenability, good machinability	0.2	0.2	0.6	0.8		1.0	
Green Cut	11SMn30	Lead-free cutting steel	0.1	0.2	1.2				S
Hydax 15	S355J0	A low-carbon, high tensile strength structural steel which can be readily welded to other weldable steel	0.1	0.4	1.3				S
Hydax 25	20Mn5F	High temperature constitutional weldable steel	0.2	0.4	1.3				S
Imacro M	5CrMn16-4F	Suitable for gas/air hardening	0.1	0.3	1.0	4.0			Nb
IMANITE M	21CrMoV5-7F	Steel suitable for nitriding	0.2	0.3	0.6	1.4	0.7		V
Imatra 4M	C45E	Steel suitable for cold working and quenching and tempering	0.5	0.3	0.7				
Imatra 520	S355J2	A low carbon, high tensile strength structural steel which can be readily welded to other weldable steel	0.1	0.3	1.2				
MC 110 M	16MnCr5	Ingot cast steel used for small-sized components	0.2	0.2	1.2	1.0			
MC 212 M	20MnCr5	Alloyed case-hardening steel with good wear resistance	0.2	0.2	1.3	1.2			
MoC 210 M	25CrMo4	High toughness and good weldability. Suitable for heat treatment	0.3	0.2	0.9	1.1	0.2		
MoC 310 M	34CrMo4	Steel suitable for cold heading	0.3	0.3	0.8	1.1	0.2		
MoCN 315	34CrNiMo6	Steel for high strained automotive and motor construction components. Suitable for heat treatment	0.3	0.2	0.7	1.4	0.2	1.3	
MoCN206M	20NiCrMo2-2	A high cleanliness steel used for small-sized bearing and transmission components	0.2	0.3	0.9	0.6	0.2	0.5	
Ovako 280 M	19MnVS6	A low carbon, high tensile strength structural steel which can be readily welded to other weldable steel	0.2	0.4	1.5				V
S355J2 SBM	S355J2	A low carbon, high tensile strength structural steel which can be readily welded to other weldable steel	0.1	0.3	1.2				

This is a selection of our standard program. The steel grades above can all be made as BQ-Steel, IQ-Steel or M-Steel.

** Designation followed by "F" is not an official EN standard grade but named according to the rules in EN 10027.*

Ovako Customer Service

We work closely with our customers, advising on cutting data recommendations, choice of tools and quality assurance through machining tests to ensure the correct material grade and dimensional characteristics are selected for a given application. M-Steel is available in a wide range of standard dimensions as round and square bars. Alternatively the material can be supplied to customer's requirements in compliance with tight dimensional tolerances. It can be supplied cut-to-length to fit the specific needs of individual machining centres.



WR-STEEL®

WEAR RESISTANCE

FOR YOUR ADVANTAGE

WR-Steel, which stands for wear-resistant steel, includes a broad range of grades with a wide range of hardness levels, dimensions and steel grades designed to give you a wear-resistant advantage when making products exposed to a high degree of wear and where service life is important.

The whole idea is to combine cost efficiency at the manufacturing stage with just the right wear resistance in your end product. The WR-Steel mission is to optimise the wear resistance of your products and, at the manufacturing stage, give you the flexibility you want to be able to form, shape and weld the steel to fit your engineering needs precisely. With three main metallurgies of billets, blooms and ingots, the WR-Steel product range is the broadest of its kind in Europe and includes more than 30 different types of boron steel and special grades for mining applications.

Over 680 special profiles supplied close to net shape are available alongside many different sizes of hot-rolled round and flat bars and grinding media. All products cover a wide range of hardness levels, in order to be flexibly tailored to your needs.

Customised heat treatment

No two heat-treating facilities or forging shops have exactly the same needs. You might be overseeing a highly automated operation where furnace temperatures and quenching times are all pre-set by a computer. Or maybe you are at a more traditional shop where the skill and experience of the staff is something you are known for in providing a superior steel end product. Either way, you depend on a consistent level of quality to get the same high-quality hardening result – batch after batch. Ovako's range of WR-Steels is characterised by the steel's consistent quality, tight process controls and good repeatability.

Advantages of WR-Steel

- Proven superior wear resistance
- Broad range of hardness intervals (350–650 HV)
- Right properties after rolling or heat treating
- Cost-effective due to optimised alloy content for different end applications
- Wide range of steel grades in different dimensions

Ovako as your technical partner

With a centuries-old steelmaking heritage and decades spent innovating boron steels, Ovako works closely with customers in the development and supply of specialised steel alloys. We can offer advice on applying the diverse WR-Steel program that is available for demanding applications and we fully understand how alloying and heat treatment steps can boost your productivity and help you to achieve just the right hardening properties.



WR-STEEL® – WEAR RESISTANT

Service life

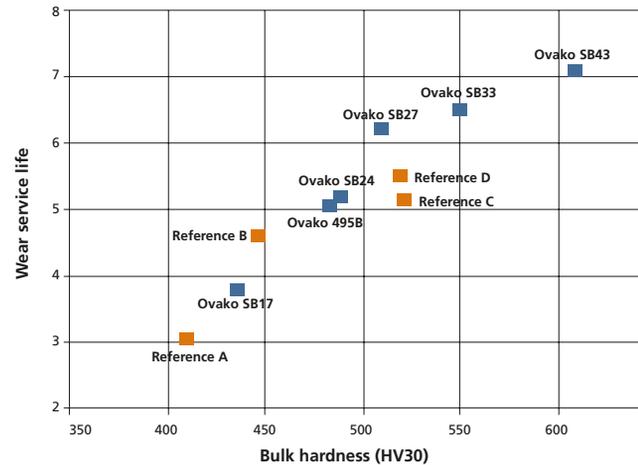
By choosing the correct WR-Steel you can prolong your service life. Longer service lifecycles mean fewer parts replacements, greater work efficiency and, ultimately, cost-reductions. Rather than just promising you that our WR-Steel grades can save money by extending your service life, Ovako turned to the independent Swerea KIMAB test facility to simulate extreme industrial conditions and see how we measure up against other hardening and pre-hardened steels.

Savings across your operations

The product forms in which we can supply WR-Steels eliminate or minimise time-consuming fabrication steps. You can choose from a diverse range of hot-rolled round and flat bars or special profiles that are close to net shape. Furthermore if you need to punch, drill or shape a WR-Steel component then it may be advantageous to do this in the steel's soft condition in order to minimise tool wear and tear.

Processing benefits of WR-Steel

Advantages	Typical effects
Flexible choice	Many sizes of hot-rolled flat bar and round bar with > 680 special profiles and growing
Consistent quality	No variations from batch to batch due to even steel quality and rigorous process controls
Easier to shape and mold	Softer steel prior to quenching and tempering due to low level of alloying elements that impair cold formability
Saves time; more efficient	Eliminate costly and time-consuming advanced machining by using our hot-rolled bar or close-to-net-shape special profiles
Energy savings	Less costly due to lower tempering temperature; many boron steels can be water quenched
Save your tools	Ease of machining of softer material helps to reduce tooling costs
Easier to weld	Favourable weldability due to low carbon content and lower amounts of alloying elements



Wear service life = Total accumulated weight reduction of reference grade (mild steel)/accumulated weight reduction of the corresponding grade.

Figure 1 shows the results from a simulation of industrial abrasive sliding wear, which provides a good relative performance indicator for prolonging service life.

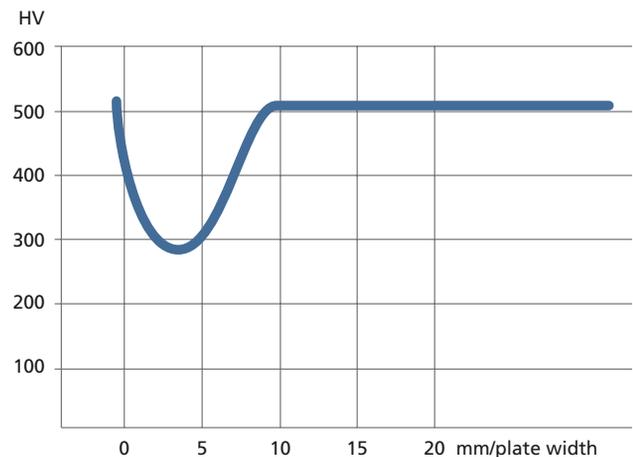


Figure 2 shows how the hardness profile from a gas cut edge declines significantly around the edge of the plate where the cut occurs. This can be avoided with WR-Steel in the form of hot-rolled bar or special profiles that require less cutting where wear resistance is critical.

TYPICAL WR-STEEL GRADES

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
SB24M13B	24MnB5F	Steel suitable for quenching and tempering. Very good forming properties in the soft delivery state and high strength after hardening	0.24	0.3	1.3				B
SB27M12CB	27MnCrB5-2	Boron alloyed heat treatable steel for wear resistant parts such as dredger buckets, plough shares, chain wheels, mechanical engineering components, axles	0.27	0.2	1.3	0.5			B
SB30M12CB	30MnCrB5-2F		0.30	0.3	1.3	0.5			B
SB33M13B	30MnB5	Steel for wear resistance in thickness <15 mm	0.30	0.2	1.3				B
SB33M13CB	33MnCrB5-2	Boron alloyed steel suitable for quenching and tempering	0.33	0.3	1.3	0.6			B
SB43M14B	43MnB6-3F	Boron steel for general purposes without any specified mechanical properties. SB43M14B has the highest level of hardness and wear resistance achievable in the standard range of boron steels. Therefore is it an excellent choice for use in machine knives and garden tools	0.43	0.3	1.4				B
Ovako 495	48CrMoNi4-10F	Ovako 495 is a high strength quench and tempering steel with high wear resistance, good toughness and good dimension stability. The steel can be tempered at high temperatures and still maintain a high hardness and high strength. It is micro alloyed to obtain a precipitation hardening effect	0.48	0.2	0.8	1.1	0.9	0.4	V

* Designation followed by "F" is not an official EN standard grade but named according to the rules in EN 10027.

Ovako as your technical partner

We work closely with our customer in the development and supply of specialised steel alloys. We can offer advice on applying the diverse WR-Steel program that is available for demanding applications and we fully understand how alloying and heat treatment steps can boost your productivity and help you to achieve just the right hardening properties.



SZ-STEEL®

SUB-ZERO PERFORMANCE

SZ-Steel, which refers to sub-zero temperatures, is a family of steel that has proven to retain properties for safer and more reliable performances in temperatures down to -40°C and below. The impact toughness of the steel is a key factor in creating reliable solutions in cold climates, especially in applications where a high-strength steel would be the best design solution. The family of SZ-Steel from Ovako has been optimized to allow the impact strength required at high strength levels and low temperature applications.

SZ-Steel is Ovako's response to the need for an easily identifiable material that has the capability to endure harsh winter climates. The "SZ" stands for both the obvious Sub Zero, but also Safety at temperatures far below Zero degrees (C or F). "Safety" comes from a good impact toughness at really low temperatures using steels with mechanical strength at the designed high levels.

MECHANICAL TESTING AND IMPACT TOUGHNESS

A tensile test shows at which force the material starts to enter the plastic deformation phase (yield strength) and at which force the material breaks (tensile strength).

To describe how a material behaves when it is subjected to sudden impact loads, a pendulum machine, with defined arm length, weight and geometries of the head, is used. The pendulum is let go from a defined height and hits a sample of the steel. The measurement is then the energy that the steel sample absorbs when the pendulum hits the sample. Steel behavior at different temperatures is investigated using the Charpy method. These tests show a behavior in steel seen in figure 1.

All steels exhibit this behaviour with a ductile zone at higher temperatures, and a brittle zone at lower ones, with a step-like change between called the transition zone. The temperature defining the middle of the transition is called the transition temperature. Ovako has testing equipment that complies with international standards at each site producing SZ-Steel, which, at the extreme, will test stud bolt materials at -101°C .

Advantages of SZ-Steel

- Enables the application of high strength solutions at sub-zero temperatures
- Enables design that creates safety for workers, service crews and the environment
- Retains key material properties and offers reduced risk of embrittlement and fracturing
- Meets key global safety standards

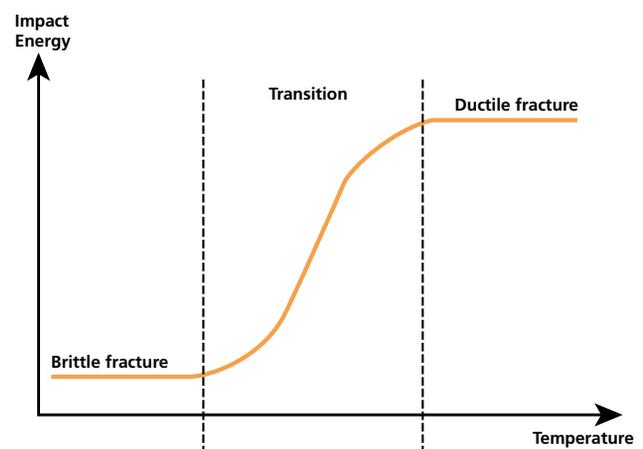


Figure 1. Curve showing transition from brittle to ductile fracture with increasing temperature..

Ovako R&D delivers for the future

To gain and maintain toughness you have to take into account a number of parameters such as structure, grain size, impurities and alloying. For a steel to be designated a SZ-Steel we have to secure our control of all these parameters. We are aiming even higher, however. We are moving to better measure and understand the fracture in order to really define whether it is ductile or brittle. To achieve this we measure the total impact fracture process. What we then see is something that looks very similar to tensile testing, although we are actually measuring when the fracture shifts from ductile behaviour to more brittle behaviour. See figure 2.

SZ-Steel combined with IQ-Steel

In conventional steels there are non-metallic inclusions elongated in the rolling direction of the steel. As standard, the sampling of material for mechanical testing is along the rolling direction, the direction least influenced by these inclusions. When the sampling is instead carried out transverse to the rolling direction, the properties will show a different behaviour, a negative difference with much lower values. If we combine the SZ-Steel with an IQ-Steel treatment we can minimise the influence of these nonmetallic inclusions as the IQ-Steel has fewer and much more uniform inclusions. The result can be seen in figure 3.

To better understand the practical need for this, the load case must be clarified. In many mechanical constructions the load is distributed along the length, e.g. along a bar. This gives us a so-called 2-dimensional load case. However when there is a so called 3-dimensional load case, as in a hydraulic cylinder, the transverse impact strength has to be considered too. The load is then both in the longitudinal direction with the forces of the cylinder acting to both extend and retract the piston. While the hydraulic liquid not only pushes the piston head along the cylinder it also acts on the cylinder ID with the same force. This radial force is transferred to a transverse force in the cylinder wall. Hence transverse properties are needed as much as the longitudinal. See figure 4.

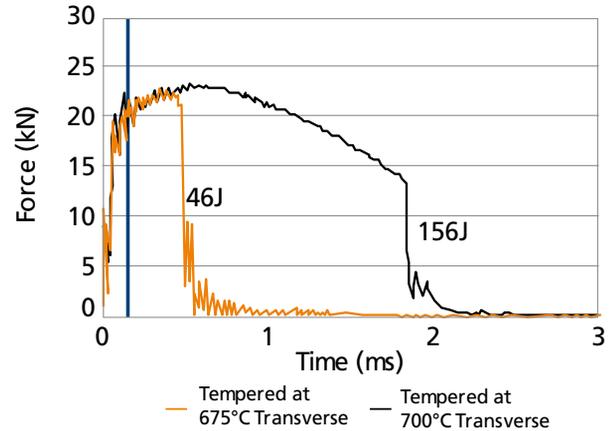


Figure 2. Energy absorbed during the impact testing of Ovako 277 with different structures resulting from tempering levels.

Charpy V – Impact strength of Ovako 277

at yield strength 650MPa

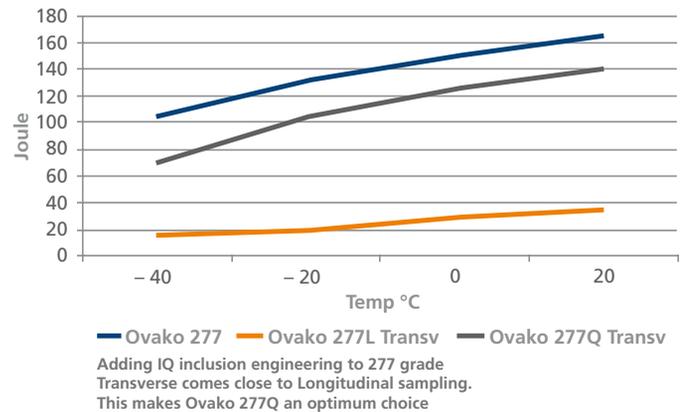


Figure 3. Impact strength of Ovako 277L and IQ-Steel version Ovako 277Q. The blue upper line is impact strength in the longitudinal direction for both versions.

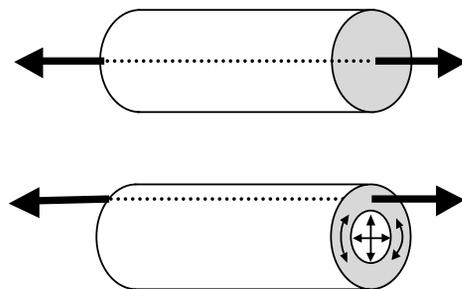


Figure 4
2- and 3-dimensional load cases.
Longitudinal forces form a 2-dimensional load in a solid bar
Longitudinal forces form a 2-dimensional load and transverse forces form an internal load, making it a 3-dimensional load case.

TYPICAL SZ-STEEL GRADES

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
Ovako 326	42CrMo4	Ingot cast	0.4	0.3	0.9	1.0	0.2		Al
Ovako 281	19MnVS6	Micro-alloyed steel with high tensile strength, good machinability and weldability. Suitable also for case hardening and nitriding. Good dimensional stability	0.2	0.4	1.5				V
Ovako 322	25CrMo4	Ingot cast	0.3	0.2	0.9	1.1	0.2		
Cromobolt	42CrMo6F	Conforms to the recommendations in ISO 898-1:2009 for fasteners 8.8 or 10.9 properties. Suitable for quenching and tempering	0.5	0.3	0.9	1.5	0.3		P
Imacro M	5CrMn16-4F	A weldable quenched and tempered steel with lath martensitic structure.	0.1	0.3	1.0	4.0			Nb
SB27M12CB	27MnCrB5-2	Boron alloyed heat treatable steel for wear resisting parts as dredger buckets, plough shares, chain wheels, mechanical engineering components, axels. Suitable for quenching and tempering	0.3	0.2	1.3	0.5			B
SB30M12CB	30MnCrB5-2F		0.3	0.3	1.3	0.5			B
Imatra L7	42CrMo4 (if Ø = 25–60 mm)	ASTM 320 L7 used mainly for applications within the oil-, gas- and chemical field where american standards are used	0.5	0.3	0.9	1.0	0.2		P
Ovako 520 M	S355J2		0.2	0.6	1.6	0.03			
23MnNiMoCr54	23MnNiMoCr54	Steels for welded round link chains and components	0.2	0.3	1.2	0.02	0.5	0.6	1.0
Ovako 277	16CrMnNi-Mo9-5-2F	Steel suitable for carburizing and nitriding. Possible for gas/air hardening	0.2	0.2	1.3	2.1	0.5	0.5	V

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Ovako customer service

Full technical advice on application suitability, mechanical data, batch production, material supply and logistics is available to customers.



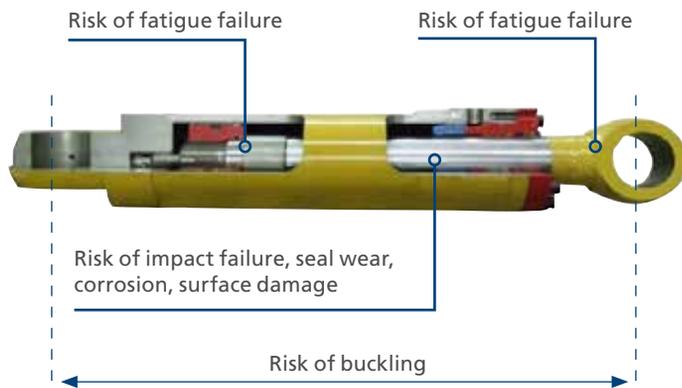
CROMAX® Hydraulic piston rod design

The diameter and the surface of the rod are important properties of piston rod material considering factors like fatigue risk, buckling and impact damage. The material should also contribute to efficient chrome plating, machining and minimized cost without weakening of the design.

Chrome-plated and nickel-chrome-plated bars and tubes are primarily used as piston rods in hydraulic cylinders.

The principal parameters in hydraulic piston rod design are:

- 1) Dimensioning against fatigue, buckling and impact failure
- 2) Tailoring the surface for low seal wear and limiting the risk of surface damage or corrosion



How to reduce cost and capital

The main driver of cost and capital is the diameter of the bar. The costs of material, handling and cutting increase with the weight of the bar while the cost of surface operations (machining, grinding, chrome plating etc.) increase with the surface area. As a result, the cost of a rod increases exponentially with the diameter.

As a general rule of thumb, the cost of a piston rod decreases by 15 % if the diameter is reduced by 5 mm. Other effects are less weight and reduced space requirements, which could translate into lower energy consumption and possibilities for alternative designs.

Advantages of Cromax

- Lowest cost to transmit a specific hydraulic force
- Enable new designs e.g., lower weight, less space and less energy consumption
- Surfaces to solve the corrosion-, impact- and seal wear challenge of any application

The Cromax offering combines materials, surfaces and services taking into account all parameters required to minimise the total cost and capital required. See figure 1.

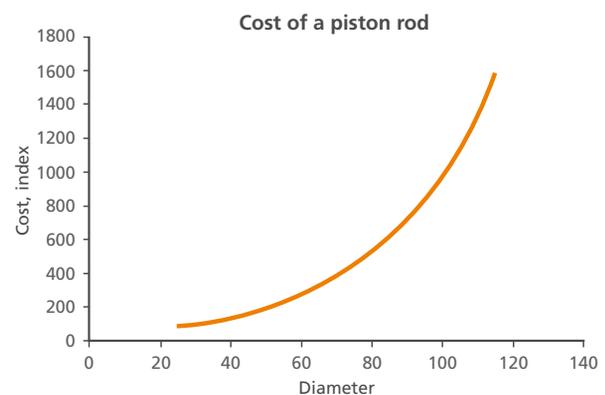


Figure 1. Cost of a piston rod as a function of the diameter

The steels used by Cromax have been developed specifically with the design and manufacturing process of piston rods in mind – they can be thought of as “piston-rod steels” in the same way as steels developed specifically for ball and roller bearing applications are called bearing steels and steels developed for springs are called spring steels.

High strength – lower cost

Hydraulic piston rods must be dimensioned against buckling, fatigue and impact failure.

The risk of buckling depends on the yield strength, the elastic modulus of the material and the geometry of the rod, as defined by the slenderness ratio. Generally speaking, the buckling stress at small slenderness ratios corresponds to the yield stress of the material and decreases with an increasing slenderness ratio to the extreme case where it becomes independent of yield strength. In practice, 70–80 % of all hydraulic cylinders are designed with low or moderate slenderness ratios (below 100) meaning that the yield stress of the material has an important influence in defining the required diameter of the rod for cylinders operating in conditions where there is risk for buckling.

However, a piston rod in many instances operates in a dynamic environment with push-pull forces and in which it will be susceptible to fatigue. Each rod has a unique fatigue limit and dimensioning is made on the basis of experience or through fatigue testing of finished piston rods or cylinders. All other things equal, fatigue strength increases with the tensile strength of the rod material. Guaranteed impact toughness might be considered in addition for safety critical applications.

Since the main cost driver is the diameter of the rod, the strength of the rod material is the main lever to reduce cost. Compared with the most commonly used material for hydraulic cylinder rods (C45E), the cost reduction potential by using stronger materials is of the order 20–30 %, see figure 2.

However, not all high-strength steels are suitable for piston rods. The main problems derive from the inherent impact of slag inclusions which intersect the surface and segregation at the centre of the rod. It is not unusual that chemical compositions, aimed at promoting strength or machinability, are the cause of problems in welding and friction welding in particular. Moreover, certain slag inclusions at the surface of the material will dissolve during the chrome-plating process and give rise to porosities which could translate into weaknesses in the chrome layer.

The true cost effect of different steel materials for a piston rod is complicated to assess, but a simple approach could be to first select several grades with sufficient impact toughness and suitable machinability/welding characteristics and then to choose the one which offers the lowest price per MPa of yield strength, see Figure 3.

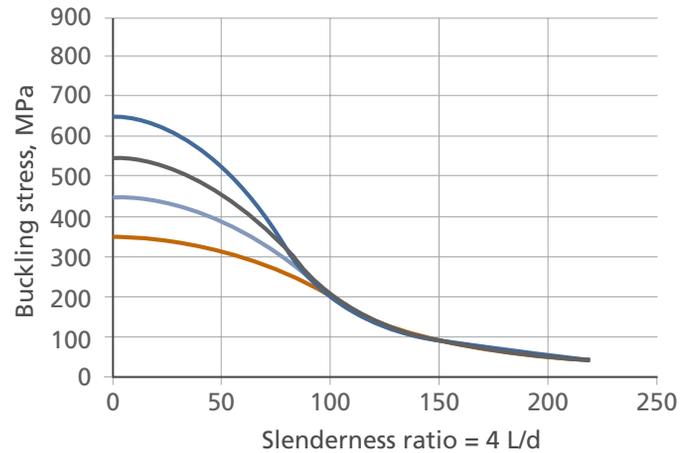


Figure 1 Buckling limit for materials with different yield strength as per ECCS and AISC.

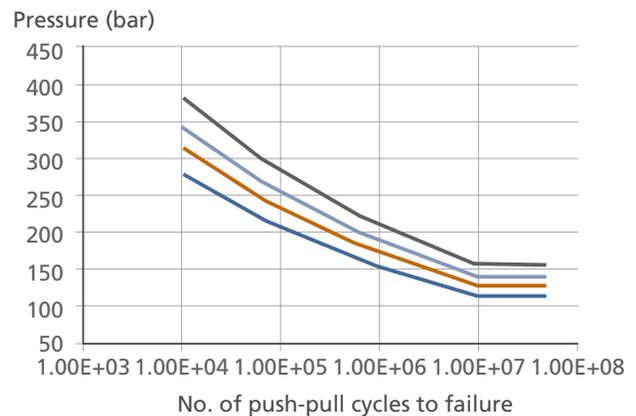


Figure 2 Fatigue limit for materials with different tensile strength.

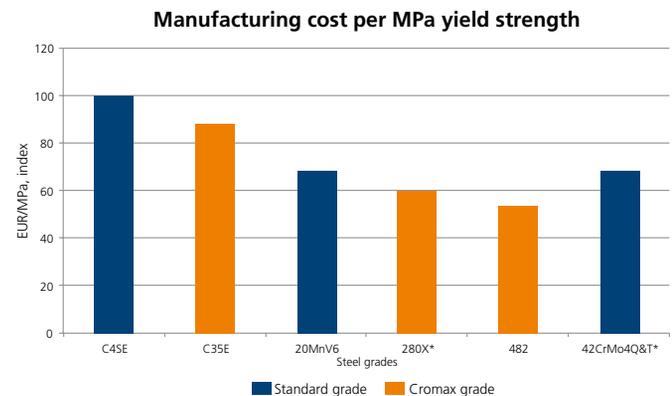


Figure 3 Cromax vs. standard steels expressed in EUR/MPa, C45E index 100. * Impact toughness guaranteed.

Right surface – lower cost

In order to minimize the cost to guarantee that the cylinder will last its economic life in different environments, Ovako can adapt the surface to meet the requirements, with minimum additional surface treatments and the thinnest possible layer of chrome or nickel-chrome.

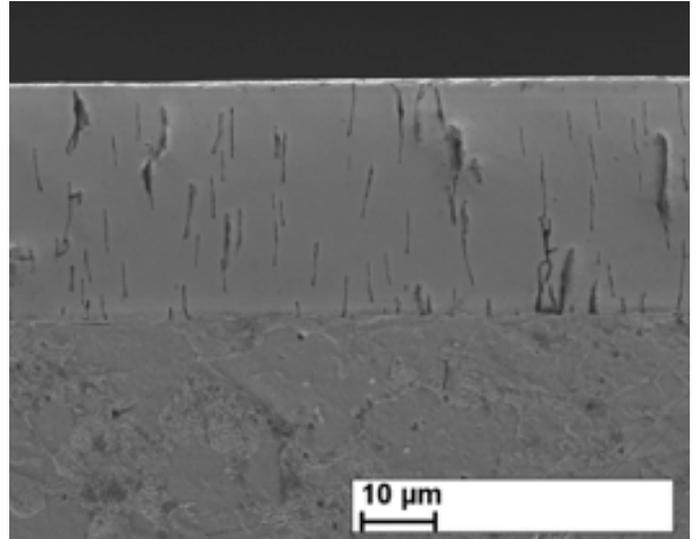
Plating with chromium is by far the most common surface treatment for piston rods. However, chromium has poor ductility and all chrome-plated layers have micro cracks which can permit the external environment to penetrate the layer and cause corrosion. Once the surface is penetrated, the corrosion process can be rather swift due to the combination of large cathode (the chromed surface) and small anode (the part of the steel in contact with the external environment).

The micro-cracks are prone to expand when the bar is used in the field and so the corrosion resistance of a chromed surface is temporary and is therefore mainly relevant during short periods of warehousing and transportation of cylinders and machines. The corrosion resistance in the field is mainly upheld by a film of hydraulic oil in modest environments.

Naturally, the protection of the oil film will cease if it is chemically or mechanically weakened or removed. In corrosive environments or in safety-critical applications exposed to risk of mechanical damage, chromium can be combined with an underlying layer of nickel. The nickel layer dramatically improves the corrosion resistance independent of the oil film and, due to its high ductility, maintains the corrosion properties in the field.

Another significant lever to reduce the cost of the piston rod is to minimize the thickness of the chrome or nickel-chrome layers. If the corrosive environment is modest, the ideal surface is normally the thinnest possible single or double layer of chrome to meet the required initial corrosion resistance.

In the case of corrosive environments in dry climate or in safety-critical applications exposed to risk of mechanical damage, the cylinder manufacturer must consider the oil film as providing insufficient corrosion protection and should select the thinnest possible combination of chrome and nickel to provide ample corrosion protection after multiple compressions.



Microscopic picture of a rod with a layer of chrome.

	Without loading	After 10 cycles of compression
Standard chrome	after 120 hours NSS 	after 24 hours NSS Loading = 10% yield stress 
NiKrom®	after 1,500 hours NSS 	after 1,500 hours NSS Loading = 50% yield stress 

A chromed bar and nickel-chromed bar after compression and corrosion test.

Cromax service concept

- Warehousing and cutting close to the customer.
- Machining and friction welding as add-on option.
- Reduced risk of supply-chain disruptions due to multiple Ovako units that can deliver the same product.



With the right steel, imagination is your only limit

There is an Ovako steel to suit almost every design and engineering challenge, no matter how extreme. Don't let your material limit your imagination. See the possibilities at ovako.com

OVAKO

ENGINEERING STEEL

At Ovako, we not only make high-quality steel products. Our priority is to find the best solutions for your requirements as your technical partner and collaborator.

Ovako is dedicated to working with you to help better understand your technical requirements and assist you in attaining sharp competitive advantages across your operations. You can gain our expertise, services and our infrastructure which are so crucial to controlling the purity, hardenability, machinability and lifecycles of our steels.

Ovako has total control of its production from melt to finished product, in order to supply you with low-alloy steels for your unique requirements when you want them. We continually develop our services and solutions to offer ever more consistent and optimised steel performance.

THROUGH-HARDENING BEARING STEEL

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
Ovako 677	67SiMnCrMo6-6-4F	Bearing steel suitable for gas/air hardening	1.0	1.5	1.4	1.0	0.2		
Ovako 803	100Cr6	The most widely-used bearing steel with a hardenability for small components (wall thickness 17 mm)	1.0	0.3	0.3	1.4			
Ovako 824	100CrMo7	Increased hardenability with Cr and Mo for small- and medium-sized components (wall thickness 20 mm)	1.0	0.3	0.3	1.7	0.2		
Ovako 825	100CrMo7-3	Increased hardenability with Cr and Mo for medium-sized components (wall thickness 30 mm)	1.0	0.3	0.7	1.7	0.2		
Ovako 826	100CrMo7-4	Increased hardenability with Cr and Mo for medium- and large-sized components (wall thickness 50 mm)	1.0	0.3	0.6	1.7	0.4		
Ovako 827	100CrMnMoSi8-4-6	Increased hardenability with Cr, Mo and Si for large-sized components (wall thickness 75 mm)	1.0	0.5	0.9	1.9	0.6		
Ovako 831	100CrMnSi4-4	Increased hardenability with Cr, Mn and Si for small- and medium-sized components (wall thickness 20 mm)	1.0	0.6	1.1	1.0			
Ovako 832	100CrMnSi6-6	Increased hardenability with Cr, Mn and Si for medium-sized components (wall thickness 40 mm)	0.9	0.7	1.5	1.4			
Ovako 837	100CrMnSi6-4	Increased hardenability with Cr, Mn and Si for small- and medium-sized components (wall thickness 30 mm)	1.0	0.6	1.0	1.4			

This is a selection of our standard program. The steel grades above can all be made as BQ-Steel, IQ-Steel or M-Steel.

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TYPICAL SPRING STEEL

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
52CrMoV4	52CrMoV4	Steel for highly strained springs. Suitable for quenching and tempering	0.5	0.2	0.9	1.1	0.2		V
55Cr3	55Cr3	Steel for springs suitable for quenching and tempering	0.6	0.2	0.9	0.9			
56Si7	56Si7	Steel for different types of springs	0.6	1.8	0.8				
56SiCr7	56SiCr7	Steel suitable for quenching and tempering. A silicon steel with an addition of chromium for hardenability	0.6	1.8	0.9	0.3			
Imatra MC 608	60Cr3	High strength, high ductility and high toughness	0.6	0.2	0.9	0.8			
MS416	38Si7	Elastic washer plates, valves for multicultivators. Hot-rolled steels for quenched and tempered spring	0.4	1.6	0.7				
Ovako 593	51CrV4	Ingot cast	0.5	0.3	0.9	1.1			V
SB33S17B	33SiMnB7-3F	Boron alloyed spring steel	0.3	1.7	0.9				B
VC 510	51CrV4	Continuous cast	0.5	0.2	0.9	1.1			V

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TYPICAL CASE-HARDENING STEEL

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
C15E	C15E	Steel suitable for cold drawing	0.2	0.2	0.5				
CN 110 M	16NiCrS4	Good toughness, controlled hardenability, good machinability	0.2	0.2	0.6	0.8		1.0	
MC 110 M	16MnCr5	Continuous cast steel suitable for cold heading	0.2	0.2	1.2	1.0			
MC 212 M	20MnCr5		0.2	0.2	1.3	1.2			
MoCN 216	18CrNiMo7-6	Carburising steel used for bearing and transmission components	0.2	0.2	0.7	1.7	0.3	1.6	
MoCN206M	20NiCrMo2-2	Continuous cast	0.2	0.3	0.9	0.6	0.2	0.5	
Ovako 124	20MoCr4	A high cleanliness steel used for small-sized bearing and transmission components	0.2	0.2	0.8	0.5	0.4		
Ovako 146	16NiCrMo7	Ingot cast steel used for medium-sized components	0.2	0.1	1.0	1.1	0.1	0.8	
Ovako 152	20NiCrMo2-2	A high cleanliness steel used for small-sized bearing and transmission components	0.2	0.3	0.9	0.6	0.2	0.5	
Ovako 157	20NiCrMo7	A high cleanliness steel used for medium-sized bearing and transmission components	0.2	0.2	0.6	0.5	0.2	1.7	
Ovako 158	20NiMo9-7F	Steel giving reduced surface oxidation after gas carburising	0.2	0.1	0.3	0.4	0.7	2.3	
Ovako 159	18CrNiMo7-6	Carburising steel used for bearing and transmission components	0.2	0.2	0.7	1.7	0.3	1.6	
Ovako 225	18CrMo8-5F	Steel designed for nitriding	0.2	0.3	0.8	1.8	0.5		
Ovako 234	16MnCr5	Ingot cast steel used for small-sized components	0.2	0.2	1.2	1.0			
Ovako 245	12NiCr14-6F	A high cleanliness steel used for large-sized bearing and transmission components	0.1	0.3	0.5	1.5	0.1	3.3	
Ovako 253	14NiCrMo13-4	High hardenability, excellent toughness, high wear resistance, good dimensional stability	0.2	0.2	0.6	1.2	0.2	2.9	
Ovako 255	18NiCrMo14-6	High hardenability carburising steel	0.2	0.3	0.5	1.4	0.2	3.3	
Ovako 256	24NiCrMo15-5F	High hardenability carburising steel	0.2	0.3	0.7	1.2	0.3	3.6	
Ovako 277	16CrMnNiMo9-5-2F	Steel suitable for carburising and nitriding. Possible to gas/air harden	0.2	0.2	1.3	2.1	0.5	0.5	V
Ovako 499	30MoCrV20-7F	Temperature resistant carburising steel	0.3	0.2	0.3	1.7	1.8		V

This is a selection of our standard program. The steel grades above can all be made as BQ-Steel, IQ-Steel or M-Steel.

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TYPICAL GENERAL STRUCTURAL STEEL

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
30MnVS6	30MnVS6	Microalloyed cold heading steel. Used for short- and long-shaft ball points, threaded and heavy duty anchor bolts	0.3	0.5	1.4				V
38MnVS6	38MnV6	High strength, yield strength and toughness. Maintains very good mechanical properties at very low temperatures. Suitable for quenching and tempering	0.4	0.4	1.3				V
C22R	C22R	Steel for mechanical engineering and automotive components. Suitable for quenching and tempering	0.2	0.2	0.6				
C40R	C40R	Steel suitable for quenching and tempering. Shows intermediate features between steels with medium carbon content and steels with high carbon content	0.4	0.2	0.7				
C45E/R	C45	Steel suitable for quenching and tempering and surface hardening	0.5	0.2	0.8				
C55R	C55R	Continuous cast steel suitable for quenching and tempering and surface hardening.	0.6	0.2	0.8				
C60R	C60R	Steel suitable for quenching and tempering and surface hardening. Used for mechanical engineering and automotive components	0.6	0.2	0.8				
EL 400	S420N	Used for welded parts that have to withstand high levels of strain	0.2	0.3	1.2				V
Green Cut	11SMn30	Lead-free cutting steel for bulk applications for joining elements in mechanical engineering and automotive components. Not intended for heat treatment	0.1	0.2	1.2				S
Hydax 15	S355J0	A low carbon, high tensile strength structural steel which can be readily welded to other weldable steel	0.1	0.4	1.3				S
Hydax 25	20Mn5F	High temperature constructional weldable steel	0.2	0.4	1.3				S
Imacro EL 700	5CrMn16-4F	Suitable for gas/air hardening	0.1	0.3	1.0	4.0			Nb
Imatra 4M	C45E	Steel suitable for cold working and quenching and tempering	0.5	0.3	0.7				
Imatra 520	S275J2	General structural steel suitable for cold-forming such as bending, folding, bordering and flanging	0.1	0.3	1.2				
Imatra 520	S355J2	A low carbon, high tensile strength structural steel which can be readily welded to other weldable steel	0.1	0.3	1.2				
Ovako 056	C55R	Ingot cast steel suitable for quenching and tempering and surface hardening	0.6	0.2	0.8				
Ovako 280	19MnVS6	Microalloyed steel with high tensile strength, good machinability and weldability. Suitable also for case hardening or nitriding. Good dimensional stability	0.2	0.4	1.5				V
Ovako 382	46MnVS3	Microalloyed also suitable for quenching and tempering	0.4	0.3	0.7				V
Ovako 482	38MnV6	Ingot cast microalloyed also suitable for quenching and tempering	0.4	0.4	1.3				V
P355NH	P355NH	A pressure vessel steel grade with good weldability and high resistance to brittle cracking. Used for the manufacture of pressure vessel tanks for the storage of pressurised gases	0.1	0.3	1.2				
S235J2	S235J2	A low carbon, high tensile strength structural steel which is suitable for welding. With its low carbon equivalent, it possesses good cold-forming properties	0.1	0.3	1.2				
S275J2	S275J2	A low carbon, high tensile strength structural steel which can be used for welding. With its low carbon equivalent, it possesses good cold-forming properties	0.1	0.3	1.2				
S355J2 SBM	S355J2	A general construction steel suitable for welded or non-welded constructions of simpler shafts with medium strength requirements	0.1	0.3	1.2				
SB400	S420N	Structural steel grade with good weldability	0.2	0.3	1.2				V
SB500	S460	A weldable structural steel suitable for offshore use	0.2	0.2	1.3				V
SB550	S550	A structural hot-rolled steel material with high yield strength and excellent cold-forming characteristics	0.2	0.4	1.5				V
SB600	S600	A high strength structural steel with good toughness and weldability	0.2	0.4	1.5				V

This is a selection of our standard program. The steel grades above can all be made as BQ-Steel, IQ-Steel or M-Steel.

* Designation followed by "F" is not an official EN standard grade but named according to the rules in EN 10027.

TYPICAL BORON STEEL

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
BCM 311	27MnCrB5-2	Boron alloyed heat treatable steel for wear resistant parts such as dredger buckets, plough shares, chain wheels, mechanical engineering components, axles	0.3	0.2	1.3	0.5			B
BCM 414	39MnCrB6-4	Boron alloyed heat treatable steel	0.4	0.3	1.5	0.5			B
BM 212	20MnB5	Structural alloy steel used for mechanical parts and all kinds of engineering components, and contains a certain amount of one or several kinds of alloy elements, 20MnB5Alloy structural steel is widely used in ships, vehicles, aircraft, railways, bridges and pressure vessels	0.2	0.2	1.3				B
BM 312	30MnB5	Steel grade suitable for quenching and tempering. Very good forming properties in the soft delivery state and high strength after heat treatment (hardening). Used as stabilisers, drive and gear shafts and parts used in passive safety systems by the automotive industry	0.3	0.2	1.3				B
SB23M12B	20MnB5	Structural alloy steel used for mechanical parts and all kinds of engineering components, and contains a certain amount of one or several kinds of alloy elements, 20MnB5Alloy structural steel is widely used in ships, vehicles, aircraft, railways, bridges and pressure vessels	0.2	0.2	1.3				B
SB24M13B	24MnB5F	Steel suitable for quenching and tempering. Very good forming properties in the soft delivery state and high strength after hardening	0.2	0.3	1.3	0.2			B
SB27M12CB	27MnCrB5-2	Boron alloyed heat treatable steel for wear resisting parts such as dredger buckets, plough shares, chain wheels, mechanical engineering components, axles. Suitable for quenching and tempering	0.3	0.2	1.3	0.5			B
SB30M12CB	30MnCrB5-2F		0.3	0.3	1.3	0.5			B
SB33M13B	30MnB5	Steel for wear resistance in thickness <15 mm	0.3	0.2	1.3				B
SB33M13CB	33MnCrB5-2	Boron alloyed steel suitable for quenching and tempering	0.3	0.3	1.3	0.6			B
SB43M14B	43MnB6-3F	Boron steel for general purposes without any specified mechanical properties. SB43M14B has the highest level of hardness and wear resistance achievable in the standard range of boron steels. Therefore is it an excellent choice for use in machine knives and garden tools	0.4	0.3	1.4				B

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E355 + SR EN 10305-1

OVAKO

TYPICAL QUENCHING AND TEMPERING STEEL

Ovako standard	EN-standard*	Comments	Typical analysis						
			C	Si	Mn	Cr	Mo	Ni	Other
21NiCrMoV5-7	21NiCrMoV5-7F	Temperature resistant steel suitable for cold drawing	0.2	0.3	0.6	1.3	0.7		V
23MnNiMoCr5-4	23MnNiMoCr5-4	Steel for high strength chains	0.2	0.2	1.3	0.5	0.6	1.0	
31CrMoV9	31CrMoV9	Steel suitable for nitriding	0.3	0.2	0.6	2.5	0.2		V
37CrV3	37CrV3F		0.4	0.3	0.8	0.8			V
40CrMoV4-6	40CrMoV4-6	Temperature resistant steel. Good mechanical properties. Good resistance to wear. Used for compressor discs, shafts, fasteners and other mechanical parts	0.4	0.3	0.7	1.1	0.6		V
B7	44CrMnMo4-4F	Steel for high strength fasteners	0.4	0.3	0.9	1.0	0.2		
B16	42CrMoV4-6F	Steel for high strength fasteners	0.4	0.3	0.6	1.0	0.6		V
C35E	C35E	Steel suitable for cold heading	0.4	0.2	0.7				
Imacro M	5CrMn16-4F		0.1	0.3	1.0	4.0			Nb
Imacro NIT	8CrMnMo16-4F	Steel suitable for nitriding	0.1	0.3	1.0	4.0	0.5		
IMAFORM	7Cr5F	Low carbon hardenable steel suitable for direct quenching	0.1	0.3	0.8	1.3			
IMANITE M	21CrMoV5-7F	Steel suitable for nitriding	0.2	0.3	0.6	1.4	0.7		V
L7	43CrMnMo4-4	Steel for high strength fasteners	0.4	0.3	0.9	1.0	0.2		
MoC 210 M	25CrMo4	Continuous cast	0.3	0.2	0.9	1.1	0.2		
MoC 310 M	34CrMo4	Steel suitable for cold heading	0.3	0.3	0.8	1.1	0.2		
MoC 410	42CrMo4	Continuous cast	0.4	0.3	0.8	1.1	0.2		
MoC 510	50CrMo4	Continuous cast	0.5	0.2	0.7	1.0	0.2		
MoCN 315	34CrNiMo6	Continuous cast	0.3	0.2	0.7	1.4	0.2	1.3	
MoCN 320	30CrNiMo8		0.3	0.3	0.7	2.0	2.0	0.3	
Ovako 322	25CrMo4	Ingot cast	0.3	0.2	0.9	1.1	0.2		
Ovako 326	42CrMo4	Ingot cast	0.4	0.3	0.8	1.1	0.2		
Ovako 355	40NiCrMo7-3F	SAE 4340 mod with V	0.4	0.3	0.7	0.8	0.3	1.8	V
Ovako 356	34CrNiMo6	Ingot cast	0.3	0.2	0.7	1.4	0.2	1.3	
Ovako 398	32CrMoV12-10	Steel suitable for deep nitriding	0.3	0.3	0.5	3.0	1.0	0.3	
Ovako 420	24CrMo13-6		0.2	0.2	0.4	3.1	0.5		
Ovako 453	32NiCrMo13-4F		0.3	0.2	0.5	1.1	0.2	3.1	
Ovako 477	40SiCrMnMo7-6F	Steel suitable for gas/air hardening	0.4	1.7	1.5	1.5	0.4		
Ovako 495	48CrMoNi4-10F	High strength high toughness steel with high wear resistance used in mining applications	0.5	0.2	0.8	1.1	0.9	0.4	V
Ovako 497	42NiSiCrMo8-7-3F	High-strength, high-toughness steel known as 300M	0.4	1.6	0.6	0.7	0.3	1.7	V
Ovako 498	30NiCrMo16-6	High-strength, high-toughness steel	0.3	0.3	0.5	1.4	0.2	4.0	
Ovako 528	50CrMo4	Ingot cast	0.5	0.2	0.7	1.0	0.2		

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PRODUCT OFFERING

HOT-ROLLED BARS

Hot-rolled round bars and square bars

Our hot-rolled round bars is characterized by close tolerances, excellent straightness as well as roundness, good surfaces and low decarburization.

Hot-rolled flat bars

Eliminate costly manufacturing steps with our hot-rolled flat bars. Flats with welding chamfers and rounded corners often deliver high cost savings compared to machining or gas cutting, which can weaken edges.

Special profiles

Beyond the round bar, we are able to roll at least 680 different kinds of profiles in both symmetrical and asymmetrical sizes.

FURTHER PROCESSED BARS

Drawn-, Ground- and Peeled bars

The size of the drawn bars can be tailored to specific needs. As a result, our customers get a material that supports consistently high quality production and contributes to cost-effective manufacturing. Peeled bars saves material, tools, machines and production time. The bars is produced from excellent quality steel using precision manufacturing. Buying finished ground bar is usually a more cost-effective and productive alternative to grinding internally.

Special properties bars

A highly advanced and flexible technology, the SP-Bar is a concept based on the ability to modify three key properties – tolerances, mechanical properties and surface quality – to meet your requirements. Prior to an order, our engineers work closely with you to plan and calculate the rolling operation to achieve the properties that are important to you.

Pre-components

Going for pre-machined components is often a cost-effective solution. It allows you to eliminate your own stockholding, crosscutting and machining.

HARD-CHROME PLATED BARS AND TUBES

Cromax is a line of chrome-plated and nickel-chrome-plated bars and tubes primarily used as piston rods in hydraulic cylinders.

SR-100 WIRE

SR-100 is Ovako's surface removed wire characterized by a high consistency of analysis and cleanliness. The wire is surface-peeled and 100% tested for any surface defects to obtain a crack-free and decarburization-free surface.

SEAMLESS TUBES AND HOLLOW BARS

Our tubes and hollow bars are used when there are stringent demands on the material such as in rolling, bearing, automotive, hydraulic and general engineering applications. Ovako tube products are characterized by uniform properties, close tolerances and small machining allowances. They are available in all grades and can be cut according to customer requirements.

ROLLED AND FORGED RINGS

For almost a century, Ovako has built a proven track record in this product niche. We strictly control the whole production chain from melt to the rolling of the rings. Manufacturers can simplify their production processes and reduce their costs, because our rings are not only predictably consistent from batch to batch but also easy to process further.

GRINDING MEDIA

Ovako grinding balls are delivered as-rolled or in the quenched and tempered condition. They are available in A810 grinding ball steel, or other grades upon request, and can maintain the same wear resistance and hardness from start to finish. Grinding rods are delivered in the as-rolled condition in dimensions of 0.75 to 120 mm or hardness 340 to 400 HBW.

HOT-ROLLED BARS

Hot-rolled round bars

Over the years we have gained a good reputation for products in which fatigue strength, toughness and wear resistance are critical. As well as meeting the specified requirements, our bar products offer good formability, machinability and weldability, making them a cost-saving solution for our customers.

Our hot-rolled bars can be further processed by heat treatment, machining and chrome plating. A major part of our round bars are supplied as peeled, ground or drawn bright bars. The Ovako hot-rolled bar offering also contains round bars, flat bars, round corner squared bars, special properties bars, special profiles and precomponents plus our SR-100 Wire and the Cromax product family. All are available in a variety of sizes. Our hot-rolled bars are characterised by close tolerances, excellent straightness as well as roundness, good surfaces and low decarburisation. This makes them ideally suited for forging and machining.

Size range

Standard hot-rolled round bars are delivered in diameters from 13 mm to 230 mm, and in many different sizes. They can be delivered at 1 mm intervals up to Ø 75 mm. Larger dimensions are available at 5 mm intervals.

Tolerances on dimensions and shape

The tolerances on dimensions and shape for round bars according to EN 10060 meet the European standards. Our rolling mills have excellent capability to produce tighter tolerances, including half the standard tolerance. Please contact our sales organisation when enquiring about and ordering hot-rolled bars if tighter tolerances are needed.

Lengths

The most common bar length is 6 metres, but can also range between 3.5 and 18 metres, depending on the producing rolling mill. Heat treatments may restrict the maximum length.

Manufacturing lengths

If not otherwise specified, the manufacturing length is 6,000 mm. Bar diameter, heat treatment and yield optimisation may result in a deviation from this common length. Ten per cent of the bars may be below the minimum of the ordered range, but not less than 3 metres.

Exact lengths

At the time of the order, bars can be delivered sawn to exact lengths.

Roundness

Out of roundness is measured as the difference between the maximum and minimum diameters. Out of roundness is at most two-thirds of the diameter tolerance.

Straightness

Straightness is measured as the maximum height of arch; in other words, the largest deviation from the straight line. Normally the test length is 1.0 metre. Normal straightness is a maximum of 2 mm/m.

Surface quality

Standard surface crack depth is max. 1% of the diameter. When an order is made the bars can be inspected, for example, by magnetic dispersion or the magnetic particle method. Normally, surface quality class D can be achieved for diameters up to Ø 80 mm and C for diameters up to Ø 120 mm that comply with EN 10221.

Our hot-rolled bars are available in a wide range of sizes. They are characterised by close tolerances, excellent straightness as well as roundness, good surfaces and low decarburisation. This makes them ideally suited for forging and machining.

Hot-rolled flat bars

Flat bars by Ovako combines precisely controlled manufacturing processes for superior impact toughness, good surfaces and high yield strength across a range of applications.

Ovako delivers hot-rolled flat bars in a broad dimension range. The bars are characterised by excellent straightness and shape as well as good surfaces and low decarburisation.

Shape and dimensions

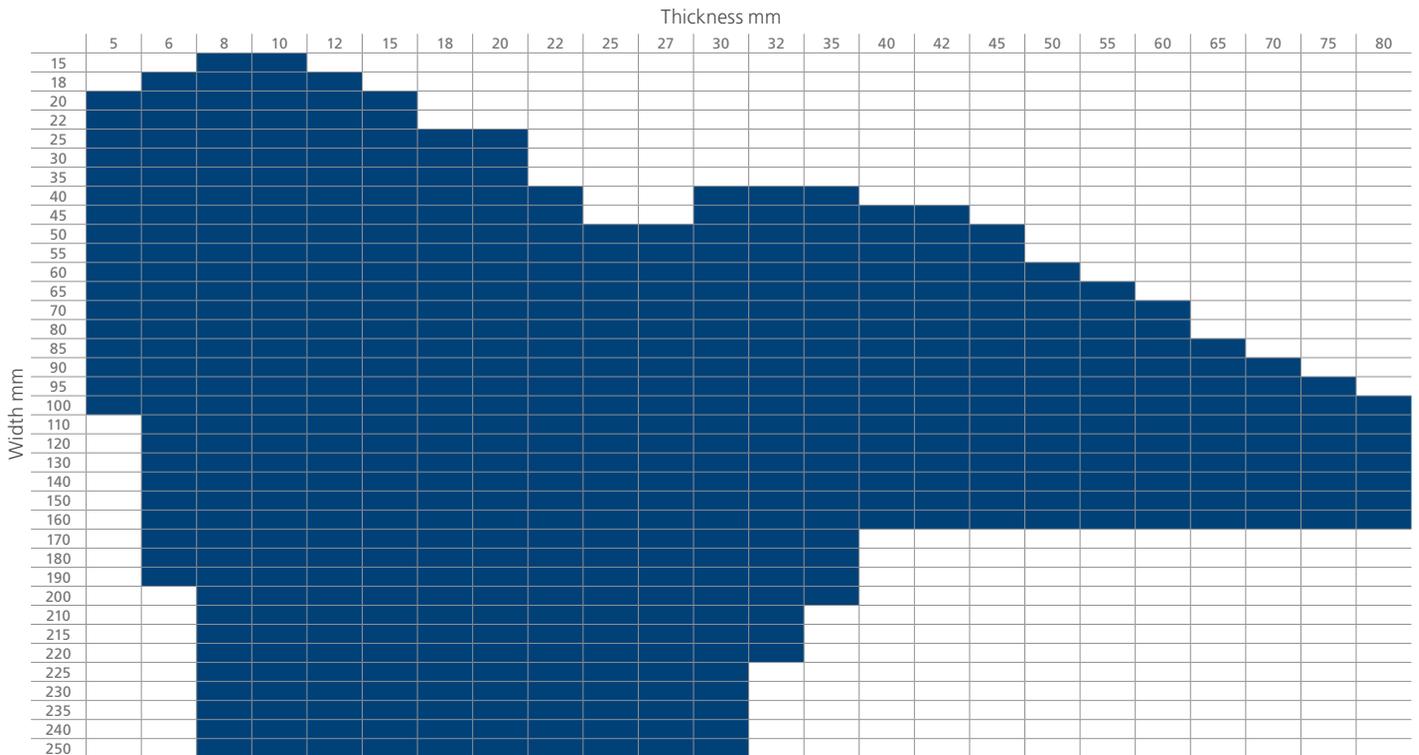
The rolled shape is generally flat bars with square corner edges. It can on request also be rolled as flat bars with different corner radiuses. The tolerances on dimensions for flat bars fulfil the European standard EN 10058.

Our rolling mills have excellent capability to produce even tighter tolerances. The most common bar length is 6 metres, but can also range from 2.8 to 21 metres, depending on size and the producing rolling mill. Heat treatments may restrict the maximum length. Bars can be delivered sawn to exact lengths.

Straightness

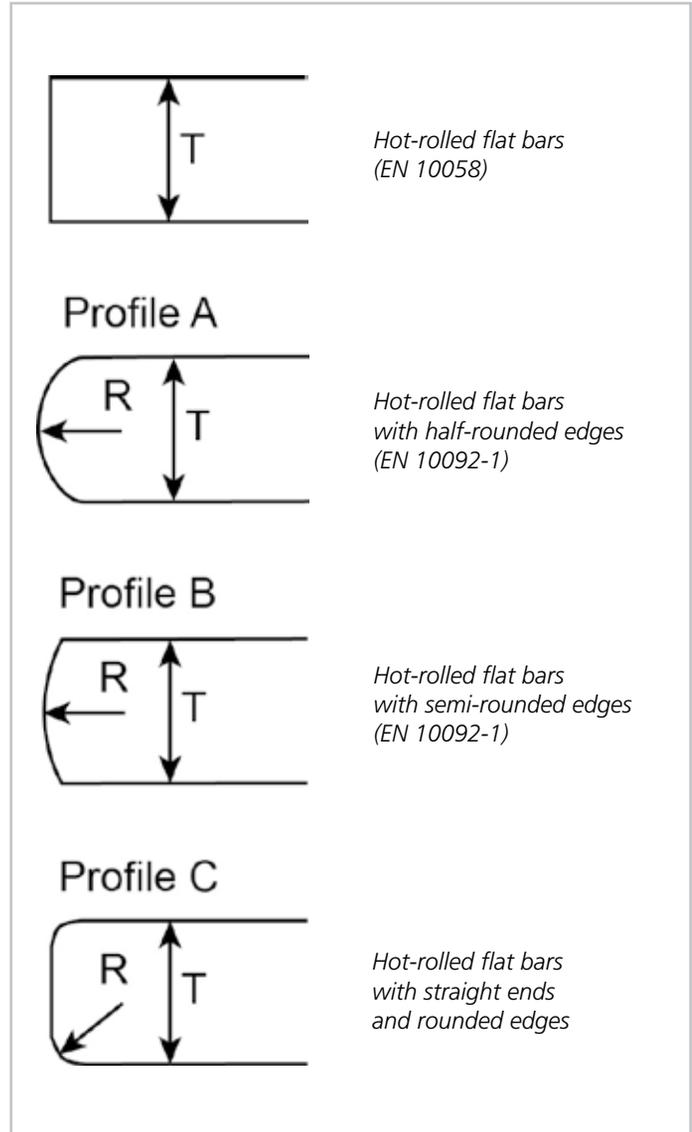
The out of straightness is measured and our flat bars comply with European Standard EN 10058 as-rolled, but can also be delivered in the as-straightened condition.

Dimensions, hot-rolled flat bars



Hot-rolled spring steel flat bars

Ovako delivers hot-rolled spring steel flat bar according to European Standard EN-10092-1 (Profile A, B, C). The steel used in Ovako's flat bars for spring manufacturing has very low levels of non-metallic inclusions and optimal hardenability. These contribute to a favourable yield-to-tensile strength ratio in the quenched and tempered condition – a combination of properties that provides exactly the right qualities for the end product.



Flat bars by Ovako combines precisely controlled manufacturing processes with the clean steel program for superior impact toughness and high yield strength across a range of applications.

Rough turned black bars

Our rough turned bars are available in the complete size range between 110 to 185 mm. The bars are characterised by a shoot blasted surface with tighter tolerances than a conventional black bars. Due to the machined surface this product is decarburisation-free.

Parameter	Rough turned
Diameter	Ø110–185 mm
Diameter tolerance	+ 0.25/– 0 mm
Roundness	Max 65 % of the diameter tolerance
Max surface defects	0.2 mm
UT testing OD<130mm	2 mm FBH
UT testing OD>130mm	3 mm FBH
Surface property	Ra < 25 µm
Straightness	1 mm/m
Length*	4.5–9.3 m
Length tolerance	+200/–200 mm
Short length	Max 10 %
End execution	Sawn ends
Hardness	Max 260 HB
Packing	Bundle with steel bands
Bundle weight	Max 4.5 tonnes

*Length

1) Manufacturing's length (yield controlled): Length between 4.5–9.3 m which gives the best yield based on bar diameter, short lengths and heat treatment demand.
Short length, min 3.2 m can occur in up to 10% of delivered quantity.

Round corner square bars

Square bars, or billets, are mainly used for drop-forged components in the automotive industry. Ovako's round corner square bars have a uniform internal structure and a very good surface quality – absolute requirements when producing drop-forged parts.

Round corner squared bars have a suitable shape for forging operations. Its shape also provides higher size flexibility in rolling processes.

Round corner square bars from Ovako has a uniform weight distribution over the bar length due to its high consistent quality which makes it possible to produce forging blanks with a small variation in weight.

Round corner square bars have no sharp edges which could provoke formation of laps and surface defects during forging operations.

Advantages

- Offers a uniform weight distribution over the bar due to high consistent quality
- No sharp edges that could cause laps or surface defects when forged
- No overheating of corners in induction heating compared to sharp corner bars
- Easier handling in rotary hearth furnaces since they do not require rolling like round bars
- Safer handling since they do not require rolling

Square bars by Ovako have a uniform inner structure with a very good surface finish and are available in our standard steel grades or even M-treated – all tailored to your specifications.

Special profiles

By using hot-rolled special profile bars tailored to your needs, some manufacturing steps may be eliminated, lowering your costs. Our capability to hot-roll special profiles as required for a specific application may enable the customer to skip several steps in their production process. Ovako manufactures special profiles both in symmetrical and asymmetrical shapes.

Size range

Our special profiles are rolled in widths ranging from 15 mm to 300 mm and thicknesses from 5 mm to 60 mm.

Lower production costs

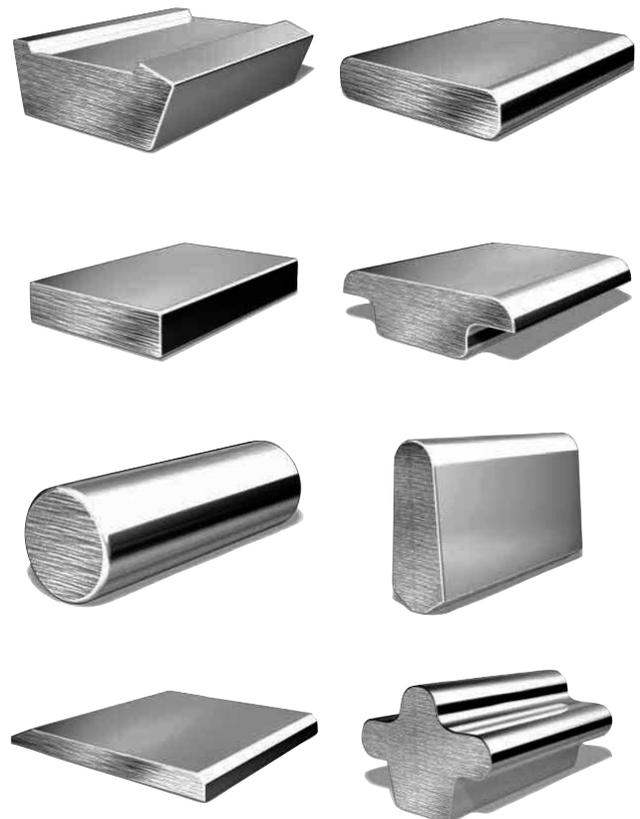
Being able to produce hot-rolled special profile bars tailored to suit your needs, allows us to often find a solution that allows more efficient manufacturing and lower production costs. Even basic simple profiles, such as flats with welding chamfers and rounded corners, often deliver high cost savings compared to machining or gas cutting.

Marking

Special profile bars can be marked with a customer logo or other information.

Advantages of Ovako's special profiles

- Manufacturing steps may be eliminated, lowering costs
- Tailored to customer needs
- High productivity process steps such as machining can be eliminated
- Lower costs for raw material due to lower weight.
- Ovako helps you design your unique profile
- Profiles can be produced from the whole range of Ovako steel grades





FURTHER PROCESSED BARS

Bright bars

Available in a wide range of shapes, our bright bar grades eliminate processing steps and unnecessary stock build-up. Our bright bars offering contains the peeled bars, drawn bars, ground bars and pre-components listed under the further processed bar products.

Diameters: from 10 to 127 mm,
with tolerances down to IT6

Lengths: from 10 to 8,000 mm,
with tolerances down to +/-0.05 mm

Advantages of further processed bars

- Rationalised production through delivery closer to end product
- Lower total cost due to lower stock levels and fewer production steps
- Cleaner production with lower maintenance cost
- Greener production with a minimum of chips handling
- Minimised risk of shocks and vibrations at high cutting speeds by using high and consistent quality bars from Ovako
- Reduced need for further surface finishing
- Just-in-time contract for deliveries according to specific needs
- Lean production through a wide range of packaging solutions
- Create additional floor space in operations and/or warehouse
- Reduce capital tied up in raw material
- Avoid spending CAPEX on non-core processes

Drawn bars

Cold-drawn bars from Ovako is produced using special steel from our own steelworks. We are able to tailor steel properties such as strength, machinability, formability and hardenability for the most common customer requirements.

The size of the drawn bars can also be tailored to specific needs. The result is that our customers receive a material that supports consistently high-quality production and contributes to cost-effective manufacturing.

Due to the availability of the material and the possibility to tailor the bars to customer requirements, the product is well suited for a wide range of applications. Rolling bearings, transmission components, shafts in automotive water pumps, spindles for textile machines, round files, bolts, springs and drills are a few examples of products made out of drawn bars from Ovako.

Advantages of Ovako's drawn bars

- Supports consistently high-quality production
- Cost-effective manufacturing



Drawn bar product properties

Size range	Drawn bars is produced in the 11 to 55 mm diameter size range.
Diameter tolerance	IT10 is the standard tolerance. IT9 can be supplied subject to separate agreement.
Surface condition	Drawn bars is supplied oiled as standard for efficient rust protection.
Straightness	Normal straightness is max. 1 mm/m.
Out of roundness	Max. 50% of the diameter tolerance, measured as the difference in diameter.
Lengths and length tolerances	The supply lengths are normally within the 2.5–6 meter range. The length tolerance is 100 mm but 50 mm can be supplied subject to separate agreement.
Heat treatment	Drawn bars can be obtained in a soft annealed condition.
End condition	Normally, the drawn bar is supplied with cold-sheared ends. However, subject to separate agreement they can be supplied with one or both ends square-milled and chamfered.
Packing and marking	The bars are delivered bundled, with or without wrapping. We can also supply the bars packed in wooden cases. Max bundle weight is 2 tonnes or 1.2 tonnes for bars in wooden cases

Peeled bars

Ovako's peeled bars saves material, tools, machines and production time. Our bar peeling is a well-integrated production that uses precision equipment. The peeled bar is supplied in a polished and straightened condition. This allows for smoother surface finish, closer tolerances and better straightness, plastic forming as well as further machining.

Peeled bars gives customers the opportunity to rationalise production and reduce production costs. The extraordinary cleanliness of the steel reduces the risk of unexpected tool failures and downtime, and the excellent straightness minimises the risk of shocks and vibrations that can occur at high cutting speeds.

The good surface finish of Ovako's peeled bars can sometimes eliminate the need for further surface finishing. This saves material, machining and production time.

Ovako's peeled bars is characterised by:

- No surface defects
- Decarburisation-free surface
- Good surface smoothness
- Close tolerances
- Adjusted structure and hardness
- Good ductility
- Low content of non-metallic inclusions
- Good machinability after forming

Advantages of Ovako's peeled bars

- Rationalised production
- Lower production cost
- Minimised risk of shocks and vibrations at high cutting speeds
- Reduced need for further surface finishing



Peeled bars product properties

Size range	Peeled bars is produced in optional sizes in the 17 to 127 mm diameter range.
Steel grades	Peeled bars is produced in a wide range of steel grades – from simple engineering steels to special steels for demanding applications.
Diameter tolerance	Tolerance class IT11 is standard. Upon separate agreement, tolerance class IT9 can be supplied.
Surface roughness	Max Rt 50 µm
Straightness	Normal straightness is max 0.6 mm/m.
Lengths and length tolerances	Delivery of optional lengths in the 4 to 8 m range. Heat-treated material may have other lengths.
Out of roundness	Max. 50 % of the diameter tolerance, measured as the difference in diameter.
End finish	Cold-sheared and deburred ends without radial burrs and/or cold sawn and chamfered, one or two ends, 45°.
Packing and marking	The material is supplied bundled with steel straps. Each bundle is supplied with a tag containing information about the order number, steel grade, heat number, dimension, weight and quantity of bars. The material is supplied oiled as standard. Other types of packaging, e.g. wrapped paper/plastic are provided upon request.

Ground bars

Buying finished ground bars is usually a more cost-effective and productive alternative to grinding internally.

Quality for efficient production

Ovako's ground bars are characterised by straightness, good out of roundness and a fine surface. These are important properties as they contribute to smooth and trouble-free production, especially when it comes to high machining speeds and accurate, vibrationless feed movements in automatic lathes. Straightness is also particularly important when producing components from long bars. In addition, our ground bars have a minimum of internal stresses, which significantly reduces the risk of distortion after machining. Ovako's ground bars is therefore a favourable material for the manufacturing of products like long shafts, rolling bearings and ball bushings.

Ground bars in three quality classes

To simplify the selection of the most suitable quality, ground bar is available in three product groups:

- Rough ground bars
- Fine ground bars, standard execution
- Fine ground bars, special execution

Advantages of Ovako's ground bars

- Smooth production especially at high machining speeds
- Accurate and vibrationless feed movements in automatic lathes
- Reduced risk of distortion after machining



Ground bars product properties

	Rough ground bars	Fine ground bars, standard execution	Fine ground bars, special execution
Size range	Ø 12 to 100 mm	Ø 12 to 100 mm	Ø 12 to 100 mm
Tolerances	≥ IT9	IT8	Down to IT6
Lengths	4 to 7 m	4 to 7 m	4 to 7 m
Surface smoothness	Max. Ra 5 µm	Ra 1.0 µm	Down to Ra 0.6 µm
Out of roundness	Max. 50 % of the diameter tolerance, measured as the difference in diameter	Max. 50 % of the diameter tolerance, measured as the difference in diameter	Max. 50 % of the diameter tolerance, measured as the difference in diameter
Straightness	0.5 mm/m	Down to 0.2 mm/m	Down to 0.1 mm/m





Special properties bars

As a hot-rolled bar with enhanced properties, Special Properties bar by Ovako is not limited to any specific grade and therefore offers increased added value and substantial cost savings due to the SP-Bar treatment's effect on mechanical properties.

Special Properties round bars, commonly known as SP-Bars, are the result of Ovako's continuous product development. SP-Bars are not limited to any specific steel grade, which creates opportunities for customers wishing to use this advanced technology. By optimising the properties of the bar material, customers can benefit from increased added value and substantial cost savings in manufacturing operations.

Size range: 14 to 52 mm

Lengths: 4 to 12 m

Mechanical properties

SP-Bars offers improved mechanical properties compared to regular bars. The result is a longer fatigue life and a greater impact strength.

Tolerances

SP-Bars offer extremely tight tolerances. Consequently SP-Bars can often replace peeled or drawn bars. Customers can decrease the nominal size and get more manufactured pieces per tonne of purchased SP-Bars.

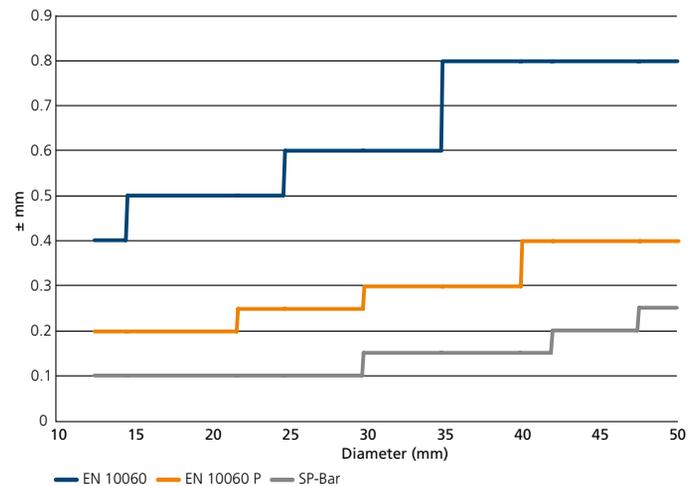
Surface quality

Scale thickness is generally reduced on SP-Bars. The reduction can be up to 50 % compared to conventionally hot-rolled products. The reduced scale thickness gives a cleaner environment in subsequent operations such as cold-forming or heat treatment.

Advantages of SP-Bars

- Tighter tolerances that deliver increased yields and repeatability as well as material savings
- Improved mechanical properties that provide longer fatigue life and greater impact strength
- Better surface quality that reduces scale and results in cleaner quenching tanks and improved process environment.

Dimensional tolerances SP-Bars



TOLERANCES



MECHANICAL
PROPERTIES

SURFACE
QUALITY

Available tolerances (1/4 EN 10060)	
Ø 14–30	± 0.10
Ø 31–42	± 0.15
Ø 43–47.5	± 0.20
Ø 48–52	± 0.25

Pre-components from bar

Selecting pre-machined components is often a cost-effective solution. It allows you to eliminate your own stockholding, crosscutting and machining. It opens up new possibilities to simplify production and to cut production costs, not least by converting fixed to variable costs.

Today, Ovako has comprehensive resources for manufacturing pre-components in various grades of machining. Our pre-components are produced with close tolerances combined with a high, even level of quality.

Pre-components from bar can be produced from hot-rolled, peeled, ground or drawn bars. All of these executions are available in a wide range of sizes and steel grades.

Chamfered or blanks with radius

Sawn off and chamfered according to customers' specifications. The standard chamfer angle is 45°. Customised chamfering and radius according to agreement.

Size range: 20 to 105 mm diameter

Lengths: 35 to 1,900 mm

Centre-hole drilled blanks

Blanks with sawn end surfaces, centre-drilled to customers' specifications.

Size range: 20 to 105 mm diameter

Lengths: 35 to 1,900 mm

Cut blanks

Length tolerance, mm at length, mm

Size mm	L ≤ 400	400 < L ≤ 800	800 < L ≤ 1600
20-100	1.0	1.4	2.0
100.1-160	2.0	2.5	3.0

Special tolerances can be provided by agreement.

Advantages of buying pre-components from Ovako

- Opportunity to fully concentrate own resources on finishing and/or assembly
- Fixed costs tied to machinery are converted to variable costs
- Capital tied up in inventory is reduced
- Bulky and time consuming handling of long products is eliminated
- No chips or off-cuts to handle
- Less internal transport, simplified administration and less material to manage
- Transport costs reduced by up to 2/3 compared to long products
- Just-in-time contract for deliveries according to specific needs



Precision-cuts

Eliminate your non-core processes and improve profitability with Ovako precision-cuts. Our precision-cut offering includes just-in-time, or flexible, delivery and provides “greener” processes.

Ovako’s precision-cuts are made from peeled, ground or drawn bars and available in a wide range of sizes and more than 60 steel grades in our bar portfolio. Our offering includes chamfered blanks, centre-hole drilled and cut blanks.

Precision-cut quality

We offer secure and exact machining precision that can be tailor-made to your specifications. This includes customised rounded or chamfered radius. We deliver precision-cuts within close tolerances and a high, consistent product quality. Our length tolerances are +/- 0.05 mm, compared with the standard +/- 0.5 mm. Other specific tolerances can be arranged by agreement.

Our precision-cuts are subject to rigorous testing and pre-production approval processes. Testing covers dimensional measurements, mechanical properties and isotropic qualities. We can guarantee the right quality, not the most expensive one, to meet your needs.

Efficient production

By using the Ovako precision-cut offering you can eliminate up to three of the following processes, and their associated costs:

- Measuring and cut to exact length
- Chamfering
- Machining of radius
- Centre-hole machining

Why not take advantage of our just-in-time delivery or ensure flexible delivery amounts suitable for you. The amount ordered can range from one piece to an unlimited amount. We deliver within 48 hours through a logistics agreement.

Chamfered blanks

We offer chamfered blanks that are sawn off and chamfered according to your specifications. The standard chamfered angle is 45°, or according to your requirements.

Size range: 10–105 mm diameter

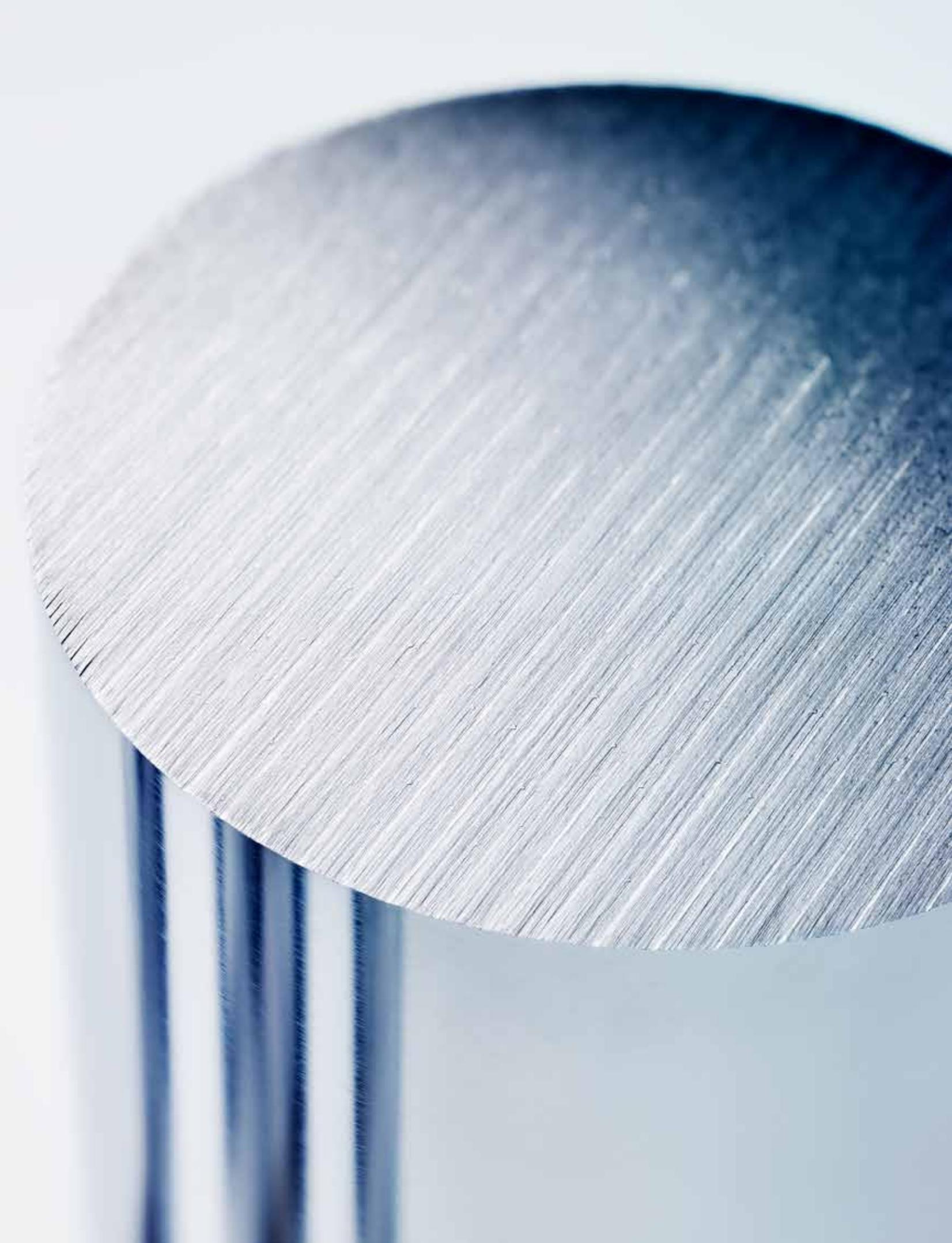
Lengths: 25–1,800 mm

Centre-hole drilled blanks

We offer blanks with sawn end surfaces, centre drilled to your specifications.

Size range: 10–105 mm diameter

Lengths: 25–1,800 mm



HARD-CHROME PLATED BARS AND TUBES

Cromax is a line of chrome-plated and nickel-chrome-plated bars and tubes primarily used as piston rods in hydraulic cylinders. Cromax offers a reduction of cost and capital required to enable a hydraulic cylinder to supply a specific force throughout its economic life. Wherever in the world it operates.

Most customers have different requirements when it comes to service and will ask for different delivery formats, lead times, logistics concepts etc. Our approach is to ensure sufficient flexibility to be able to tailor the most cost- and capital-efficient solution for each client.

We fulfil our mission by offering a line of base steels which have been specifically developed with the operation and manufacturing process of hydraulic-cylinder piston rods in mind. The steels are designed to provide the most economical designs while enabling a productive manufacturing process. The surfaces of the rods are adapted to minimise the cost yet fulfil the requirements for each application, even up to the most demanding ones. We tailor our deliveries to the needs of the customer to make sure the costs, capital and risks are kept to a minimum. Our understanding is that this offer is unique.

In order to maximise the value of our offering, we encourage our customers to think through each design in three simple steps:

Step 1 – What material should we use in order to minimise the cost of the rod? – The rule of thumb is to use the material with the lowest price per MPa yield strength while, at the same time, meeting manufacturing and safety parameters.

Step 2 – What surface will guarantee problem-free operation at minimum cost? – Firstly, set the requirements for the rod in the field considering time of exposure, compressive loading, corrosive environments and risk of impact damage. Secondly, determine if additional initial corrosion protection is needed for warehousing and transportation needs. Thirdly, select the combination of processes resulting in the lowest cost.

Step 3 – Which service level best minimises cost, capital and risk? – Starting from the lead time requirement of the cylinder-making process for a specific facility, work out the ideal logistics and delivery format. Ideally, there should be one independent back-up manufacturing route for each product to provide a comfortable margin of safety.



Machining and friction welding available as add-on service in Europe.

STANDARD AND CROMAX STEEL GRADES

Step 1	Selection criteria					Technical data						
Steel grades	Machinability	Fusion welding	Friction welding	High impact requirements	EUR/Mpa Index	Dimension DIA. (mm)	Yield strength $R_{0.2}/R_{p0.2}$ (MPa)	Tensile strength R_m (MPa)	Elongation A5 (%)	Hardness HB	Impact toughness KV (J)	Surface hardness IH HRC
C45E	Good	Quite suitable	Suitable	No	100	< 100	≥ 305	≥ 580	14	172–242	-	-
C35E	Excellent	Quite suitable	Suitable	No	90	20–90	≥ 345	≥ 590	19	165–220	-	≥ 50
280X	Good	Suitable	Suitable	Yes	60	20–90 91–125 > 125	≥ 520 ≥ 440 ≥ 350	650–800 550–700 500–700	19 19 19	200–241 180–230 180–230	≥ 27 at -20°C ≥ 27 at -20°C ≥ 27 at -20°C	≥ 45
482IH	Rather good	Needs care	Suitable	No	55	< 125	≥ 580	850–100	14	250–300	-	≥ 55
42CrMo4	Moderate	Un-suitable	Suitable	Yes	70	< 40 40–95 > 95	≥ 750 ≥ 690 ≥ 550	1000–1200 900–1100 800–950	11 12 13	295–355 265–325 235–295	≥ 35 at 20°C ≥ 35 at 20°C ≥ 35 at 20°C	≥ 55
TUBE	Good	Suitable	Suitable	Yes	N/A		≥ 450	550–800	20	160–240	≥ 27 at -20°C	≥ 45

Customer-specific grades are available upon request.

CROMAX SURFACES

Step 2	Environment classified according to ISO 12944-2					Corrosion resistance according to ISO 9227			Technical data			
Surface	C1	C2	C3	C4 or evaporated/damaged oil film	C5	AASS	NSS	CASS	Surface roughness		Chrome thickness μm	Chrome hardness HV _{0.1}
									Ra (μm)	Rt (μm)		
Cromax standard	√	√	-	-	-	Up to 40 h R10	Up to 120 h R10	Up to 64 h R10	≤ 0.2	≤ 2.0	≥ 20	≥ 850
Cromax C	√	√	√	-	-	Up to 80 h R10	Up to 240 h R10	-	≤ 0.2	≤ 2.0	≥ 20	≥ 850
NIKROM 150	√	√	√	√	-	Min. 150 h R10	Min. 500 h R10	-	≤ 0.2	≤ 1.6	Ni ≥ 10, Cr ≥ 20	≥ 850
NIKROM 500	√	√	√	√	√	Min. 500 h R10	Min. 1500 h R10	-	≤ 0.2	≤ 1.6	Ni ≥ 30, Cr ≥ 20	≥ 850

All surfaces can be modified to meet specific customer requests.

CROMAX MANUFACTURING FORMAT AND SERVICE OPTIONS

Step 3	Manufacturing format					Service options					
Location	Max. length	Diameter min.	Diameter max.	Hardening	Packing	Warehousing	Kan-Ban	Cutting	Machining	Friction welding	
Hallstahammar, Sweden	7.8 m	18 mm	150 mm	Continuous	Plastic/cardboard	√	√	√	Upon request	Upon request	
Twente, The Netherlands	7.3 m	18 mm	150 mm	Continuous	Plastic/cardboard	√	√	√	Upon request	Upon request	
Redon, France	7.3 m	18 mm	160 mm	Continuous	Plastic/cardboard	√	√	√	Upon request	-	
Molinella, Italy	6.6 m	10 mm	130 mm	Continuous/skip	Plastic	√	√	√	√	-	
Dudley, UK	-	-	-	-	-	√	√	√*	-	-	
Baltimore, USA	-	-	-	-	-	√	√	√*	-	-	
Pune, India	-	-	-	-	-	√*	√*	√*	-	-	
Shanghai, China	-	-	-	-	-	√	√	√*	-	-	

* Under implementation or planned to be implemented at the latest in 2017.

WIRE

SR-100 Wire

Ovako's SR-100 Wire is a surface removed and inspected wire that increases the quality of the finished product. Sometimes the surface of rolled base materials is sensitive to cracking and decarburisation, which can have a negative effect on the production economy of the finished product. In the production of SR-100 Wire we remove surface defects and carry out a 100% automatic inspection of the surface. Ovako offers wire that meets most requirements for high-grade structural steel and bearing steel. The steels we use for our wire are characterised by high consistency of analysis and cleanliness.

As a rule, our wire is manufactured in accordance with specifications established by our customers. Tolerances and dimensions are adapted to the demands of the finished product and its manufacturing routines.

Size range: SR-100 Wire is produced in any size within the diameter range 11 to 26.5 mm.

Surface treatment: By agreement, SR-100 Wire can be supplied zinc phosphated, soap coated and/or oiled.

Advantages of SR-100 Wire

- Better economy of production
- Fewer quality complaints





SEAMLESS TUBES AND HOLLOW BARS

Our tube products are characterised by uniform properties, close tolerances and small machining allowances. Ovako's tubes and hollow bars are used when there are stringent demands on the material, such as within the rolling bearing, automotive, hydraulic and general engineering industries.

Standard items and stock program

As a service to our customers we have a standard tube program offering smaller order quantities and a shorter lead time than we normally require for a production batch.

Ovako has two such standard programs; both have the tubes stocked at our mill as well as at some of our sales companies and appointed distributors.

In addition to the bearing steel program and the Ovako 280 hollow bar program, we supply tubes in all Ovako standard steel grades.

Bearing steel program

This program covers roughly 350 tube sizes from OD 50 to 243 mm.

Ovako 280 hollow bar program

This program covers microalloyed steel hollow bars in grade Ovako 280 based on the standard EN 10294. We keep roughly 250 dimensions in stock from OD 30 to 256.5 mm.

Both the bearing steel tubes and the Ovako 280 hollow bar program are based on tight machining allowances. For each item we can provide a guaranteed finished turned size for either inner or outer chucking.

Hot-rolled tubes, cold-worked tubes

Machining allowances

In most cases we sell tubes for a specific application. To support this all tubes are delivered with a guaranteed finish machined size. Since we produce our products as close to final clean machined components as possible, our entire size range requires minimal machining, with inner or outer centering on a maximum part length of 2.5 x OD. For longer parts an extra allowance is calculated.

Tolerances

The level of a machining allowance is calculated from the tube tolerances. To support our small machining allowances, Ovako has very tight tolerances across the entire size range, both with regard to outer diameter and wall thickness, as well as other parameters such as straightness and ovality. In practice, this means less machining and better yield for the user, resulting in lower component production costs.

OD/Wall tolerances

As shown in the table below.

Straightness

The maximum deviation from the straight line is 1 mm on a gauge length of 1,000 mm.

Ovality

The maximum out of roundness is 65% of the total outer diameter tolerance.

Lengths

Tubes can be delivered with random manufacturing length or to fixed length with tight tolerances.

Packing

The components are supplied, packed in collared pallets, arranged randomly or stacked, either unprotected or wrapped in waxed paper or plastic shrink-wrapped, depending on the method of transportation. Customer specific packing specifications can also be met.

Labelling and marking

Material delivered directly from our mill is labelled in accordance with automotive standards, including with both alphanumeric and bar code information. Customer specific data can be added on request.

Outer diameter and wall tolerance

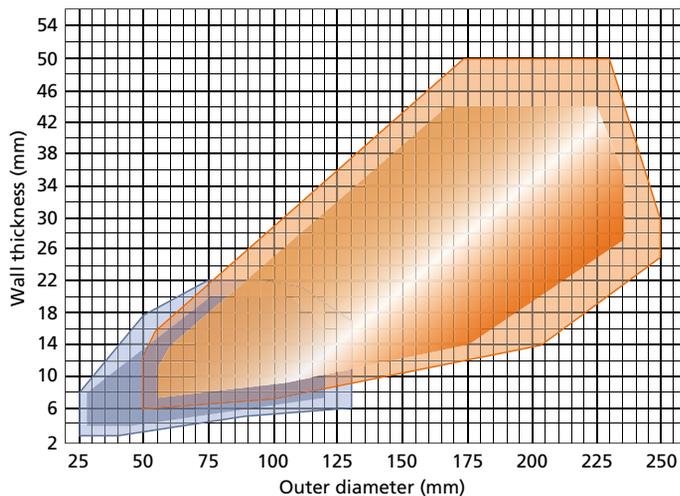
Execution	Size range	OD tolerances	Wall tolerances
Hot-rolled tubes	OD ≤ 80 mm OD > 80 mm Wall < 12 mm Wall ≥ 12 mm	±0.4 mm ±0.5% of OD	±0.7 mm ±(5% x wall thickness +0.1 mm)
Hot-rolled peeled tubes	All sizes Wall < 12 mm Wall ≥ 12 mm	+0.25/-0 mm	±0.8 mm ±(5% x wall thickness +0.2 mm)
Cold-worked tubes cold-rolled or cold-drawn	OD < 40 mm OD 40 – (80)mm OD 80 – Wall < 6 mm Wall 6 – (8) mm Wall 8 –	+0.30/-0 mm* +0.35/-0 mm* +0.40/-0 mm*	±0.30 mm ±0.35 mm ±0.40 mm

* Heat treatment after cold-working alters these tolerances.

Tube lengths

	Hot-rolled	Hot-rolled peeled	Cold-worked (incl. ground)
Length	4–9 m	1.8–9 m	1.8–9 m

Size ranges



Hot-rolled tubes and cold-worked tubes by Ovako offer cleaner components for smaller machining allowances, tighter tolerances and superior surfaces – all delivered on time and with bespoke markings.

Pre-components from tube

An ever-increasing trend in industry is to buy premachined or completely finished components. Ovako has recognised this and invested in the resources required to manufacture components, in particular the supply of cut blanks.

Our production systems are designed to respond to both short lead times and product optimisation to satisfy our customers' requirements. The equipment is flexible and able to handle small quantities of short runs as well as long-run mass-production batches. With broad experience in different types of applications, and a thorough knowledge of our products, Ovako is uniquely able to find an alternative solution best suited to meet individual requirements.

Production program

The diameter, tolerances and surface finish of components are the same as those stated for the full length tube.

Outer diameter: 25 to 254 mm

Lengths: 10 to 5,000 mm

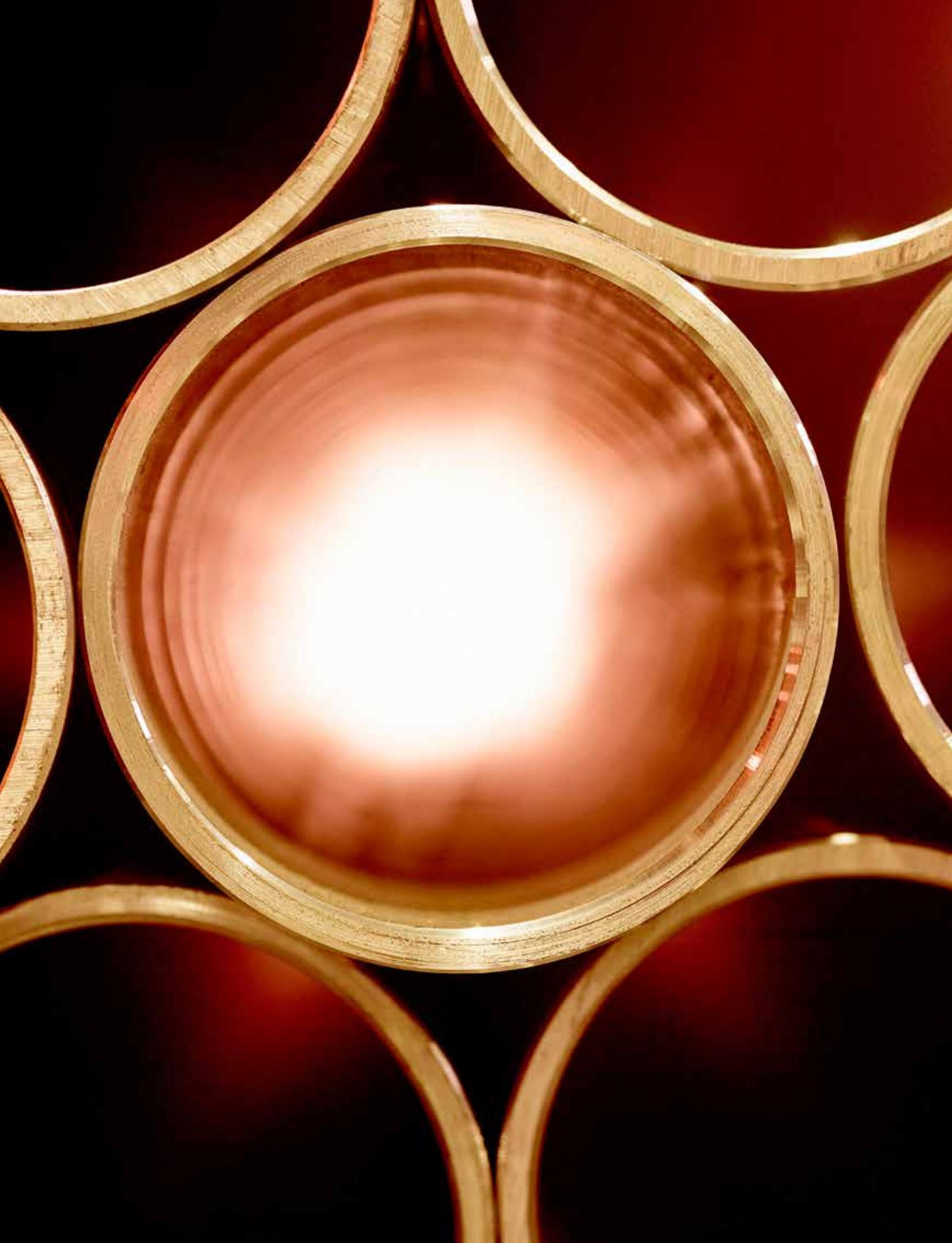
Cut rings can be delivered shot blasted on request.

Deviations from square cut are within the tolerances above, albeit limited to the following values:

- Deviations from square cut are to be a maximum of 1.0% of OD.
- Deviations from square cut determine the tolerance when the deviation exceeds the tolerance.

Packing

The components are supplied, packed in collared pallets, arranged randomly or stacked, either unprotected or wrapped in waxed paper or plastic shrink-wrapped, depending on the method of transportation. Customer specific packing specifications can also be met.



Ovako 280 – hollow bars

Ovako has an extensive hollow bar stock program with approximately 250 dimensions based on the Ovako 280 general structural steel grade. Ovako 280 is produced according to the same principles as our bearing steels, which result in a steel with a very high degree of cleanliness and the greatest possible consistency with regards to properties.

Better economy of production

Thanks to the high strength of the tubes in the hot-rolled condition, they can replace conventionally used, more expensive quenched and tempered tubes or eliminate heat treatment during component manufacturing. Due to the technology used for the production, the Ovako 280 hollow bars gains an inherent strength thanks to the accurate monitoring of chemical composition.

Tight tolerances throughout the whole size range will result in higher yield and reduced costs for raw materials and machining. The tolerances of Ovako 280 hollow bars are considerably closer than those specified by EN 10294, with regard to outer diameter and wall thickness.

Smoother production

The narrow limits of the chemical composition of Ovako 280 hollow bars contribute to smoother production. The outcome of heat treatment is very consistent with small and predictable dimensional changes.

Higher quality steel structures

Ovako 280 T hollow bars carries a very low risk of failures caused by detrimental inclusions. Fatigue strength is of decisive importance for the safety and life of steel structures.

Ovako 280 hollow bars has good weldability and a minimised risk for brittle fracture of welds due to their low carbon equivalent.

Mechanical properties in hot-rolled condition

Wall thickness mm	Yield stress ReHmin MPa	Tensile strength Rmmin MPa	Elongation A5 min %	Hardness Approx. HB	Impact strength at 20°C min Joule
≤ 25	500	670	20	225	27
> 25	470	640	20	220	27

Straightness

Maximum deviation from a straight line is 1 mm/m.

Ovality

Maximum ovality is 65% of the total tolerance of the OD.

Finished dimensions

Finished dimensions are guaranteed for the clean up of part lengths of maximum 3 x OD.

Shot blasting

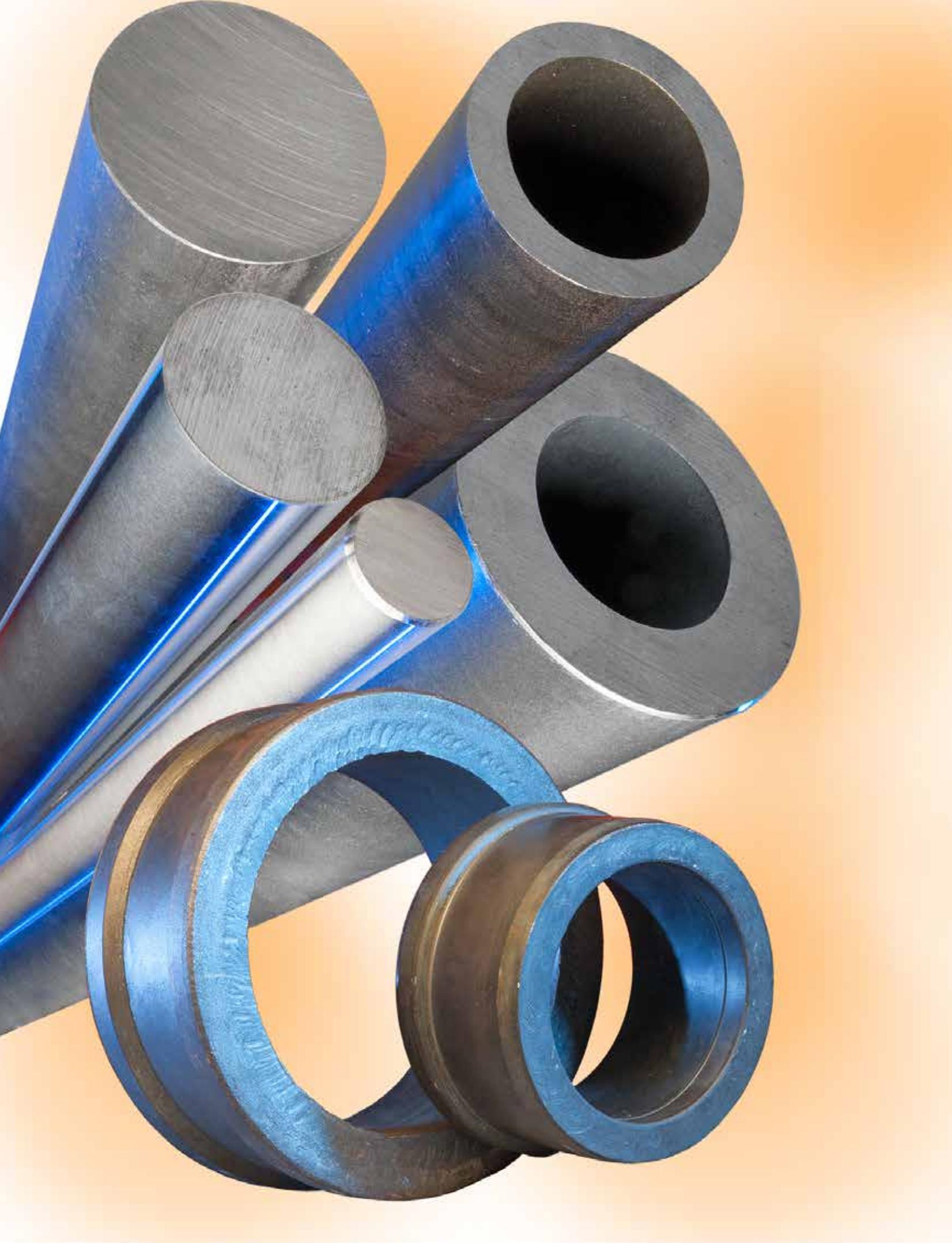
Shot blasting is possible for rings up to 1,200 mm and 500 kg.

Advantages that gives Ovako 280 hollow bars added value

- Versatility in properties covers many customer needs
- Availability – 250 sizes in stock

Good machinability

- Good weldability without the need for preheating up to wall thickness of 25 mm
- Better production economy thanks to higher yield which leads to reduced raw material and machining costs



ROLLED AND FORGED RINGS

As a producer of rolled and forged rings for almost a century, Ovako has a proven track record in this product niche. We strictly control the whole production chain, from melt to the rolling of the rings. For example, to ensure the superior quality of our rings, we carefully manage the levels of oxygen content in the steel to ensure the production of a cleaner steel. Few ring producers can match our commitment to consistent quality from delivery to delivery.

As a result of our quality control, manufacturers can simplify their production processes and reduce their costs because the rings are not only predictably consistent from batch to batch, but also easy to process further. Ovako produces profiled rings with very small allowances and tight tolerances close to the final shape of the end product. In addition, our machined rings enable you to concentrate resources on finishing and/or assembly. Furthermore, Ovako can offer shot blasted rings of diameters up to 4,000 mm and weights up to 5,000 kg.

Rings can also be heat treated before delivery in a variety of executions such as:

- Normalised
- Soft annealed
- Stress relieved
- Isothermally annealed
- Quenched and tempered

Rings to meet the industry's needs

Ovako has long experience with seamless rolled rings characterised by cylindrical or profiled geometry that are very close to the final shape of the finished component. Our reputation for precision is well earned, whether it concerns the physical geometry of the rings or the composition and homogeneity of the steel. The bulk of our production is consumed by the rolling bearing industry, but a substantial share is also delivered to customers in other industrial segments, such as the heavy vehicle, automotive and machine tool manufacturing industries. The dimensional range is 170 to 4,000 mm and the weight range is 7 to 5,000 kg. Forged rings are also supplied up to 3,400 kg.

Parting of rings

Rings with lower widths than stated in the ring mill technical data can often be rolled in multiples and parted. Ovako has a capable machine park for this purpose and expanded its parting capacity with additional state-of-the-art parting technology and a packaging robot.

Machined rings

Ovako has relationships with several high-quality soft machining subcontractors and is growing fast in supplying semi-finished and finished machined rings. Single ring types or complete assortments can be supplied in these executions according to individual customer requirements with full traceability and, if desired, US testing.

Advantages of Ovako's rolled and forged rings

- Consistent quality from batch to batch
- The ability to produce profiled rings close to the final shape of the customer's end product results in more efficient production and cost savings
- Machined rings with close tolerances and an even quality level speeds up production and cuts costs by enabling customers to focus on finishing and/or assembly

A close profile means less machining

Depending on the desired shape of your final product, we can roll rings with very small allowances and tight tolerances.

Some examples of typical profiles are shown below. The specialist will immediately see that this representative sample offers interesting solutions for many manufacturing challenges. Near-net-shaped rings offer the buyer a total cost that is substantially less than other conventional methods of production.

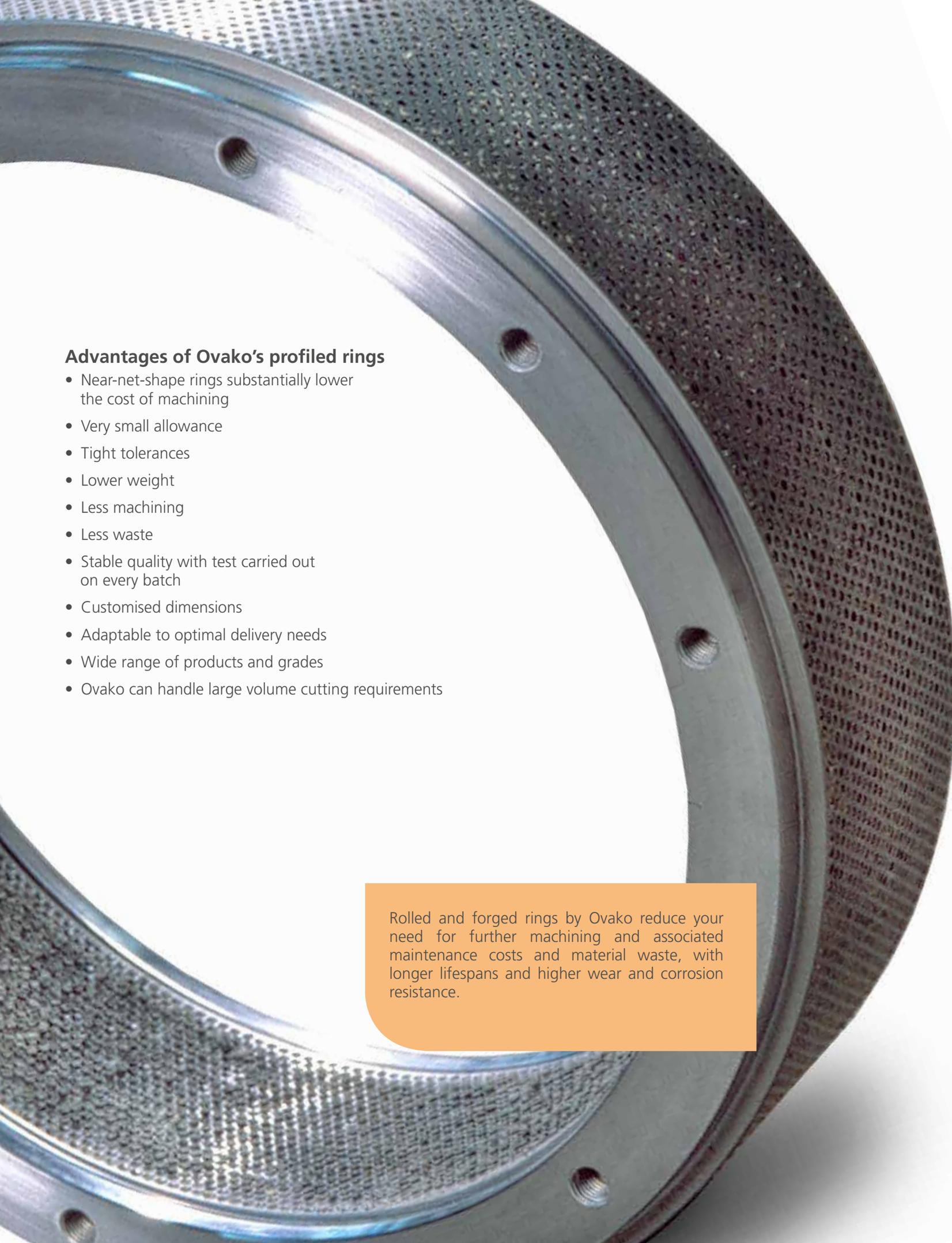
A near-net-shaped rings can be up to 50% lighter than a cylindrical equivalent, while at the same time reducing machining time and waste through lower volume, chip production and handling. Some surfaces may require no further machining at all. Our roll rings also demonstrate the Ovako expertise that few other manufacturers can match.

Size range

Rings are made in five different ring mills and one forging press. Outline production data is provided in the table below:

	Ring diameter	Ring width	Ring weight
Ring mill 8	170–380 mm	50–120 mm	7–20 kg
Ring mill 4	200–750 mm	100–230 mm	20–85 kg
Ring mill 10	300–1,200 mm	100–350 mm	55–250 kg
Press 6	350–2,200 mm	40–1,400 mm	70–3,400 kg
Ring mill 9	400–2,500 mm	50–550 mm	80–2,500 kg
Ring mill 11	500–4,000 mm	80–950 mm	300–5,000 kg



A close-up photograph of a large, circular metal ring. The ring has a smooth, polished inner edge and a perforated outer edge. Several threaded holes are visible along the inner circumference. The lighting highlights the metallic texture and the precision of the manufacturing.

Advantages of Ovako's profiled rings

- Near-net-shape rings substantially lower the cost of machining
- Very small allowance
- Tight tolerances
- Lower weight
- Less machining
- Less waste
- Stable quality with test carried out on every batch
- Customised dimensions
- Adaptable to optimal delivery needs
- Wide range of products and grades
- Ovako can handle large volume cutting requirements

Rolled and forged rings by Ovako reduce your need for further machining and associated maintenance costs and material waste, with longer lifespans and higher wear and corrosion resistance.



GRINDING MEDIA

Grinding balls

Grinding balls are delivered as-rolled or in the quenched and tempered condition. The standard grinding ball steel A810 is of the type 0.83% C, 0.8% Mn, 0.3% Cr. Hardness in the quenched and tempered condition. The A810 grinding balls maintain the same wear resistance from start to finish. Grinding balls in other steel grades can be supplied upon request.

Hardness

Surface	62–66 HRC
Core	60–65 HRC
Average volumetric hardness	61–65 HRC

Nominal standard diameter

Ø mm	Weight per ball g	Theoretical weight kg/m ³	Number of balls/tonne balls	Surface area/ball cm ²	Surface area/m ³ m ²
20	33	4,520	~31,000	12.6	1,738x10 ³
25	64	4,520	~16,000	19.6	1,390x10 ³
30	110	4,520	~9,100	28.3	1,158x10 ³
35	175	4,520	~5,700	38.5	993x10 ³
40	261	4,520	~4,000	50.2	869x10 ³
50	510	4,520	~2,000	78.5	695x10 ³
60	882	4,520	~1,100	113	579x10 ³
70	1,400	4,520	~700	154	497x10 ³

Grinding rods

Grinding rods are delivered in the as-rolled condition. Maximum out of straightness for grinding rods in the as-rolled condition is 2 mm/m for diameters < 92 mm and 0.0100 x L for diameters > 92 mm. On request, maximum out of straightness of 1 mm/m can be achieved by straightening. The grinding rod steel is of type CHA with 0.90% C and 0.70% Cr, or of type C100 with 1.0% C and 0.75% Cr. The dimension range is Ø 40–120 mm. The hardness range is 300–400 HBW.

Mechanical properties

Chemical composition	Condition	Bar diameter Ø mm	Hardness HBW
CHA	As-rolled	40–120	300–400
C100	As-rolled	40–100	340–400



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OVAKO SERVICES

Ovako is pioneering a comprehensive set of integrated, value-added services that focus on your needs as a customer. These range from close collaboration to meet your product's unique technical requirements to providing logistical services with short lead times, on-line ordering and advanced ultrasonic testing, among many other services. Many of our customers want to try out new ideas to improve the characteristics of their steel

products. Our mill engineers, technical specialists and metallurgists will work in shoulder-to-shoulder with you to achieve your goals. We can, for example, fine-tune our heat treatment processes to achieve the specific steel characteristics you want prior to delivery. Our commitment to providing you with a wide range of value-added services that give you the edge starts in the mill and extends all the way to your loading dock.

HEAT TREATMENT

Heat-treated tubes

Our tubes can be supplied in the following heat-treated conditions or combinations thereof:

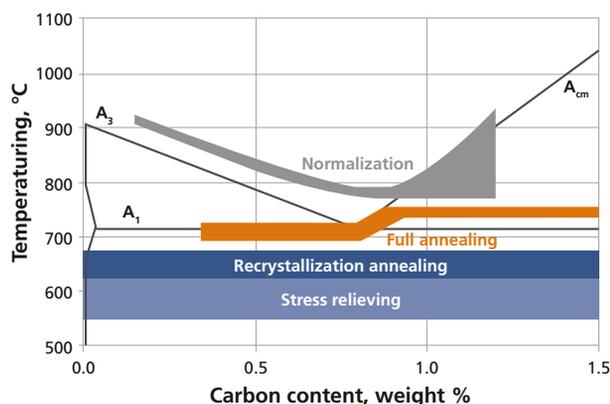
- Normalised
- Soft annealed
- Isothermal annealing
- Stress relief annealed
- Quenched and tempered
- Controlled cooling for case hardening steels
- Annealing in protective atmosphere to avoid decarburisation

Heat-treated bars

Our bars can be supplied in the following heat-treated conditions or combinations thereof:

- Normalised
- Soft annealed

- Spheroidised
- Stress relief annealed
- Isothermal annealed
- Quenched and tempered
- Induction hardened



Iron-carbon diagram with temperature ranges for different types of annealing.

Type of heat treatment/Advantages

Soft or full annealing, (Spheroidising/globulisation)	Softening the steel by offering a structure well suited to machining and cold-forming.
Isothermal annealing	This type of annealing offers, for example, for a case hardening steel, a homogenous structure consisting of ferrite-pearlite, well suited for machining and proper control of chip formation.
Stress relieving	Reducing stress in the steel to avoid distortion during subsequent machining and heat treatment. Also reduces risk of cracking in connection with welding.
Hydrogen annealing	Reduction or elimination of hydrogen in the steel in order to prevent hydrogen embrittlement and subsequent risk of cracking.
Recrystallisation annealing	Restores a cold-worked microstructure. Necessary for further processing involving plastic deformation. Note that the level of deformation controls the grain size and final toughness.
Normalising	Offers the steel a predictable even microstructure of fine grains, ensuring toughness and impact strength as well as improved machinability.
Homogenising	Evens out segregations in the steel. The soaking is performed at high temperature over a long time.
Hardening	Hardening is the general name for heat treatment methods, when the temperature is increased until the structure is transformed into austenite, then dissolving alloying elements (soaking), followed by a rapid cooling (quenching) creating a martensitic or bainitic structure. Hardening is performed in order to increase the hardness or strength of the steel and is normally followed by tempering.
Surface induction hardening	Surface induction hardening offers a hardened surface layer a few millimetres deep with compressive residual stresses.
Tempering	The aim with tempering is to improve the toughness and reduce stresses of the steel. After quenching the martensitic structure has a relatively low toughness with residual stresses. Toughness can be increased and stresses reduced if the steel is reheated to a temperature between 160 to 650°C for 1 to 2 hrs depending on grade. Tempering will reduce the risk of cracking.

OVATRACK

OvaTrack is a customer web portal that enables selected Ovako users, customers and partners to view up-to-date information on the status of their orders and other business activities. Once logged in, customers can view exactly where the order is in the production process and the expected date of delivery.

Site links make it possible for the customer to access detailed information about production steps, materials analysis and charges, and order confirmations, dispatch advice, certificates and invoices are all available as PDF files. OvaTrack also provides information about production schedules for some of the production mills, deliveries to selected destinations and up-to-date information on stocks. OvaTrack data can be exported from the screen to Excel or other systems for further processing. OvaTrack also provides customers with daily e-mail updates known as the Personalised Information Service. This service enables customers to subscribe to alerts about activities related to their orders, such as production, delivery, and invoicing status.

Selected users can also use OvaTrack for entering repeat orders for specific Ovako production units.

In the past year, some 250 customers have used OvaTrack. Today, about 500 are set up to receive alerts or PDF documents. For more information on how you can set up an OvaTrack account, contact your Ovako sales representative.



SERVICES THAT GIVE YOU AN EDGE

Smaller quantities catered for

As a service to our customers, Ovako standard product programs offer smaller order quantities and shorter lead times than we normally require for a production batch. These programs pull together our delivery and storage facilities. A variety of products are stocked at our mills as well as at some of our sales companies and appointed distributors. Our fully transparent services place Ovako at the forefront of meeting industry demands for smaller and lighter components, helping you to attain ever higher standards of cost efficiency.

Special profiles save time and costs

You can eliminate manufacturing steps and significantly lower your costs with Ovako's special profile offerings – e.g. by opting for hot-rolled special profile bar tailored for your unique specifications. We can often find a solution that allows more efficient manufacturing and lower production costs. Even basic simple profiles, such as flats with welding chamfers and rounded corners, often deliver high cost savings compared to machining or gas cutting. Ovako manufactures special profiles both in symmetrical and asymmetrical shapes. Special profile bars can also be marked with your company logo or other information.

Lead times

Few steel producers can match Ovako's commitment to reliable delivery of products, and we have long-standing experience in supplying steel products to customers all over the world with dedicated just-in-time delivery, 24/5. Ovako continuously refines its logistics solutions for shorter lead times, more rational and cost-effective transport systems, and more purpose-driven warehousing routines. Our ultimate goal is to enable you to simplify your material handling, reduce capital costs and enjoy better service. This is reinforced by our comprehensive total quality systems which conform to ISO 9001:2015, ISO 9000: 2015 and ISO/TS 16949:2009.

Planning and warehousing to meet your requirements

Logistics have always been integral to Ovako's operations, which is why you can also benefit from our infrastructure. Customers increasingly demand efficient on-time deliveries for their tube and ring products, and Ovako takes care of these requirements by offering the option to store customers' steels at our facilities and have them delivered to their chosen location. Our strategically located steel centres provide 24/7 storage services. Each centre is managed by our experts, with 70 years of practical knowledge and experience to solve all your requirements.

Technical support with expert knowledge

Making steel is only one part of our job. Just as important is our collaboration with each individual customer, helping you to realise your technical requirements. Comprehensive technical support from Ovako draws on our comprehensive knowledge and experience in a wide range of applications and production methods, not only with regards to the properties of our steel but also heat treatment and machining. We can help you get the most out of your chosen Ovako products and attain the highest quality end result, with the best production economy.

Online ordering for your convenience

Online ordering systems and interactive tools by Ovako give you quicker and enhanced access to the engineering steels you need. Through OvaTrack our customers can enter repeat orders including documentation and distribution set-up. Access the Ovako bespoke online ordering services through our website at www.ovako.com.

OvaTrack – Online customer service support

OvaTrack answers the questions: Where is my order, and when can it be delivered? Our services can ensure that you get the steels you need when you want them, 24 hours around the clock to perfectly suit your project's time scale and cost requirements. OvaTrack contains an automatic e-mailed deviation alert, claims handling function and order amendment ability.

Customer value adding services by Ovako are designed to create real value, and true competitive advantages, across your operations.

Ovako is devoted to comprehensively ensuring that you can receive the steels needed for your unique project requirements, when you want them. We are uniquely equipped to find alternative solutions best suited for your individual specifications, around the clock. Visit our website www.ovako.com where you can find contact details for our sales and technical support.



EASY TO INTERACT WITH OVAKO

Finding the best solutions for your needs is always our priority at Ovako. To achieve this, you can use a number of our service systems and interactive tools for developing solutions and managing orders. These tools also help us keep a close eye on the value created for our customers, and strengthen our services to you as a partner and technical collaborator.

Sales and service centres

Ovako is a leading provider of the highest quality engineering steels that offer operational reliability. Our goal is to provide outstanding know-how and support in developing solutions that give our customers a competitive edge.

The objective of Ovako's on-going product and process development work is to strengthen our position as one of Europe's leading producers. We do this by developing the best possible know-how and practices in metallurgy, materials science, forming, machinability, heat treatment and material testing procedures.

We apply quality management systems to all company processes. To fulfil the high demands from the automotive industry, some Ovako units have included the ISO/TS 16949 requirements in their quality management systems and are third-party certified.

Ovako understands that you require steels that are specifically developed and adapted for your needs. You also need them delivered on time to your chosen location. The centres also offer services such as cutting and chamfering of different pre-components – all depending on your individual requirements. The product is packed, marked and delivered as specified by the customer. Our technical customer support gives advice on product choice, adaptability to the customer's process and other technical information.

Product finder

Steel Navigator can be used to find the right steel for your needs. The tool includes approximately 200 steel grades covering Ovako's business areas.

A search can be performed in a number of ways. Start with the steel designation, chemical composition or application. The grade's main page links to data sheets containing versatile information about the grade.

Scrap and alloy surcharges

Ovako provides monthly updated scrap and alloy surcharges on the web. Scrap and alloy surcharges are commonly used in the industry to adjust steel prices due to national and international variations in cost for scrap and alloying elements. The surcharges are generally based on published prices.

Cutting data

The M-Steel Calculator provide the cutting data for Ovako's M-Steel grades. The user enters data about the cutting conditions and the M-Steel Calculator calculates the recommended cutting speed, cutting stream and the required engine power. M-Steel Calculator provide values for turning, drilling and sawing. M-Steel Calculator can be downloaded and installed from our website at www.ovako.com.

Online customer service support

OvaTrack is an extranet system designed to support customer service and sales activities. It allows selected customers and partners to process information related to their business activities.

DELIVERY CONDITIONS

TERMS OF DELIVERY

For the sale and delivery of goods from the seller ("Ovako") to the buyer, the following terms of delivery shall apply.

The buyer shall acknowledge the application of these terms of delivery by a written confirmation thereof by letter, fax or email. In case these terms of delivery have been invoked in a quotation, then the buyer confirms the application of the terms by accepting the quotation.

General provisions

General Conditions, ALBIF 2000, for Delivery of Iron and Steel Products, etc. (Appendix 1) shall apply between the parties with the additions and adjustments set forth below.

Delivery clause, ALBIF 2000 Clause 4

Stated delivery clause, according to INCOTERMS 2010, in quotation or order acknowledgement, shall apply. The risk to the goods is transferred to the buyer when the goods have been delivered by Ovako according to INCOTERMS 2010.

Conditions for late payment, ALBIF 2000 Clause 24

Instead of Clause 24) of ALBIF 2000, the following shall apply.

In the event of late payment, penalty interest shall be payable with 18%

annual interest from the date of the invoice. In the event of late payment Ovako will issue two notices of delay and the claim will thereafter be submitted to debt collection. Ovako will charge a fee in connection with an issued notice of delay and, in the event that actions for debt collection are being taken, Ovako have the right to charge reasonable costs for such actions.

Disputes, ALBIF 2000 Clause 26

Instead of Clause 26) of ALBIF 2000, the following shall apply.

Any dispute, controversy or claim arising out of or in connection with these delivery terms, or breach, termination or invalidity thereof, shall be finally resolved through arbitration administered by the Arbitration Institute of the Stockholm Chamber of Commerce (the "SCC"). The Rules for Expedited Arbitrations shall apply, unless the SCC in its discretion determines, taking into account the complexity of the case, the amount in dispute and other circumstances, that the Arbitration Rules shall apply. In the latter case, the SCC shall also decide whether the Arbitral Tribunal shall be composed of one or three arbitrators. The site of arbitration shall be in Stockholm, Sweden.

The parties undertake and agree that all arbitral proceedings conducted shall be kept strictly confidential and all information, documentation, materials in whatever form disclosed in the course of such arbitral proceedings shall be used solely for the purpose of those proceedings.

ALBIF 2000, General Conditions for delivery of Iron and Steel Products

Introduction

- 1) These conditions shall form an integral part of all contracts for the sale of goods entered into by the Seller. Inconsistent conditions put forward by the Buyer in orders or otherwise shall be of no effect. Additions to and changes in these conditions are valid only if agreed in writing by and between Seller and Buyer.
- 2) Unless otherwise stated, written offers are binding 14 days from date of issue.
- 3) If an offer, order or order acknowledgement of an order has been made or given in writing, agreements collateral to the contract are not binding until they have been confirmed in writing.

Delivery

- 4) If delivery terms have been agreed, these shall be interpreted in accordance with the INCOTERMS in force on the date of the contract. If no specific delivery terms have been agreed, the term "Ex Works" shall apply.
- 5) In regard to deliveries of goods not stocked by the Seller, the Seller shall, unless otherwise agreed, be entitled to make excess delivery or short delivery in accordance with the practice generally applied in the sector of Swedish industry for the category of goods concerned.

Product information, etc.

- 6) Statements in product information or price lists are binding only if expressly restated in the contract. The Seller does not warrant that the goods are fit for a particular purpose unless expressly agreed in writing.
- 7) Unless otherwise agreed, samples provided are to be regarded as type samples and complete conformity of delivered goods with samples is not promised.

Drawings and technical documents

- 8) All drawings and technical documents supplied by either party to the other shall remain the property of the supplying party and may not by the receiving party be improperly used, reproduced, or disclosed to third parties.

Inspection

- 9) Prior to delivery, the Seller shall inspect the goods to verify compliance with the contract. Any testing, inspection or documentation requested by the Buyer after the conclusion of the contract shall be for the Buyer's account unless otherwise agreed. The Buyer shall inspect the goods upon delivery, as set out in Clause 17.

Delivery time

- 10) If a delivery time is stated as a certain period, that period shall be deemed to commence on the date of the contract.

Delivery delays

- 11) If the Seller or the Buyer finds that he cannot observe the agreed time for the delivery or receipt of the goods, or if a delay appears probable, he shall within a reasonable time give notice to that effect to the other party (notice of delay), stating when delivery or receipt of the goods can be expected.
- 12) If a notified or actual delay in delivering the goods or part of the goods is attributable to the Seller, and if, as the Seller has understood or should have understood, such delay would cause the Buyer material inconvenience, the Buyer shall have the right to cancel the contract with respect to the goods whose delivery is delayed, by giving notice in writing thereof to the Seller. If the Seller has given notice of the delay, the Buyer shall exercise his right to cancel the contract within ten days from receipt of that notice; otherwise the time stated in the notice shall be deemed to be a new agreed time of delivery. If no notice has been given, the right to cancel shall be exercised within ten days from the agreed time of delivery.

- 13) If a notified or actual delay in delivering the goods or part of the goods is attributable to the Buyer, the Seller has the right to extend the delivery time by a period that is reasonable in consideration of the circumstances. If the delay, as the Buyer has understood or should have understood, causes the Seller material inconvenience, the Seller shall have the right to cancel the contract with respect to the goods whose delivery is delayed, by giving notice in writing thereof to the Buyer. If the Buyer has given notice of delay, the Seller shall exercise any cancellation rights within ten days of receiving notice thereof. If no notice has been given, the right to cancel shall be exercised within ten days from the agreed time of delivery.
- 14) If delivery cannot be made at the time stipulated for reasons attributable to the Buyer, the Buyer shall nevertheless be liable to fulfil all payment obligations as if delivery had been made. The Seller shall arrange for storage of the goods at the Buyer's risk and expense. At the Buyer's request, the Seller shall insure the goods at the Buyer's expense.
- 15) If delayed goods are related to goods already delivered, or goods to be delivered later in such a way that the party entitled to cancel the contract would suffer material inconvenience if he were partially to stand by the purchase, the contract may be cancelled in its entirety by that party.
- 16) If delivery of the goods is delayed, damages or liquidated damages shall be payable by the party who has caused the delay only to the extent agreed upon by the parties in writing. However, this limitation does not apply to a party who is guilty of gross negligence.

Claims

- 17) When the goods have been delivered, the Buyer shall verify them in the manner prescribed by sound business practice. Claims regarding any faults in the goods shall be made in writing, specifying the nature and extent of the fault. Claims shall be issued within a reasonable time after the Buyer discovered or should have discovered the fault. The liability of the Seller is limited to faults in respect of which claims in accordance with the above provisions are made within one year of delivery.
Claims regarding any fault in the goods caused by damage during transportation carried out by an independent carrier shall be addressed directly to the carrier in accordance with the terms and conditions applicable to the carriage, and, if the damage occurred when the Seller bore the risk for the goods, also to the Seller in accordance with the preceding paragraph.
The above-mentioned provisions regarding faults in the goods shall also in their relevant parts apply with respect to shortages in quantities.

Remedies in respect of faults or shortages

- 18) If there is in goods delivered any fault for which the Seller is liable and in respect of which a claim has been made in accordance with the provisions of section 17, the Seller shall at his own expense and with the promptness demanded by the circumstances at his own option, but after consultation with the Buyer, either rectify the fault (e.g. by repair or reprocessing), reduce the price in proportion to the fault, or deliver new and faultless goods in return for the faulty goods. The Seller shall thereby defray the necessary costs of transportation, but not any expenditure incurred for dismantling, installation or processing, unless otherwise agreed. If the Seller neglects to fulfil his obligations in accordance with the provisions of the first paragraph of this section, the Buyer has the right – after notification in writing to the Seller, but not subject to his consent – to remedy the fault himself and receive justifiable compensation from the Seller in respect thereof, or, if such a remedy is impossible and the fault is substantial, to cancel the contract in so far as the faulty goods are concerned. If faulty goods are related to goods already delivered, or goods to be delivered later in such a way that the Buyer would suffer material inconvenience if he were partially to stand by the purchase, the Buyer may cancel the contract in its entirety. Apart from the remedies expressly set out in the contract or in these conditions, no other remedies can be invoked in respect of a fault in the goods. The Seller is not liable for direct or indirect damage or losses suffered in consequence of a fault in the goods. However, this limitation of the Seller's liability does not apply if the Seller is guilty of gross negligence. The above-mentioned provisions regarding faults in the goods shall also in their relevant parts apply with respect to shortages in quantities.

Grounds of discharge from liability (force majeure)

- 19) The Seller and the Buyer have no right in relation to each other to appeal to negligence in the fulfilment of the contract, if such fulfilment is substantially rendered difficult by industrial action, or by circumstances beyond the control of the party that could not have been anticipated when the contract was concluded, such as, but not limited to war, mobilisation, political disturbances, governmental intervention of various kinds, currency restrictions, fire, act of God, power shortages, interference with transport, extensive operational breakdowns, or substantial scrapping of goods by a party, or by deficient performance on the part of sub-suppliers owing to any circumstance such as is referred to in this section. If a party has not immediately notified the other party in writing that such a circumstance has occurred, he has no right to appeal to this as grounds for discharge from liability. If any circumstance such as is referred to in this section has the effect that the contract cannot be fulfilled within a reasonable time, either of the parties has the right to cancel the contract in writing to the extent that it has not been fulfilled. If, in such a case, the Buyer cancels the contract, the Seller shall be entitled to receive compensation for the costs incurred by discharging delivery obligations up to the time of the contract's cancellation; but not for what he can gain in the course of his business.

Infringement of rights of third parties

- 20) If goods are delivered in accordance with drawings, models or other patterns submitted by the Buyer, or in accordance with analysis prescriptions or descriptions given by him, the Buyer shall indemnify the Seller for any infringement of the rights of third parties, such as patents, patterns, or trademarks.

Tools and models

- 21) Repairs of tools and models, belonging to the Buyer and in the custody of the Seller, shall be paid for by the Buyer, if such repairs are caused by wear and tear or reasons not attributable to the Seller. The Seller shall be liable for keeping such tools and models during the agreed period of delivery. If they remain with the Seller after the period of delivery, the Seller shall keep them at the expense of the Buyer, unless otherwise agreed. All storage of such tools and models shall be at the risk of the Buyer.
After three years have lapsed since completion of delivery of the goods, the Seller has the right – after notification to the Buyer in writing – to discard or return such tools and models unless otherwise agreed.
Transportation of such tools and models shall be effected at the risk and expense of the Buyer.
The term "tools and models" in this context includes other equipment required for the production of the goods and belonging to the Buyer.

Cancellation

- 22) The Buyer may not without the consent of the Seller cancel any contracted deliveries.

Retention of title

- 23) The Seller reserves the title to and property in goods delivered until full payment thereof.

Payment

- 24) Amounts overdue for payment will entitle the Seller to charge the Buyer interest. Such interest shall be calculated on a day-to-day basis on the amount outstanding from the date of maturity until paid at a rate 6% above the official Repo Rate of the European Central Bank.

Governing law

- 25) The contract shall be governed by Swedish law, with exclusion of its conflicts of law rules as well as the International Sale of Goods Act (1987:822).

Disputes

- 26) Any disputes shall be settled by arbitration in Stockholm, Sweden, in accordance with the provisions of the Swedish Act on Arbitration. Either party may, however, initiate legal proceedings against the other in a court of law that has jurisdiction to collect sums of money that are indisputably due and outstanding under the contract.

About Ovako

Ovako develops high-tech steel solutions for, and in co-operation with, its customers in the bearing, transport and manufacturing industries. Our steel makes our customers' end products more resilient and extends their useful life, ultimately resulting in smarter, more energy-efficient and more environmentally-friendly products.

Our production is based on recycled scrap and includes steel in the form of bar, tube, ring and pre-components. Ovako is represented in more than 30 countries, and has sales offices in Europe, North America and Asia. Ovako's sales in 2015 amounted to EUR 834 million, and the company had 2,905 employees at year-end. For more information, please visit us at www.ovako.com

MARKETING AND SALES:

Scandinavia

Ovako Sales Unit Scandinavia
Centralplan 1
SE-691 32 Karlskoga
Sweden
Phone: +46 591 600 00

Finland & Baltics

Ovako Imatra Oy Ab
Steel Service Centre
Teollisuuskujja 1
FI-14200 Turenki
Finland
Phone: +358 40 751 5249

Central Europe

Ovako GmbH
Postfach 12 55
DE-40672 Erkrath
Germany
Phone: +49 211 250 40

Benelux

Ovako BeNeLux
Bedrijvenpark Twente 295
NL-7602 KK Almelo
The Netherlands
Phone: +31 546 588 360

France & Spain

Ovako S.A.S.
14 rue de Mirande
FR-21000 Dijon
France
Phone: +33 3 8054 1515

Italy

Ovako Molinella S.p.A.
Magazzino Prodotti Dal Pronto
Via Varesina 204
I-20156 Milano
Italy
Phone: +39 51 690 0332

United Kingdom & Ireland

Ovako Ltd.
Unit 2 York's Park
Blowers Green Road
Dudley DY2 8UL
United Kingdom
Phone: +44 138 421 3940

Eastern Europe

Ovako Polska Sp. z o.o.
Ul. Patriotow 110, lok. 312
04-844 Warszawa
Poland
Phone: +48 22 870 0503

Russia & Ukraine

Ovako LLC
Office 2401, fl. 24
Savelkinskiy proezd, bldg. 4
Zelenograd
124482 Moscow
Russia
Phone: +7 495 228 0780

Asia Pacific

Ovako Steel Marketing
Singapore
E-mail: sales.asia@ovako.com
Phone: +65 9675 9052

China

Ovako Special
Steel Trading Co. Ltd.
No. 189 Fulian 2nd Road
Baoshan District
Shanghai
China 201906
Phone: +86 21 3366 2787

North America

Ovako North America Inc.
1096 Assembly Drive, Suite 312
Fort Mill, SC 29708
USA
Phone: +1 803 802 1500

Rest of the World

Ovako Head Office
Ovako AB
P.O. Box 1721
SE-111 87 Stockholm
Sweden
Visiting address:
Kungsträdgårdsgatan 10
Phone: +46 8 622 1300

