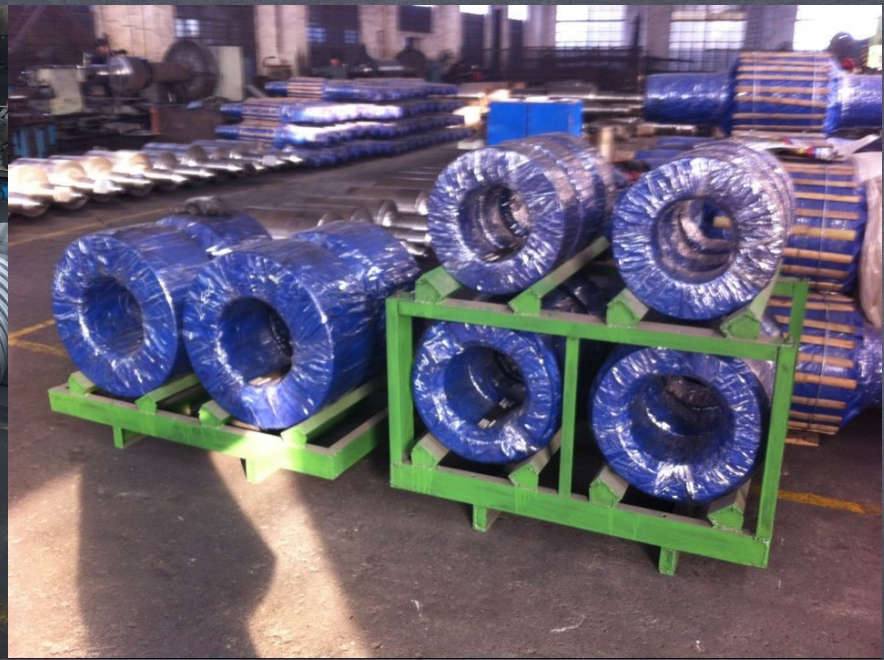




常州市瑞宏轧辊有限公司
Leon Roll China co.,Ltd

introduction



Professional Rolls(Ring) supplier

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I.company overview

LRC Rolls is a professional mill roll foundry doing the cast iron roll to export.55% of our rolls are export.

Corporate	Weiping Jiang
Company Property	Private
Registered Capital	13 million RMB
Number of employees	150
Technical staff	15
Registered address	Jiangsu Changzhou . China
2010 Turnover	40 million RMB
2011 Turnover	45 million RMB
2012 Turnover	60 million RMB
2013 Turnover	63 million RMB
2014 Turnover	65 million RMB
Business capacity:	120 million RMB
Main Product:	Mill roll,Mill Ring
Enterprise Mode:	Casting and machining
Trade:	Metallurgy Heavy Industry
Main customer1:	Steel factory
Process	ISO90001

Rolls overview



Materil	Size	Casting type	Hardness (HSC)
SGP	265-800	Staic	50-65
SGP	265-700	Centrifugal	55-70
SGA	265-700	Centrifugal	65-75
adamite	350-1150	Staic	45-55
High speed		Centrifugal	70-90

Pearlitic nodular

化学成分 Chemical ingredients

轧辊名称 Roll name	材质代码 Material code	C	Si	Mn	Ni	Cr	Mo	Mg
珠光体球墨铸铁轧辊Ⅰ Pearlitic nodular cast iron roll Ⅰ	SGP Ⅰ	3.00~3.40	1.40~1.90	0.40~0.80	1.50~2.00	0.20~0.60	0.20~0.60	≥0.04
珠光体球墨铸铁轧辊Ⅱ Pearlitic nodular cast iron roll Ⅱ	SGP Ⅱ	3.00~3.40	1.20~2.00	0.40~0.80	2.01~2.50	0.20~1.00	0.20~0.60	≥0.04
珠光体球墨铸铁轧辊Ⅲ Pearlitic nodular cast iron roll Ⅲ	SGP Ⅲ	3.00~3.40	1.00~2.00	0.40~0.80	2.51~3.00	0.20~1.20	0.20~0.60	≥0.04

物理性能 Physical property

轧辊名称 Roll name	材质代码 Material code	辊身硬度 HSD Hardness of roll body	辊颈硬度 HSD Hardness of roll neck	抗拉强度 Mpa Tensile strength
珠光体球墨铸铁轧辊Ⅰ Pearlitic nodular cast iron roll Ⅰ	SGP Ⅰ	45~55	35~55	>450
珠光体球墨铸铁轧辊Ⅱ Pearlitic nodular cast iron roll Ⅱ	SGP Ⅱ	55~65	35~55	>450
珠光体球墨铸铁轧辊Ⅲ Pearlitic nodular cast iron roll Ⅲ	SGP Ⅲ	62~72	35~55	>450

金相组织 Metallurgical structure

轧辊名称 Roll name	材质代码 Material code	金相组织 Metallurgical structure
珠光体球墨铸铁轧辊Ⅰ Pearlitic nodular cast iron roll Ⅰ	SGP Ⅰ	珠光体+渗碳体+少量石墨 Pearlite+ Cementite+ A small amount of graphite
珠光体球墨铸铁轧辊Ⅱ Pearlitic nodular cast iron roll Ⅱ	SGP Ⅱ	珠光体+渗碳体+少量石墨 Pearlite+ Cementite+ A small amount of graphite
珠光体球墨铸铁轧辊Ⅲ Pearlitic nodular cast iron roll Ⅲ	SGP Ⅲ	珠光体+碳化物+球状石墨 或 珠光体+少量贝氏体+碳化物+球状石墨 Pearlite+ Carbonide+ Spheroidal graphite Or Pearlite +A small amount of bainite +Carbonide+ Spheroidal graphite

应用范围 Range of application

轧辊名称 Roll name	材质代码 Material code	应用范围 Range of application
珠光体球墨铸铁轧辊Ⅰ Pearlitic nodular cast iron roll Ⅰ	SGP Ⅰ	型材、棒材、线材及窄带钢轧机粗、中轧机架 Profile material、Rods and bars、Wire rod and narrow strip steel rolling mill set、Intermediate rolling stand
珠光体球墨铸铁轧辊Ⅱ Pearlitic nodular cast iron roll Ⅱ	SGP Ⅱ	型材、棒材、线材及窄带钢轧机粗、中轧机架 Profile material、Rods and bars、Wire rod and narrow strip steel rolling mill set、Intermediate rolling stand
珠光体球墨铸铁轧辊Ⅲ Pearlitic nodular cast iron roll Ⅲ	SGP Ⅲ	型材、棒材、线材及窄带钢轧机粗、中轧机架 Profile material、Rods and bars、Wire rod and narrow strip steel rolling mill set、Intermediate rolling stand

承制规格 Manufacturing specifications

辊身直径≤1500mm Roll diameter≤1500mm
辊身长度≤3000mm Roll length≤3000mm

Bainitic nodular

化学成分 Chemical ingredients

轧辊名称 Roll name	材质代码 Material code	C	Si	Mn	Ni	Cr	Mo	Mg
贝氏体球墨离心复合铸铁轧辊Ⅰ Bainitic nodular centrifugal compound cast iron roll Ⅰ	SGA Ⅰ	3.00~3.40	1.20~2.20	0.40~0.80	3.01~3.50	0.20~0.80	0.50~1.00	≥0.04
贝氏体球墨离心复合铸铁轧辊Ⅱ Bainitic nodular centrifugal compound cast iron roll Ⅱ	SGA Ⅱ	3.00~3.40	1.00~2.00	0.40~0.80	3.51~4.50	0.20~1.00	0.50~1.00	≥0.04

物理性能 Physical property

轧辊名称 Roll name	材质代码 Material code	辊身硬度 HSD Hardness of roll body	辊颈硬度 HSD Hardness of roll neck	抗拉强度 Mpa Tensile strength
贝氏体球墨离心复合铸铁轧辊Ⅰ Bainitic nodular centrifugal compound cast iron roll Ⅰ	SGA Ⅰ	55~78	32~45	>350
贝氏体球墨离心复合铸铁轧辊Ⅱ Bainitic nodular centrifugal compound cast iron roll Ⅱ	SGA Ⅱ	60~80	32~45	>350

金相组织 Metallurgical structure

轧辊名称 Roll name	材质代码 Material code	金相组织 Metallurgical structure
贝氏体球墨离心复合铸铁轧辊Ⅰ Bainitic nodular centrifugal compound cast iron roll Ⅰ	SGA Ⅰ	贝氏体+少量马氏体+碳化物+石墨 Bainite+ A small amount of martensite + Carbonide+ Graphite
贝氏体球墨离心复合铸铁轧辊Ⅱ Bainitic nodular centrifugal compound cast iron roll Ⅱ	SGA Ⅱ	贝氏体+少量马氏体+碳化物+石墨 Bainite+ A small amount of martensite + Carbonide+ Graphite

应用范围 Range of application

轧辊名称 Roll name	材质代码 Material code	应用范围 Range of application
贝氏体球墨离心复合铸铁轧辊Ⅰ Bainitic nodular centrifugal compound cast iron roll Ⅰ	SGA Ⅰ	型钢、棒材、线材轧机粗轧、中轧、预精轧机架；无缝钢管连轧机定减径机架 Profile material、Rods and bars、Wire rolling mill Rough rolling、Intermediate rolling、Pre-finishing mill stand；Seamless steel tube tandem mill microtension reducing-sizing stand
贝氏体球墨离心复合铸铁轧辊Ⅱ Bainitic nodular centrifugal compound cast iron roll Ⅱ	SGA Ⅱ	型钢、棒材、线材轧机粗轧、中轧、预精轧机架；无缝钢管连轧机定减径机架 Profile material、Rods and bars、Wire rolling mill Rough rolling、Intermediate rolling、Pre-finishing mill stand；Seamless steel tube tandem mill microtension reducing-sizing stand

承制规格 Manufacturing specifications

辊身直径≤1500mm Roll diameter≤1500mm
辊身长度≤3000mm Roll length≤3000mm

Hi Chrome

化学成分 Chemical ingredients

轧辊名称 Roll name	材质代码 Material code	C	Si	Mn	Ni	Cr	Mo
CS	HCrS	1.00-1.80	0.40-1.00	0.50-1.00	0.50-1.50	8.00-15.00	1.50-4.50

物理性能 Physical property

轧辊名称 Roll name	材质代码 Material code	辊身硬度 HSD Hardness of roll body	辊颈硬度 HSD Hardness of roll neck	抗拉强度 Mpa Tensile strength
CS	HCrS	70-85	35-45	≥450

金相组织 Metallurgical structure

辊身工作层金相组织为：回火索氏体 或 马氏体+碳化物

The matrix structure of the working layer on roll body is: Tempered sorbite or martensite+ Carbonide

应用范围 Range of application

轧辊名称 Roll name	材质代码 Material code	应用范围 Range of application
CS	HCrS	热轧带钢粗轧、精轧前段工作辊、宽中厚板轧机工作辊；型钢万能轧机轧辊 Hot-rolling strip steel rough rolling、Working roll in the front part of finishing rolling mill、 Working roll for wide/mid-thickness rolling mill、Mill roll of universal rolling mill for profile steel

承制规格 Manufacturing specifications

辊身直径 ≤1500mm Roll diameter ≤1500mm
辊身长度 ≤4300mm Roll length ≤4300mm

High speed

化学成分 Chemical Analysis

轧辊名称 Designation of rolls	材质代码 Material code	C	Si	Mn	Ni	Cr	Mo	V	W
HSS	HSS	1.50-2.20	0.30-1.00	0.40-1.20	0.00-1.50	3.00-8.00	2.00-8.00	2.00-9.00	0.00-0.05
S-HSS	S-HSS	0.60-1.20	0.80-1.50	0.50-1.00	0.20-1.20	3.00-9.00	2.00-5.00	0.40-3.00	0.00-0.05

物理性能 Physical Properties

轧辊名称 Designation of rolls	材质代码 Material code	辊身硬度 HSD Barrel hardness	辊颈强度 Mpa Roll neck strength	抗拉强度 Mpa Tensile strength
HSS	HSS	75-95	30-45	400-500
S-HSS	S-HSS	75-98	30-45	400-500

金相组织 Microstructure

辊身工作层金相组织为：回火马氏体+少量碳化物+碳化物

A small amount of tempered martensite + carbide + carbon

应用范围 Application

轧辊名称 Designation of rolls	材质代码 Material code	应用范围 Application
HSS	HSS	热轧带钢、棒材精轧辊、高速线材预精轧、型钢万能轧机轧辊、宽中厚板轧机工作辊 Rolled strip, bar finishing roller, high speed wire pre-finishing, steel roller univers rolling mill, wide plate mill work rolls
S-HSS	S-HSS	热轧带钢粗轧工作辊、冷轧带钢工作辊、中间辊 Rough rolling hot strip mill work rolls, cold rolled strip steel work roll, intermediate

承制规格 Scope of supply

辊身直径 ≤1000mm barrel diameter ≤1000mm
辊身长度 ≤3000mm barrel length ≤3000mm

indefinite Chilled

化学成分 Chemical ingredients

轧辊名称 Roll name	材质代码 Material code	C	Si	Mn	Ni	Cr	Mo
铬钼无限冷硬铸铁轧辊 Nickel-chromium-molybdenum indefinite chilled cast iron roll	IC	3.1~3.4	0.6~0.9	0.5~1.0		0.7~1.1	0.2~0.6
镍铬钼无限冷硬铸铁轧辊 (I) Nickel-chromium-molybdenum indefinite chilled cast iron roll (I)	IC I	3.1~3.4	0.6~0.9	0.5~1.0	0.6~0.8	0.7~1.1	0.2~0.6
镍铬钼无限冷硬铸铁轧辊 (II) Nickel-chromium-molybdenum indefinite chilled cast iron roll (II)	IC II	3.1~3.4	0.6~1.0	0.5~1.0	2.2~2.8	0.7~1.1	0.2~0.6
镍铬钼无限冷硬铸铁轧辊 (III) Nickel-chromium-molybdenum indefinite chilled cast iron roll (III)	IC III	3.1~3.4	0.6~1.0	0.5~1.0	2.2~2.8	0.8~1.3	0.2~1.0
镍铬钼无限冷硬铸铁轧辊IV Nickel-chromium-molybdenum indefinite chilled cast iron roll (IV)	IC IV	3.1~3.4	0.6~1.0	0.5~1.0	3.1~4.3	1.0~1.3	0.2~1.0
镍铬钼无限冷硬铸铁轧辊V Nickel-chromium-molybdenum indefinite chilled cast iron roll (V)	IC V	3.1~3.4	0.8~1.2	0.5~1.0	3.8~4.5	1.4~2.0	0.2~1.2

物理性能 Physical property

轧辊名称 Roll name	材质代码 Material code	辊身硬度 HSD Hardness of roll body	辊颈硬度 HSD Hardness of roll neck	抗拉强度 Mpa Tensile strength
铬钼无限冷硬铸铁轧辊 Nickel-chromium-molybdenum indefinite chilled cast iron roll	IC	50~70	35~55	>160
镍铬钼无限冷硬铸铁轧辊 (I) Nickel-chromium-molybdenum indefinite chilled cast iron roll (I)	IC I	55~72	35~55	>160
镍铬钼无限冷硬铸铁轧辊 (II) Nickel-chromium-molybdenum indefinite chilled cast iron roll (II)	IC II	55~72	35~55	>160
镍铬钼无限冷硬铸铁轧辊 (III) Nickel-chromium-molybdenum indefinite chilled cast iron roll (III)	IC III	65~78	35~55	>350
镍铬钼无限冷硬铸铁轧辊 (IV) Nickel-chromium-molybdenum indefinite chilled cast iron roll (IV)	IC IV	70~83	35~55	>350
镍铬钼无限冷硬铸铁轧辊 (V) Nickel-chromium-molybdenum indefinite chilled cast iron roll (V)	IC V	77~82	35~55	>350

金相组织 Metallurgical structure

轧辊名称 Roll name	材质代码 Material code	金相组织 Metallurgical structure
铬钼无限冷硬铸铁轧辊 Nickel-chromium-molybdenum indefinite chilled cast iron roll	IC	珠光体+渗碳体+少量石墨 Pearlite+ Cementite+ A small amount of graphite
镍铬钼无限冷硬铸铁轧辊 (I) Nickel-chromium-molybdenum indefinite chilled cast iron roll (I)	IC I	细珠光体+渗碳体+少量石墨 Nodular pearlite+ Cementite+ A small amount of graphite
镍铬钼无限冷硬铸铁轧辊 (II) Nickel-chromium-molybdenum indefinite chilled cast iron roll (II)	IC II	细珠光体+渗碳体+少量石墨 Nodular pearlite+ Cementite+ A small amount of graphite
镍铬钼无限冷硬铸铁轧辊 (III) Nickel-chromium-molybdenum indefinite chilled cast iron roll (III)	IC III	索氏体+渗碳体+少量石墨 Sorbite+ Cementite+ A small amount of graphite
镍铬钼无限冷硬铸铁轧辊 (IV) Nickel-chromium-molybdenum indefinite chilled cast iron roll (IV)	IC IV	回火索氏体+贝氏体+碳化物+石墨或贝氏体+少量马氏体+碳化物+石墨 tempered sorbite+ Bainite+ Carbide+ GraphiteOr Bainite+ A small amount of martensite+Carbide+ Graphite
镍铬钼无限冷硬铸铁轧辊 (V) Nickel-chromium-molybdenum indefinite chilled cast iron roll (V)	IC V	回火索氏体+贝氏体+碳化物+石墨或贝氏体+少量马氏体+碳化物+石墨 tempered sorbite+ Bainite+ Carbide+ GraphiteOr Bainite+ A small amount of martensite+Carbide+ Graphite

应用范围 Range of application

轧辊名称 Designation of rolls	材质代码 Material code	应用范围 Application
铬钼无限冷硬铸铁轧辊 Nickel-chromium-molybdenum indefinite chilled cast iron roll	IC	型材、棒材、线材轧机中轧、精轧机架 Profile material, Rod-wire material, Narrow strip steel rolling mill intermediate rolling, Finishing rolling stand
镍铬钼无限冷硬铸铁轧辊 (I) Nickel-chromium-molybdenum indefinite chilled cast iron roll (I)	IC I	型材、棒材、线材轧机中轧、精轧机架 Profile material, Rod-wire material, Narrow strip steel rolling mill intermediate rolling, Finishing rolling stand
镍铬钼无限冷硬铸铁轧辊 (II) Nickel-chromium-molybdenum indefinite chilled cast iron roll (II)	IC II	型材、棒材、线材轧机中轧、精轧机架 Profile material, Rod-wire material, Narrow strip steel rolling mill intermediate rolling, Finishing rolling stand
镍铬钼无限冷硬铸铁轧辊 (III) Nickel-chromium-molybdenum indefinite chilled cast iron roll (III)	IC III	型材、棒材、线材轧机中轧、精轧机架 Profile material, Rod-wire material, Narrow strip steel rolling mill intermediate rolling, Finishing rolling stand
镍铬钼无限冷硬铸铁轧辊 (IV) Nickel-chromium-molybdenum indefinite chilled cast iron roll (IV)	IC IV	型材、棒线材、窄带钢轧机精轧机架, 中厚板、平整机架、带钢精轧 Profile material, Rod-wire material, narrow strip steel rolling mill finishing stand, Mid-thickness plate, Levelling machine stand, Strip steel finishing rolling
镍铬钼无限冷硬铸铁轧辊 (V) Nickel-chromium-molybdenum indefinite chilled cast iron roll (V)	IC V	中厚板、平整机架、带钢精轧 Mid-thickness plate, Levelling machine stand, Strip steel finishing rolling

■ 承制规格 Manufacturing specifications 辊身直径≤1400mm Roll diameter≤1400mm 辊身长度≤4600mm Roll length≤4600mm

Alloy Chilled

化学成分 Chemical ingredients

轧辊名称 Roll name	材质代码 Material code	C	Si	Mn	Ni	Cr	Mo
镍铬钼冷硬铸铁轧辊 (I) NiCrMo chilled cast iron roll (I)	CC I	3.00~3.40	0.30~0.80	0.20~1.00	0.50~1.00	0.20~0.60	0.20~0.60
镍铬钼冷硬铸铁轧辊 (II) NiCrMo chilled cast iron roll (II)	CC II	3.00~3.40	0.30~0.80	0.20~1.00	1.10~2.00	0.30~1.20	0.20~0.60
镍铬钼冷硬铸铁轧辊 (III) NiCrMo chilled cast iron roll (III)	CC III	3.00~3.40	0.30~0.80	0.20~1.00	2.10~3.00	0.50~1.50	0.20~0.60
镍铬钼冷硬铸铁轧辊 (IV) NiCrMo chilled cast iron roll (IV)	CC IV	3.00~3.40	0.30~0.80	0.20~1.00	3.10~4.00	0.50~1.70	0.20~0.60

物理性能 Physical property

轧辊名称 Roll name	材质代码 Material code	辊身硬度 HSD Hardness of roll body	辊颈硬度 HSD Hardness of roll neck	抗拉强度 Mpa Tensile strength
镍铬钼冷硬铸铁轧辊 (I) NiCrMo chilled cast iron roll (I)	CC I	60~70	32~50	>150
镍铬钼冷硬铸铁轧辊 (II) NiCrMo chilled cast iron roll (II)	CC II	62~75	35~52	>150
镍铬钼冷硬铸铁轧辊 (III) NiCrMo chilled cast iron roll (III)	CC III	65~80	32~45	>350
镍铬钼冷硬铸铁轧辊 (IV) NiCrMo chilled cast iron roll (IV)	CC IV	70~85	32~45	>350

金相组织 Metallurgical structure

轧辊名称 Roll name	材质代码 Material code	金相组织 Metallurgical structure
镍铬钼冷硬铸铁轧辊 (I) NiCrMo chilled cast iron roll (I)	CC I	珠光体+渗碳体 Pearlite+ Cementite
镍铬钼冷硬铸铁轧辊 (II) NiCrMo chilled cast iron roll (II)	CC II	细珠光体+渗碳体 Nodular pearlite+ Cementite
镍铬钼冷硬铸铁轧辊 (III) NiCrMo chilled cast iron roll (III)	CC III	细珠光体+渗碳体 Nodular pearlite+ Cementite
镍铬钼冷硬铸铁轧辊 (IV) NiCrMo chilled cast iron roll (IV)	CC IV	索氏体+渗碳体 Sorbite+ Cementite

应用范围 Range of application

轧辊名称 Roll name	材质代码 Material code	应用范围 Range of application
镍铬钼冷硬铸铁轧辊 (I) NiCrMo chilled cast iron roll (I)	CC I	型材、棒材、线材轧机及窄带钢轧机精轧机架 Profile material, Rods and bars, Wire rod rolling mill and narrow strip steel rolling mill finishing stand
镍铬钼冷硬铸铁轧辊 (II) NiCrMo chilled cast iron roll (II)	CC II	型材、棒材、线材轧机及窄带钢轧机精轧机架 Profile material, Rods and bars, Wire rod rolling mill and narrow strip steel rolling mill finishing stand
镍铬钼冷硬铸铁轧辊 (III) NiCrMo chilled cast iron roll (III)	CC III	型材、棒材、线材轧机及窄带钢轧机精轧机架 Profile material, Rods and bars, Wire rod rolling mill and narrow strip steel rolling mill finishing stand
镍铬钼冷硬铸铁轧辊 (IV) NiCrMo chilled cast iron roll (IV)	CC IV	型材、棒材、线材轧机及窄带钢轧机精轧机架 Profile material, Rods and bars, Wire rod rolling mill and narrow strip steel rolling mill finishing stand

承制规格 Manufacturing specifications

辊身直径≤500mm Roll diameter≤500mm
辊身长度≤1000mm Roll length≤1000mm

Alloy Steel (surfacing)

adamite rolls

化学成分 Chemical ingredients

轧辊名称 Roll name	材质代码 Material code	C	Si	Mn	Ni	Cr	Mo
Zu60CrMoMn	AS60	0.55-0.65	0.20-0.45	0.90-1.20		0.80-1.20	0.20-0.45
Zu 60CrMoMnNi	AS60 I	0.55-0.65	0.20-0.60	0.50-1.00	0.20-1.50	0.80-1.20	0.20-0.60
Zu65CrNiMo	AS65 I	0.60-0.70	0.20-0.60	0.50-0.80	0.20-0.50	0.80-1.20	0.20-0.45
Zu70Mn	AS70	0.65-0.75	0.20-0.45	0.80-1.40			
Zu70Mn2	AS70 I	0.65-0.75	0.20-0.45	1.40-1.80			
Zu70Mn2Mo	AS70 II	0.65-0.75	0.20-0.45	1.40-1.80			0.20-0.45
Zu75CrMo	AS75	0.70-0.80	0.20-0.45	0.60-0.90		0.75-1.00	0.20-0.45
Zu75CrNiMnMo	AS75 I	0.70-0.80	0.20-0.70	0.70-1.10	≥0.20	0.80-1.50	0.20-0.60

物理性能 Physical property

轧辊名称 Roll name	材质代码 Material code	辊身硬度 HSD Hardness of roll body	辊颈硬度 HSD Hardness of roll neck	抗拉强度 Mpa Tensile strength
Zu60CrMoMn	AS60	35-50	≤45	>650
Zu 60CrMoMnNi	AS60 I	35-45	≤45	>750
Zu 65CrNiMo	AS65 I	35-45	≤45	>750
Zu 70Mn	AS70	32-42	≤45	>650
Zu 70Mn2	AS70 I	35-45	≤45	>680
Zu 70Mn2Mo	AS70 II	35-45	≤45	>700
Zu 75CrMo	AS75	35-50	≤45	>700
Zu 75CrNiMnMo	AS75 I	35-50	≤45	>800

金相组织 Metallurgical structure

辊身工作层金相组织为：珠光体 或 回火索氏体

The matrix structure of the working layer on roll body is: Pearlite or Tempered sorbite

应用范围 Range of application

轧辊名称 Roll name	材质代码 Material code	应用范围 Range of application
Zu60CrMoMn	AS60	棒材、线材、带钢、板带、型钢粗轧 Rods and bars, Wire material, Strip steel, plate strip, Profile steel rough rolling
Zu 60CrMoMnNi	AS60 I	棒材、线材、带钢、板带、型钢粗轧 Rods and bars, Wire material, Strip steel, plate strip, Profile steel rough rolling
Zu 65CrNiMo	AS65 I	棒材、线材、带钢、板带、型钢粗轧 Rods and bars, Wire material, Strip steel, plate strip, Profile steel rough rolling
Zu 70Mn	AS70	棒材、线材、带钢、板带、型钢粗轧 Rods and bars, Wire material, Strip steel, plate strip, Profile steel rough rolling
Zu 70Mn2	AS70 I	棒材、线材、带钢、板带、型钢粗轧 Rods and bars, Wire material, Strip steel, plate strip, Profile steel rough rolling
Zu 70Mn2Mo	AS70 II	棒材、线材、带钢、板带、型钢粗轧 Rods and bars, Wire material, Strip steel, plate strip, Profile steel rough rolling
Zu 75CrMo	AS75	棒材、线材、带钢、板带、型钢粗轧，窄带钢支撑辊 Rods and bars, Wire material, Strip steel, plate strip, Profile steel rough rolling, Narrow strip steel support roll
Zu 75CrNiMnMo	AS75 I	棒材、线材、带钢、板带、型钢粗轧，窄带钢支撑辊 Rods and bars, Wire material, Strip steel, plate strip, Profile steel rough rolling, Narrow strip steel support roll

承制规格 Manufacturing specifications

辊身直径≤1500mm Roll diameter≤1500mm
辊身长度≤3000mm Roll length≤3000mm

化学成分 Chemical ingredients

轧辊名称 Roll name	材质代码 Material code	C	Si	Mn	Ni	Cr	Mo
ZuB140CrNiMo	AD140 I	1.30-1.50	0.30-0.60	0.70-1.10	0.50-1.20	0.80-1.20	0.20-0.60
ZuB160CrNiMo	AD160 I	1.50-1.70	0.30-0.60	0.80-1.30	≥0.20	0.80-2.00	0.20-0.60
ZuB180CrNiMo	AD180	1.70-1.90	0.30-0.80	0.60-1.10	0.20-2.00	0.80-1.50	0.20-0.60
ZuB190CrNiMo	AD190	1.80-2.00	0.30-0.80	0.60-1.20	1.00-2.00	1.50-3.50	0.20-0.50
ZuB200CrNiMo	AD200	1.90-2.10	0.30-0.80	0.80-1.20	0.60-2.50	0.60-2.00	0.20-0.80

物理性能 Physical property

轧辊名称 Roll name	材质代码 Material code	辊身硬度 HSD Hardness of roll body	辊颈硬度 HSD Hardness of roll neck	抗拉强度 Mpa Tensile strength
ZuB140CrNiMo	AD140 I	35-50	≤60	500-800
ZuB160CrNiMo	AD160 I	40-60	≤50	500-800
ZuB180CrNiMo	AD180	45-60	≤50	450-700
ZuB190CrNiMo	AD190	50-65	≤50	450-700
ZuB200CrNiMo	AD200	50-65	≤50	450-700

金相组织 Metallurgical structure

辊身工作层金相组织为：珠光体+碳化物 或 细珠光体+少量贝氏体+碳化物

The matrix structure of the working layer on roll body is: Pearlite+ Carbonide or Nodular pearlite+ A small amount of martensite+ Carbonide

应用范围 Range of application

轧辊名称 Roll name	材质代码 Material code	应用范围 Range of application
ZuB140CrNiMo	AD140 I	棒材、线材、型钢、板带粗轧、立辊 Rods and bars, Wire material, Profile steel, Plate strip rough rolling, Vertical roll
ZuB160CrNiMo	AD160 I	棒材、线材、型钢、板带粗中轧、立辊、辊环、支撑辊 Rods and bars, Wire material, Profile steel, Plate strip rough intermediate rolling, Vertical roll, Roll collar, Support roll
ZuB180CrNiMo	AD180	棒材、线材、型钢、板带粗中轧、立辊、辊环、支撑辊 Rods and bars, Wire material, Profile steel, Plate strip rough intermediate rolling, Vertical roll, Roll collar, Support roll
ZuB190CrNiMo	AD190	棒材、线材、型钢、板带粗中轧、立辊、辊环、支撑辊 Rods and bars, Wire material, Profile steel, Plate strip rough intermediate rolling, Vertical roll, Roll collar, Support roll
ZuB200CrNiMo	AD200	棒材、线材、型钢、板带粗中轧、立辊、辊环、支撑辊 Rods and bars, Wire material, Profile steel, Plate strip rough intermediate rolling, Vertical roll, Roll collar, Support roll

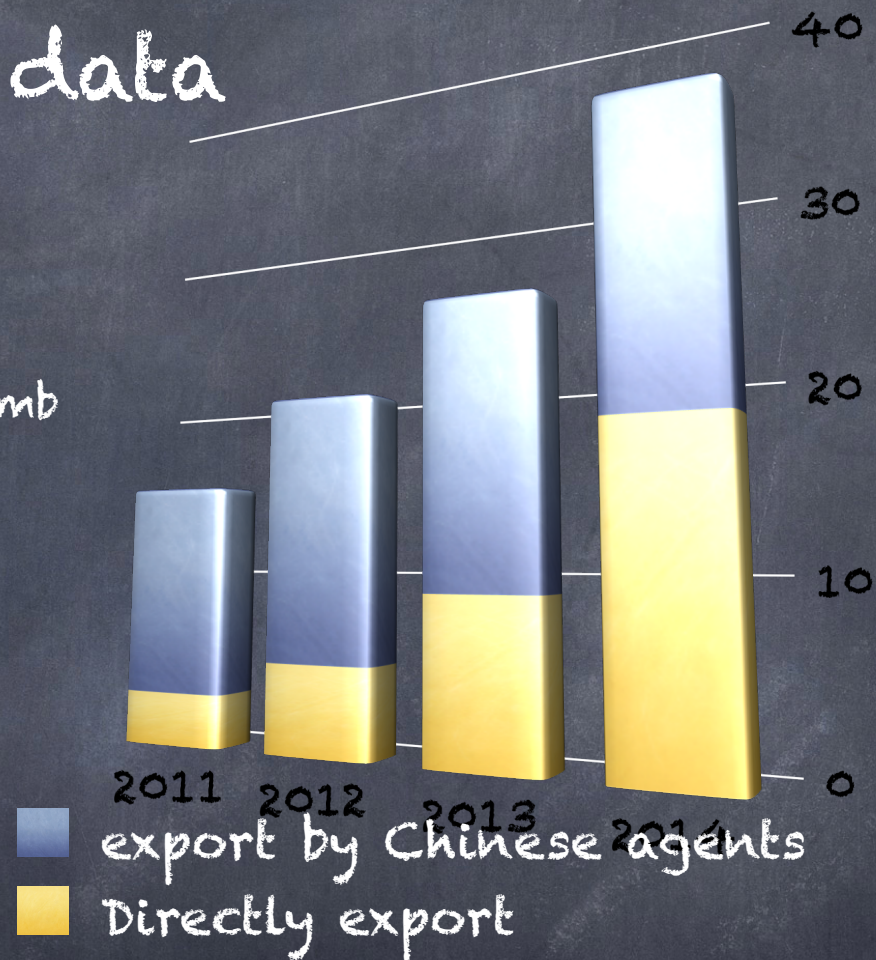
承制规格 Manufacturing specifications

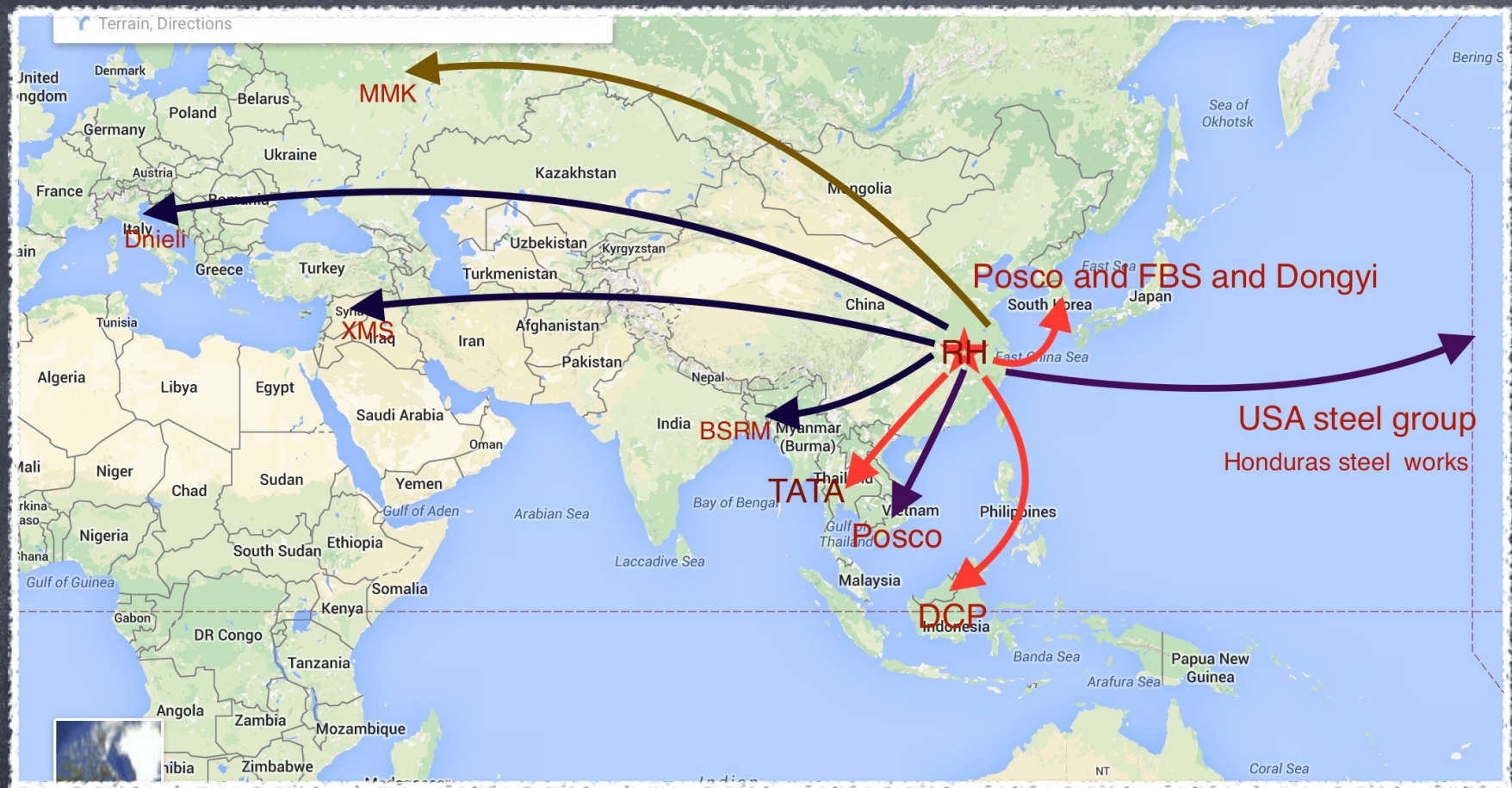
辊身直径≤1800mm Roll diameter≤1800mm
辊身长度≤3000mm Roll length≤3000mm

international business

Exporting data

million rmb





Directly export

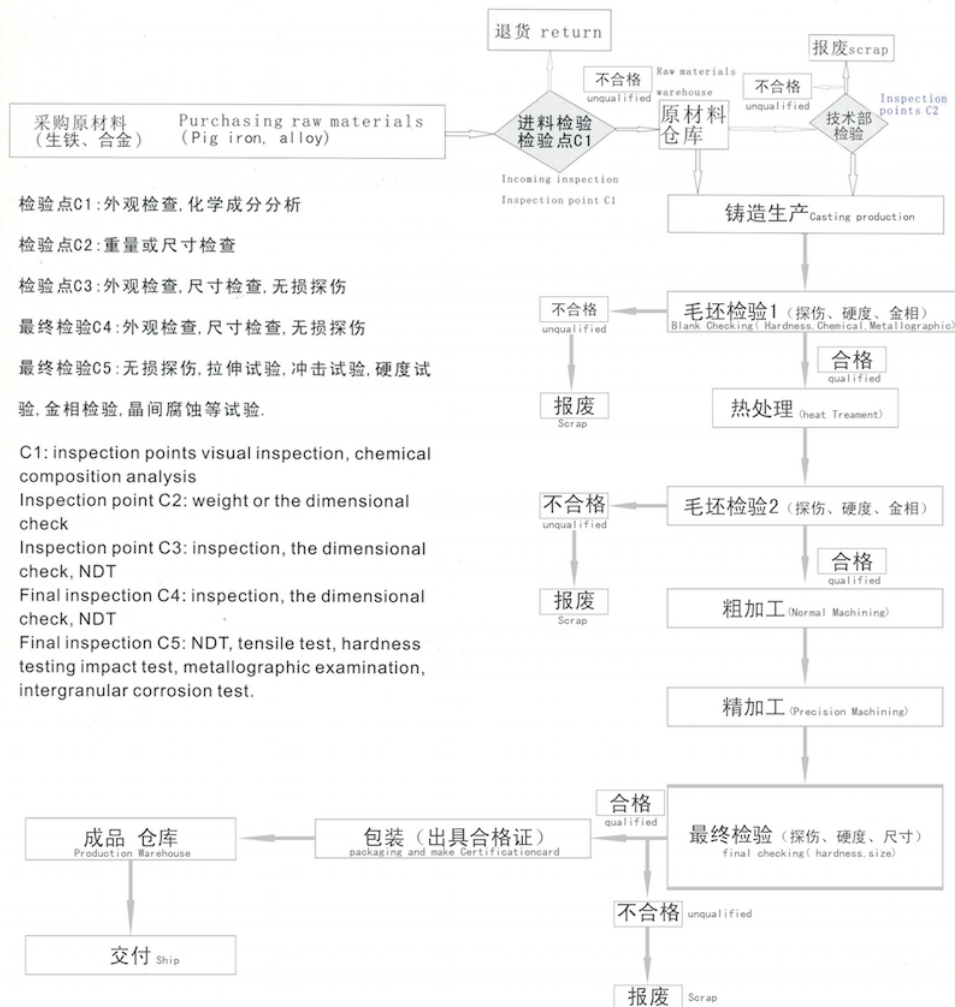
international business

Country	Steel works	Steel style	Tips
Korea	Posco FBS and 3 other steel works	Rebar angle bar	provide 1000 tones rolls per year
Vietnam	Posco-ss	wire rod section bar	1500 tones per year
Bangladesh	BSRM	wire rod section bar	biggest steel works in Bangladesh
Thailand	TATA	wire rod	the main market, make good service and quality
USA roll group	Roll group	section	biggest rolls group
China	bao steel	wire rod	biggest steel works in China

Quality control

生产工序流程图

Production process flow diagram



Device

Spectrum

Germany
Bruker

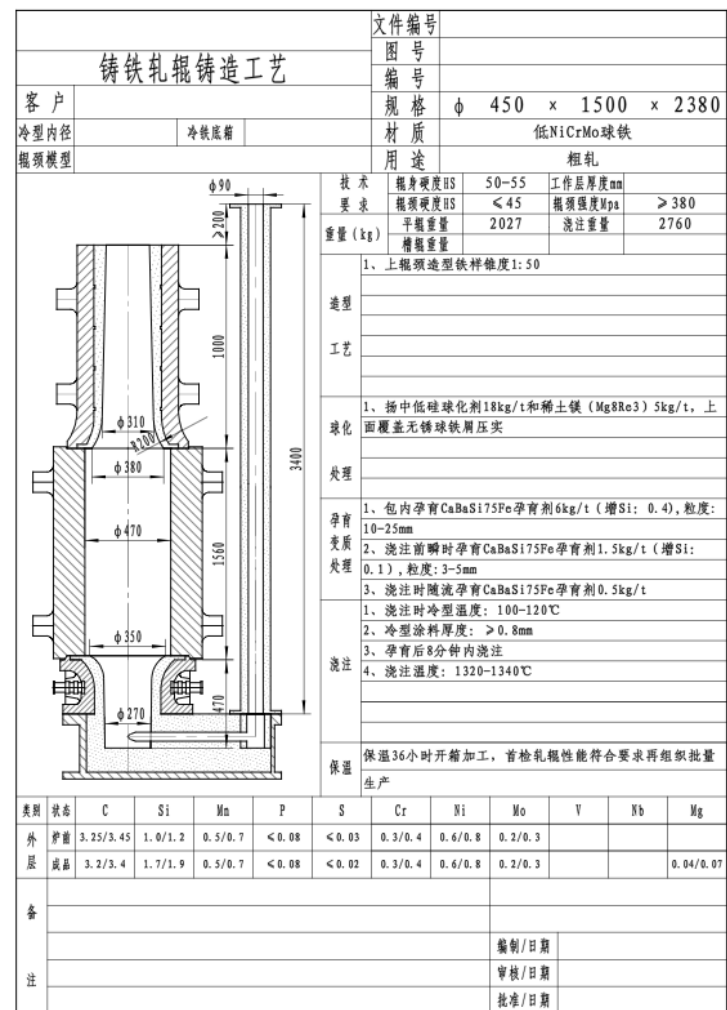
Chemical
composition

Metallography instrument

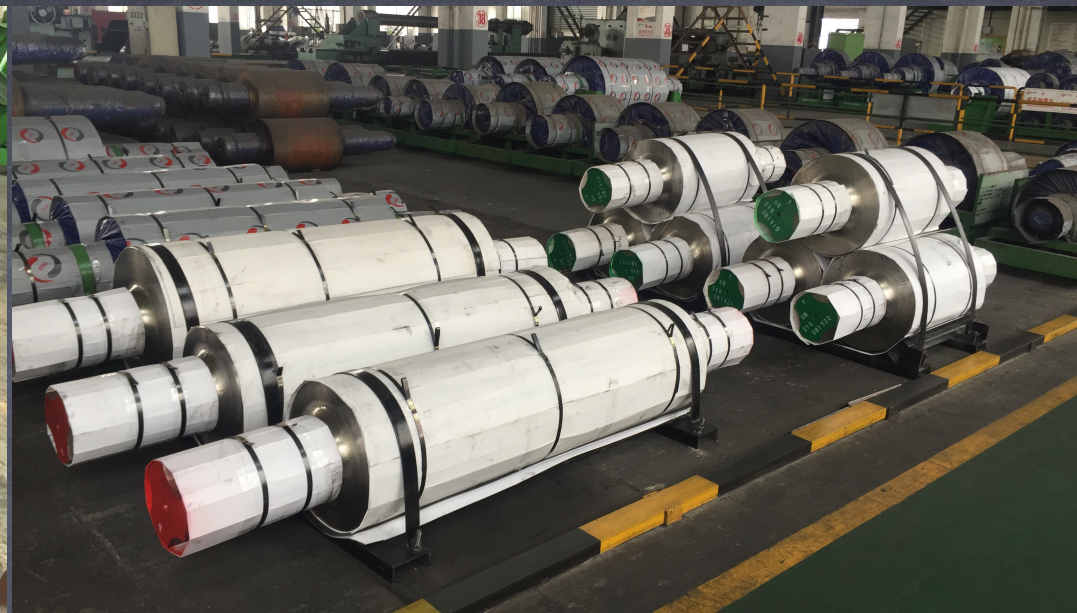
Ultrasonic flaw detector

Hardness testing

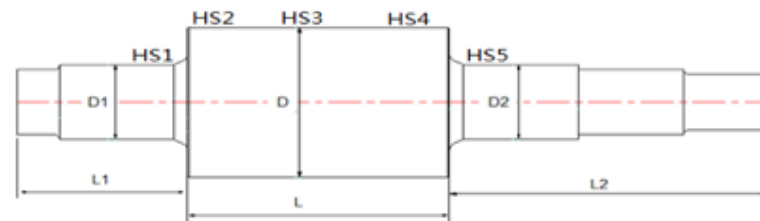
				文件编号									
离心轧辊铸造工艺				图号		SI-KJS-03-01							
客户				编号									
端盖型号				造型芯子		规格		$\phi 310 \times 780 \times 1430$					
辊模代号				冷型: $\phi 332 \times 830$		材质		贝氏体球铁 (CCSGA)					
						用途		棒材精轧机架					
				技术要求		辊身硬度HS		70-75		工作层厚度mm		≥ 35	
						辊颈硬度HS		35-45		辊颈强度Mpa		≥ 350	
				重量 (kg)		轧辊净重		535		中间层铁水			
						外层铁水		325		芯部铁水		485	
				涂料		1. 覆膜砂涂料单边厚度3mm, 重量: 4.0kg							
						2. 涂时冷型温度: 170-190, 电机转速500转/分							
				外层铁水处理		1. 球化:							
						2. 孕育: 包内加入CaBaSi孕育剂4.5kg/吨 (增SI: 0.3%)							
				中间层铁水处理									
				芯部铁水处理		1. 球化: 包底加入稀土镁 (Mg8Re3) 18kg/吨, 上面无铸球铁剂							
		2. 孕育: 包内加入CaBaSi孕育剂4.5kg/吨, 浇注时随流孕育1.5kg/t											
离心工艺		1. 外层出铁温度: 1470-1490℃, 浇注温度: 1340-1350℃											
		2. 外层浇注时间: <30秒											
		3. 辊模转速: 800-820转/分, 电机转速:											
		4. 玻璃渣重量: 2.3kg											
		5. 停机温度: 1030-1050℃ (按下限控制)											
		6. 合箱时间: <3分钟											
		7. 填芯铁水温度: 1365-1375℃ (起包测温1375-1385℃)											
		8. 填芯时间: <50秒 (水口直径 $\phi 40$)											
保温		保温时间: 36小时											
类别	状态	C	Si	Mn	P	S	Cr	Ni	Mo	V	Nb	Mg	
外层	炉前	3.25/3.45	0.9/1.0	0.4/0.6	<0.08	<0.02	0.4/0.5	3.3/3.5	0.5/0.7				
	成品	3.2/3.4	1.3/1.5	0.4/0.6	<0.08	<0.01	0.4/0.5	3.3/3.5	0.5/0.7			0.04/0.07	
中间层	炉前												
	成品												
芯部	炉前	3.25/3.45	0.9/1.1	0.5/0.6	<0.08	<0.03	<0.02	0.3/0.4					
	成品	3.2/3.4	2.0/2.2	0.5/0.6	<0.08	<0.03	<0.02	0.3/0.4				0.04/0.07	
备注	1. 铁水包温度: 600-700									编制/日期			
	2. CaBaSi孕育剂颗粒5-10mm									审核/日期			
	3. 玻璃渣: 75% O型渣+25%KN渣									批准/日期			







客户/CUSTOMER :		订单号/ORDER NO. :	LST001
规格/SPECIFICATION :	420 X 800	图纸号/DRAWING NO. :	2001-01/1
材质/MATERIAL :	SGP	硬度/HARDNESS :	63-68
数量/QTY :	8	单重/WEIGHT :	1057



辊号/ ROLL NO.:	尺寸/DIMENSIONS (mm)					
	D(420)	D1(220)	D2(220)	L(800)	L1(450)	L2(450)
	+3	+0.015/+0.04	+0.015/+0.04		-1/+2	-1/+2
LR-TSSY-TJ-01	420	220.03	220.02	800	450	450
LR-TSSY-TJ-02	420	220.02	220.02	800	450	450
LR-TSSY-TJ-03	420	220.02	220.03	800	450	450
LR-TSSY-TJ-04	420	220.03	220.02	800	450	450

Measures of other places are also satisfied with the dimension of the dwg.

辊号/ ROLL NO.:	合金成分/CHEMICAL COMPOSITION(%)								
	C	Si	Mn	P	S	Ni	Cr	Mo	Mg
	3.0/ 3.5	1.2/1. 8	0.2/0.8			2.0/2.5	0.3/1.0	0.2/0. 8	
LR-TSSY-TJ-01	3.2 1	1.41	0.58	0.02	0.01	2.21	0.67	0.31	0.03
LR-TSSY-TJ-02	3.3 6	1.43	0.54	0.05	0.01	2.31	0.72	0.32	0.02
LR-TSSY-TJ-03	3.3 1	1.41	0.58	0.02	0.01	2.41	0.67	0.31	0.03
LR-TSSY-TJ-04	3.3 1	1.43	0.54	0.05	0.01	2.31	0.72	0.32	0.02

辊号/ ROLL NO.:	抗拉强度	超声波UT	硬度HARDNESS (HSC)				
			HS-1	HS-2	HS-3	HS-4	HS-5
	RM(N/ mm2)	Qualified		65-70	65-70	65-70	
LR-TSSY-TJ-01	476	良好	38	65	67	66	37
LR-TSSY-TJ-02	473	良好	36	67	68	67	38
LR-TSSY-TJ-03	474	良好	36	68	67	68	38
LR-TSSY-TJ-04	475	良好	36	67	68	67	38

检验员/吕文娟
INSPECTED BY:
签字

复核/蒋新征
APPROVED BY:
签字

日期/2015.06.19
DATE

Customer Service

- the product promise quality good to send out.
- Make sure customer will have a nice feedback.
Our engineer will go to Thailand twice every year to interview our customer to check their using. then improve more to them
- If the rolls have any problem in using, we will compensate new rolls to you.

Thank you very
much