

Forged Steel Rolls For Hot Mills

The forged steel rolls for hot mills are manufactured with well chosen quality forged steel blanks, special heat treatment is applied to make rolls in satisfactory barrel hardness and hardening depth. While good wear-ability is obtained, a comprehensive property of high toughness and excellent biting ability is also achieved. This type of rolls is used in the plate (strip) mills, among the various rolls, the tube rolls is with a high quality and is rich in assortment, complete in specification and wide application. The technical properties of FSH-10 butt welded tube mill rolls have satisfactorily met the customer's requirement. The quality of hyperbolic straightening rolls are in leading position at domestic market, recently the rolls and sleeves for non-ferrous casting mill have also been developed successfully.

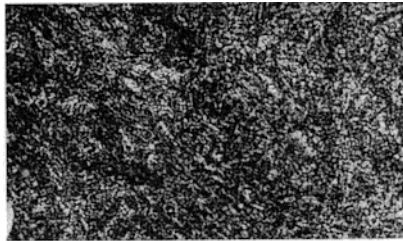
化学成分 Chemical composition(%)

代号 symbol	C	Si	Mn	Cr	Ni	Mo	V	W
FSH-1	0.55-0.65	0.17-0.40	0.50-1.00	0.50-1.20	≤ 0.25	0.20-0.40	-	-
FSH-2	0.55-0.65	0.20-0.40	0.60-1.00	0.70-1.00	1.50-2.00	0.10-0.30	-	-
FSH-3	0.45-0.65	0.20-0.50	0.50-0.90	3.00-3.60	-	0.40-1.20	0.10-0.35	-
FSH-4	0.60-0.80	0.30-0.80	0.40-0.90	2.50-3.50	0.40-0.60	0.20-0.60	-	-
FSH-5	0.30-0.40	≤ 0.40	≤ 0.40	2.20-2.70	-	-	0.20-0.50	7.50-9.00
FSH-6	0.32-0.43	0.80-1.20	0.20-0.50	4.50-5.50	-	1.00-1.60	0.30-0.60	-
FSH-7	0.80-0.95	0.25-0.45	0.20-0.55	1.70-2.40	-	0.20-0.40	≤ 0.15	-
FSH-8	0.13-0.23	≤ 0.30	≤ 1.00	0.80-1.20	-	0.80-1.20	0.15-0.30	-
FSH-9	0.30-0.42	0.17-0.50	0.25-0.50	1.20-1.60	3.00-3.50	0.25-0.45	0.10-0.25	-
FSH-10	1.45-1.70	≤ 0.40	≤ 0.40	11.0-12.5	-	0.40-0.60	0.15-0.30	-

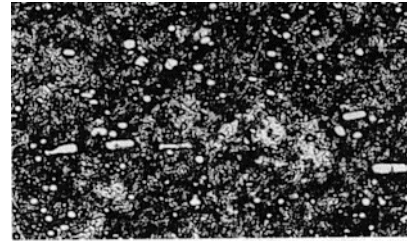
辊身硬度 Barrel hardness (HS):

FSH-1	FSH-2	FSH-3	FSH-4	FSH-5	FSH-6	FSH-7	FSH-8	FSH-9	FSH-10
34-40	35-45	50-60	34-45	65-76	50-58	69-76	38-45	40-50	80-87
55-75	50-60	60-70	60-75	80-87	65-71	80-87			

金相组织 Microstructure: 珠光体 + 碳化物 pearlite + carbide



FSH-1 基体 Matrix 500



FSH-10 基体 Matrix 500X

锻钢热轧辊应用一览表 Application of forged steel rolls for hot mills:

轧机类别 Mill type	轧辊类别 Roll type	FSH										
		1	2	3	4	5	6	7	8	9	10	
板材轧机 Plate mills	初轧辊 Primary rolls	●	●									
	工作辊 Work rolls					●						
行星轧机 Planetary mills	送料辊 Feed rolls	●										
	支承辊 Back-up rolls	●										
焊管轧机 Welding tube mills	成型、定径及立辊 Forming, sizing and vertical rolls							●				
无缝钢管轧机 Seamless tube mills	挤压辊 Extruding rolls					●	●					●
	矫直辊 Straitening rolls							●				●
有色金属板带热轧机 Non-ferrous plate and strip mills	穿孔辊 Piercing rolls				●							
	轧尖辊 Pushing point rolls							●				
	工作辊 Work rolls		●	●								
	支承辊 Back-up rolls			●	●							
有色金属铸轧机轧辊(辊套) Non-ferrous casting-mills rolls(sleeves)										●	●	

承制范围 The capacity of making:

辊身直径(mm) Diameter of barrel	辊身长度(mm) length of barre	单重(t) Weight
Φ 1200(max.)	3500(max.)	12(max.)