

CARBON HOLLOW BAR

750 (32 to 250 mm OD)

2C (254 to 610 mm OD)

Typical Analysis (Ave. values %)	C	Mn	Si	V	S	P
	0.22	1.60	0.35	0.12	0.03	0.03
NEAREST STANDARD	DIN		UNS		ASTM	
	1.5217 20MnV6		K03013		A381	

DESCRIPTION	ASSAB 750 & ASSAB 2C Carbon Hollow Bar are high yield strength aluminium treated fine grained, low alloy calcium treated steels, with improved machinability and welding characteristics.
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APPLICATIONS	Universally used due to reduced machining requirements. All forms of mechanical equipment, such as hydraulic cylinders, gear wheels, shafts, axles, stuffing boxes, lock nuts , spindles, drill jigs, rolls etc.
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MECHANICAL PROPERTIES (as supplied)	Tensile strength	650-800 MPa		
		Wall thickness	MPa	
	Yield Strength	=16 mm	480	
		>16-30 mm	460	
		>30 mm	440	
	Elong	18%		
Hardness	200-240 HB			

TOLERANCES	Outside Diameter	<75 mm +1.00 mm -0 75-100 + 1.20 mm -0 >100 mm + 1.40 mm -0
	Wall	Minimum thickness not more than 5% below nominal thickness
	Straightness	1 in 1000 measured in total length.

PHYSICAL PROPERTIES	Density (kg/dm ³)	7.85
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HEAT TREATMENT	Normalize	880-900°C. Air cool.
	Anneal	650-700°C. Cool slowly in controlled furnace.
	Carburize	900-950°C. Furnace or Air cool
	Core Refine	840°C. Water quench.
	Harden	800°C Water quench.
	Temper	180-210°C air cool

WELDING	Parts should be welded before Carburizing and Hardening. Preheat to 250-350°C. Filler metals:-Bohler FOX EV63 electrodes.
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SIZE RANGE	ASSAB 750	32 mm OD x 16 mm ID to 250 mm OD x 150 mm ID
	ASSAB 2C	254 mm OD x 154 mm ID to 610 mm OD x 490 mm ID

<u>LOCATIONS</u>					
Bohler Uddeholm Australia Pty Ltd ABN 15000013052					
Sydney	129-135 McCredie Rd Guildford	2161	Ph (02) 8724 5554	Fax (02) 8724 5555	
Newcastle	3 Pavilion Pl Cardiff	2285	Ph (02) 4954 6611	Fax (02) 4956 5773	
Albury	1 Eames St Albury	2640	Ph (02) 6041 3399	Fax (02) 6041 1820	
Wollongong	40 Doyle Ave Unanderra	2526	Ph (02) 4272 6544	Fax (02) 4272 7563	
Marayong	1/21 Binney Rd Marayong	2148	Ph (02) 9831 4431	Fax (02) 9671 1682	
Melbourne	282-290 Greens Rd Dandenong	3175	Ph (03) 9767 5554	Fax (03) 9767 5555	
Bayswater	4 Amsted Rd Bayswater	3153	Ph (03) 9739 8022	Fax (03) 9739 8033	
Adelaide	1 Williams Cir Pooraka	5095	Ph (08) 8368 4554	Fax (08) 8368 4555	
Brisbane	12-18 Limestone St Darra	4076	Ph (07) 3712 9554	Fax (07) 3712 9555	
Townsville	9-11 Caldwell St Garbutt	4814	Ph (07) 4479 4800	Fax (07) 4725 1316	
Perth	29-33 Gauge Cir Canningvale	6155	Ph (08) 9455 8672	Fax (08) 9455 8673	
Kewdale	5 Beete St Welshpool	6106	Ph (08) 9350 9582	Fax (08) 9350 9683	
Launceston	20 Murphy St Invermay	7248	Ph (03) 6334 3542	Fax (03) 6331 4001	
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