

This information is based on our present state of knowledge and is intended to provide general notes on our products and their uses. It should not therefore be construed as a warranty of specific properties of the products described or a warranty for fitness for a particular purpose.

Classified according to EU Directive 1999/45/EC
For further information see our "Material Safety Data Sheets".
Edition 3, 11.2006



SS-EN ISO 9001
SS-EN ISO 14001

General

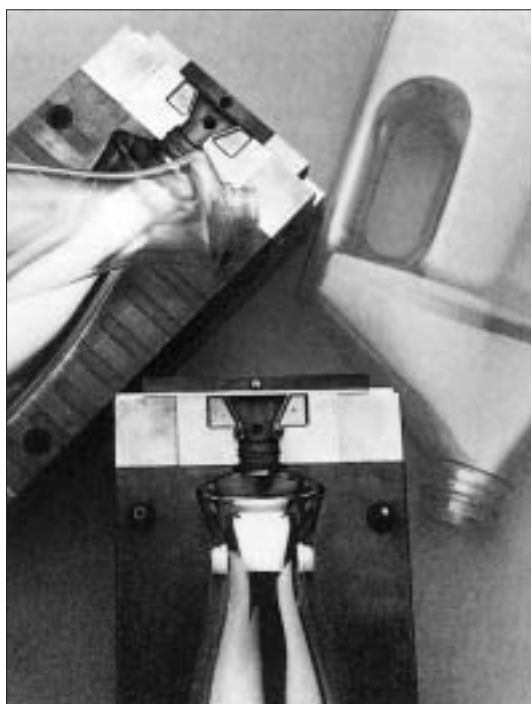
Moldmax HH is a high-strength beryllium copper mould alloy made by Brush Wellman Inc. for plastics moulding applications. Its main properties include:

- high thermal conductivity
- good corrosion resistance
- good polishability
- good wear resistance
- good resistance to galling
- good machinability
- high strength and hardness
- excellent weldability

Typical analysis %	Be 1,9	Co + Ni 0,25	Cu Bal.
Delivery condition	High hard = 40 HRC (Low hard = 30 HRC)		
Colour code	HH Black/Gold LH Red/Gold		

Moldmax HH is widely used for injection moulding tools or as cores and inserts in steel moulds. When used in steel mould it effectively cools hot spots, reducing or eliminating the need for cooling channels.

Moldmax HH is available in wrought round and flat section, machined core pins, and welding wire.



Two halves of a Moldmax HH beryllium copper blow mould.

Moldmax HH's high thermal conductivity, 3 to 5 times better than steel, ensures uniform, rapid heat removal, minimizing part distortion, warpage, poor replication of detail and similar defects. In many cases it can significantly reduce cycle times, even when used in a steel mould just for selected cores and inserts.

For mould applications which require even higher thermal conductivity than that of Moldmax HH, Protherm beryllium copper mould alloy is available, see separate technical brochure.

Applications

The special properties of Moldmax HH beryllium copper alloy make it a suitable mould/core/insert material for a wide variety of moulding situations but especially where a combination of high thermal conductivity, corrosion resistance and good polishability are needed.

- Blow moulds: pinch offs, neck rings and handle inserts
- Injection mould: moulds, cores, inserts
- Injection nozzles and manifolds for hot runner systems

Properties

Physical data

Data at room and elevated temperatures.

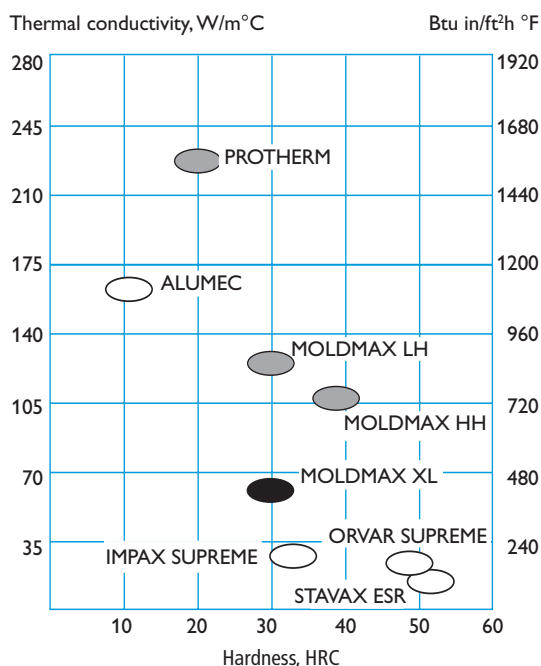
Temperature	20°C (68°F)	200°C (390°F)	300°C (570°F)
Density, kg/m ³ lb/in ³	8 350 0,302	8 275 0,299	8 220 0,297
Modulus of elasticity N/mm ² psi	131 100 19 x 10 ⁶	124 100 19 x 10 ⁶	103 400 15 x 10 ⁶
Coefficient of thermal expansion from °C to 20°C from °F to 68°F	– –	17 x 10 ⁻⁶ 9,7 x 10 ⁻⁶	17,8 x 10 ⁻⁶ 9,9 x 10 ⁻⁶
Thermal conductivity W/m°C			
HH 40 HRC	110	145	155
LH 30 HRC	120	160	170
Btu in/ft ² h °F			
HH 40 HRC	754	994	1063
LH 30 HRC	823	1097	1166
Specific heat, J/kg°C Btu/lb °F	380 0,091	480 0,114	535 0,128

Tensile strength at room temperature

The tensile values are to be considered as approximate only.

Hardness	HH 40 HRC	LH 30 HRC
Tensile strength, R_m N/mm ² psi	1 280 185 000	1 170 170 000
Compressive yield strength, $R_{c0,2}$ N/mm ² psi	1 070 155 000	970 140 000
Elongation, A_5 %	6	8

RELATION BETWEEN STRENGTH AND HEAT CONDUCTIVITY FOR DIFFERENT MOULD MATERIAL



Note: Increasing alloying content gives a higher strength, but a lower thermal conductivity. However, this is only valid when comparing material within one material group i.e. steel must be compared with steel and copper with copper alloys.

Heat treatment

Moldmax HH is delivered in the heat treated condition—additional heat treatment is not normally required.

Machining

Moldmax HH has a good machinability and can be machined with conventional cutting tools. Perform machining wet to avoid breathing metal dust.

The cutting data, in following tables, are to be considered as guiding values which must be adapted to existing local conditions.

Turning

Cutting data parameters	Turning with carbide		Turning with high speed steel
	Rough turning	Fine turning	
Cutting speed, v_c m/min f.p.m.	270–300 890–990	300–370 990–1220	60–90 200–300
Feed, f mm/rev i.p.r.	0,3–0,6 0,012–0,023	–0,3 –0,012	–0,3 –0,012
Depth of cut, a_p mm inch	2–6 0,08–0,23	–2 –0,08	–2 –0,08
Carbide designation ISO	K20	K20	–

Use tools with generous positive rake angles

Milling

FACE AND SQUARE SHOULDER FACE MILLING

Cutting data parameters	Milling with carbide		Milling with high speed steel
	Rough milling	Fine milling	
Cutting speed, v_c m/min f.p.m.	100–150 330–490	150–200 490–660	45–60 150–200
Feed, f_z mm/tooth in/tooth	0,2–0,4 0,008–0,016	0,1–0,2 0,004–0,008	–0,1 –0,004
Depth of cut, a_p mm inch	2–5 0,08–0,20	–2 –0,08	–2 –0,08
Carbide designation ISO	K20	K20	–

Use tools with positive rake angles when milling with carbide

END MILLING

Cutting data parameters	Type of milling		
	Solid carbide	Carbide indexable insert	High speed steel
Cutting speed, v_c m/min f.p.m.	80–100 260–330	150–200 490–660	45–60 ¹⁾ 150–200
Feed, f_z mm/tooth in/tooth	0,010–0,10 ²⁾ 0,0004–0,004	0,08–0,20 ²⁾ 0,003–0,008	0,05–0,35 ²⁾ 0,002–0,014
Carbide designation ISO	–	K20	–

¹⁾ For coated HSS end mill an increased cutting speed of ~30% can be used

²⁾ Depending on radial depth of cut and cutter diameter

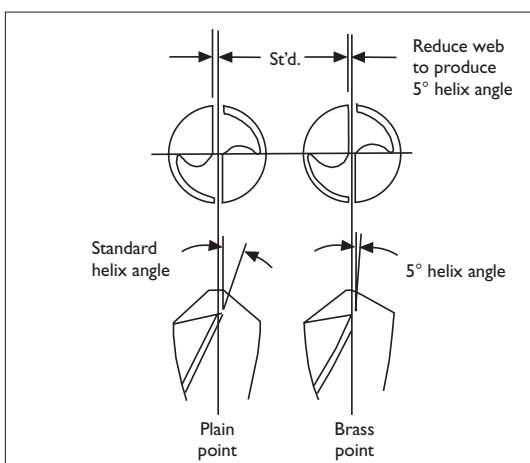
Drilling

HIGH SPEED STEEL TWIST DRILL

Drill diameter		Cutting speed v_c		Feed	
mm	inch	m/min	f.p.m.	mm/r	i.p.r
–5	–3/16	30–40	100–130	0,03–0,08	0,001–0,003
5–10	3/16–3/8	30–40	100–130	0,08–0,15	0,003–0,006
10–15	3/8–5/8	30–40	100–130	0,15–0,20	0,006–0,008
15–20	5/8–3/4	30–40	100–130	0,20–0,25	0,008–0,010

When drilling holes deeper than 1 x drill diameter use “Peckdrilling” and retract the drill after each 5 mm drilled depth.

Standard HSS drills can be used but for best performance the tip should be altered to a “brass point” according to the figure below.



Threading with tap

When tapping Moldmax HH use taps with straight flutes. Use same kind of taps when tapping blind holes. Suitable cutting speed 6–8 m/min. Use cutting compound or cutting oil.

Grinding

Conventional grinding wheels can be used when grinding Moldmax HH. Surface grinding, use A 54 LV-type of wheels. Cylindrical grinding, use A 60 LV-type of wheels.

All grinding should be done wet to avoid breathing metal dust.

Surface treatments

To enhance the surface properties of Moldmax HH, standard treatments can be applied.

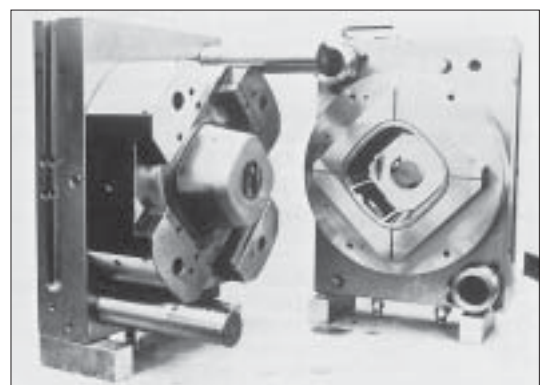
Treatment	Benefits
Hard chrome	Wear resistance, corrosion resistance, hardness.
Electroless (chemical) Nickel	Hardness, wear resistance, surface release, corrosion resistance.
Electroless Nickel with Teflon	Hardness, wear resistance, surface release
PVD: Titanium Nitride Chromium Nitride	Superior wear resistance, surface release.

Note: Treatment temperature should not exceed 320°C (610°F).

EDM

While Moldmax HH’s high thermal conductivity makes it slower to EDM than mould steel, EDM’ing presents no significant problem.

Proper ventilation with an effective exhaust system is essential to prevent fumes in the air.



Welding

Moldmax HH can easily be welded if good care is taken and good welding practices are followed. The area to be welded should be thoroughly cleaned with a degreasing solvent. The always present oxidized layer should be removed using aggressive brushing, sand blasting or acid pickling immediately prior to the welding.

For best results TIG (GTAW) or MIG (GMAW) is recommended. Suitable welding consumables are available for welding Moldmax HH.

The weld and the surrounding area will show a lower hardness. If the strength of the weld is crucial, the whole part needs to be re-heat treated including solution annealing, quenching and age-hardening. After such a treatment the weld will have the same strength as the base material.

For more information, contact your local Uddeholm office.

Welding operations should be carried out using properly designed local exhaust ventilation to draw all fumes away from the operator and through an appropriate filter before venting outside of the work area.

Polishing

Moldmax HH has very good polishability and highly glossy surfaces are readily achievable. The following steps can serve as guidelines:

1. After grinding, pre-polish using successively finer grit stones ending with a 600 grit.
2. Polish with diamond paste grade 15 to obtain a dull satin looking surface.
3. Polish with a grade 6 diamond paste.
4. Polish with a grade 3 diamond paste.
5. If necessary, hand finish with a #1 grade diamond paste.

As in all polishing, work thoroughness and cleanliness are of utmost importance. In order to avoid overpolishing, or “orange peel” effect, do not polish longer than necessary to achieve an even looking surface.

Safe handling

Moldmax HH is a copper-alloy with a content of ~2% Beryllium.

Make sure, during the machining of Moldmax HH, to avoid breathing metal dust fume or mist. Perform machining, grinding and polishing wet when possible. If dry operation is needed use ventilation to capture the dust.

Further information can be found in our “Material Safety Data Sheets”.

Further information

Contact your local Uddeholm office for additional information on selection, heat treatment, application and availability of Uddeholm tooling materials.

Europe

Austria

Representative office
UDDEHOLM
Albstraße 10
DE-73765 Neuhausen
Telephone: +49 7158 9865-0
www.uddeholm.de

Belgium

UDDEHOLM
Europark Oost 7
B-9100 Sint-Niklaas
Telephone: +32 3 780 56 20
www.uddeholm.be

Croatia

BÖHLER UDDEHOLM Zagreb
d.o.o za trgovinu
Zitnjak b.b
10000 Zagreb
Telephone: +385 1 2459 301
Telefax: +385 1 2406 790
www.bohler-uddeholm.hr

Czech Republic

BÖHLER UDDEHOLM CZ s.r.o.
Division Uddeholm
U Silnice 949
161 00 Praha 6, Ruzyně
Telephone: +420 233 029 850,8
www.uddeholm.cz

Denmark

UDDEHOLM A/S
Kokmose 8, Bramdrupdam
DK-6000 Kolding
Telephone: +45 75 51 70 66
www.uddeholm.dk

Estonia

UDDEHOLM TOOLING AB
Silikatsiidi 7
EE-11216 Tallinn
Telephone: +372 655 9180
www.uddeholm.ee

Finland

OY UDDEHOLM AB
Ritakuja 1, PL 57
FI-01741 VANTAA
Telephone: +358 9 290 490
www.uddeholm.fi

France

Head office
UDDEHOLM
Z.I. de Mitry-Compans, 12 rue Mercier,
FR-77297 Mitry Mory Cedex
Telephone: +33 (0)1 60 93 80 10
www.uddeholm.fr

Branch offices

UDDEHOLM S.A.
77bis, rue de Vesoul
La Nef aux Métiers
FR-25000 Besançon
Telephone: +33 (0)381 53 12 19

LE POINT ACIERS
UDDEHOLM - Aciers à outils
Z.I. du Recou, Avenue de Champlevert
FR-69520 GRIGNY
Telephone: +33 (0)4 72 49 95 61

LE POINT ACIERS
UDDEHOLM - Aciers à outils
Z.I. Nord 27, rue François Rochema
FR-01100 OYONNAX
Telephone: +33 (0)4 74 73 48 66

Germany

Head office
UDDEHOLM
Hansaallee 321
DE-40549 Düsseldorf
Telephone: +49 211 5351-0
www.uddeholm.de

Branch offices

UDDEHOLM
Falkenstrasse 21
DE-65812 Bad Soden/TS
Telephone: +49 6196 6596-0

UDDEHOLM
Albstraße 10
DE-73765 Neuhausen
Telephone: +49 7158 9865-0

UDDEHOLM
Friederikenstraße 14b
DE-06493 Harzgerode
Telephone: +49 39484 727 267

Great Britain

UDDEHOLM DIVISION
BOHLER-UDDEHOLM (UK) LIMITED
European Business Park
Taylors Lane, Oldbury
GB-West Midlands B69 2BN
Telephone: +44 121 552 5511
Telefax: +44 121 544 2911
www.uddeholm.co.uk

Greece

STASSINOPOULOS-UDDEHOLM
STEEL TRADING S.A.
20, Athinon Street
GR-Piraeus 18540
Telephone: +30 210 4172 109
www.uddeholm.gr

SKLERO S.A.
Heat Treatment and Trading of Steel
Uddeholm Tool Steels
Industrial Area of Thessaloniki
P.O. Box 1123
GR-57022 Sindos, Thessaloniki
Telephone: +30 2310 79 76 46
www.sklero.gr

Hungary

UDDEHOLM TOOLING/BOK
Dunaharaszti, Jedlik Ányos út 25
HU-2331 Dunaharaszti 1. Pf. 110
Telephone/fax: +36 24 492 690
www.uddeholm.hu

Ireland

Head office:
UDDEHOLM DIVISION
BOHLER-UDDEHOLM (UK) LIMITED
European Business Park
Taylors Lane, Oldbury
UK-West Midlands B69 2BN
Telephone: +44 121 552 5511
Telefax: +44 121 544 2911
www.uddeholm.co.uk
Dublin:
Telephone: +353 1845 1401

Italy

UDDEHOLM
Divisione della Bohler Uddeholm
Italia S.p.A.
Via Palizzi, 90
IT-20157 Milano
Telephone: +39 02 39 49 211
www.uddeholm.it

Latvia

UDDEHOLM TOOLING LATVIA SIA
Piedrujas Street 7
LV-1035 Riga
Telephone: +371 7 702133
Telefax: +371 7 185079

Lithuania

UDDEHOLM TOOLING AB
BE PLIENAS IR METALAI
T. Masiulio 18B
LT-52459 Kaunas
Telephone: +370 37 370613, -669
www.besteel.lt

The Netherlands

UDDEHOLM
Isolatorweg 30
NL-1014 AS Amsterdam
Telephone: +31 20 581 71 11
www.uddeholm.nl

Norway

UDDEHOLM A/S
Jernkroken 18
Postboks 85, Kalbakken
NO-0902 Oslo
Telephone: +47 22 91 80 00
www.uddeholm.no

Poland

INTER STAL CENTRUM
Sp. z o.o./Co. Ltd.
ul. Kolejowa 291, Dziekanów Polski,
PL-05-092 Lomianki
Telephone: +48 22 429 2260, -203, -204
www.uddeholm.pl

Portugal

F RAMADA Aços e Industrias S.A.
P.O. Box 10
PT-3881 Ovar Codex
Telephone: +351 256 580580
www.ramada.pt

Romania

BÖHLER-UDDEHOLM Romania SRL
Atomistilor Str. No 96-102
077125 - com. Magurele, Jud. Ilfov.
Telephone: +40 214 575007
Telefax: +40 214 574212

Russia

UDDEHOLM TOOLING CIS
9A, Lipovaya Alleya, Office 509
RU-197183 Saint Petersburg
Telephone: +7 812 6006194
www.uddeholm.ru

Slovakia

Bohler-Uddeholm Slovakia s.r.o.
divizia UDDEHOLM
Čsl.Armády 5622/5
SK-036 01 Martin
Telephone: +421 (0)434 212 030
www.uddeholm.sk

Slovenia

Representative office
UDDEHOLM
Divisione della Bohler Uddeholm
Italia S.p.A.
Via Palizzi, 90
IT-20157 Milano
Telephone: +39 02 39 49 211
www.uddeholm.it

Spain

Head office
UDDEHOLM
Guifré 690-692
ES-08918 Badalona, Barcelona
Telephone: +34 93 460 1227
www.acerosuddeholm.com

Branch office

UDDEHOLM
Barrio San Martín de Arteaga,132
Pol.Ind. Torrelarragoiti
ES-48170 Zamudio (Bizkaia)
Telephone: +34 94 452 13 03

Sweden

Head office
UDDEHOLM TOOLING SVENSKA AB
Aminogatan 25
SE-431 53 Mölndal
Telephone: +46 31 67 98 50
www.uddeholm.se

Branch offices

UDDEHOLM TOOLING SVENSKA AB
Box 45
SE-334 21 Anderstorp
Telephone: +46 371 160 15

UDDEHOLM TOOLING SVENSKA AB
Box 148
SE-631 03 Eskilstuna
Telephone: +46 16 15 79 00

UDDEHOLM TOOLING SVENSKA AB
Aminogatan 25
SE-431 53 Mölndal
Telephone: +46 31 67 98 70

UDDEHOLM TOOLING SVENSKA AB
Nya Tanneforsvägen 96
SE-582 42 Linköping
Telephone: +46 13 15 19 90

UDDEHOLM TOOLING SVENSKA AB
Derbyvägen 22
SE-212 35 Malmö
Telephone: +46 40 22 32 05

UDDEHOLM TOOLING SVENSKA AB
Honnörsgratan 16A
SE-352 36 Växjö
Telephone: +46 470 457 90

Switzerland

HERTSCH & CIE AG
General Wille Strasse 19
CH-8027 Zürich
Telephone: +41 44 208 16 66
www.hertsch.ch

Turkey

Head office
ASSAB Korkmaz Celik A.S.
Organize Sanayi Bölgesi
2. Cadde No: 26 Y. Dudullu
Umraniye-Istanbul Turkey
Telephone: +90 216 420 1926-121/124
www.assabkorkmaz.com

Ukraine

DC CETAB UKRAINE
Box 2431
49040 Dniepropetrovsk
Telephone: +380 562 32 68 65
www.cetab.com

America

Argentina

ACEROS BOEHLER UDDEHOLM S.A
Mozart 40
1619-Centro Industrial Garin
Garin-Prov.
AR-Buenos Aires
Telephone: +54 332 7444 440
www.uddeholm.com.ar

Brazil

AÇOS BOHLER-UDDEHOLM DO
BRASIL LTDA- DIV. UDDEHOLM
Estrada Yae Massumoto, 353
CEP 09842-160
BR-Sao Bernardo do Campo - SP Brazil
Telephone: +55 11 4393 4560, 4554
www.uddeholm.com.br

Canada

Head Office & Warehouse

UDDEHOLM
2595 Meadowvale Blvd.
Mississauga, ON L5N 7Y3
Telephone: +1 905 812 9440
www.bucanada.com

Branch Warehouses

UDDEHOLM
3521 Rue Ashby
St. Laurent, QC H4R 2K3
Telephone: +1 514 333 8000

UDDEHOLM

730 Eaton Way - Unit #10
New Westminster, BC V3M 6J9
Telephone: +1 604 525 3354

Heat Treating

THERMO-TECH
2645 Meadowvale Blvd.
Mississauga, ON L5N 7Y4
Telephone: +1 905 812 9440

Colombia

AXXECOL S.A.
Carrera 35 No 13-20
Apartado Aereo 80718
CO-Bogota 6
Telephone: +57 1 2010700
www.axxecol.com

ASTECO S.A.

Carrera 54 No 35-12
Apartado Aereo 663
CO-Medellin
Telephone: +57 4 2320122
www.asteco.com

Dominican Republic

RAMCA, C. POR A.
Luis Puigbó Alegre, EPS P-2289
P O Box 02-5261
DO-Santo Domingo
Telephone: +1 809 682 4011
domrep@assab.com

Ecuador

IVAN BOHMAN C.A.
Cagilla Postal 17-01370
Quito
Telephone: +593 2 2248001

IVAN BOHMAN C.A.

Apartado 1317
Km 6 1/2 Via a Daule
Guayaquil
Telephone: +593 42 254111

El Salvador

ACAVIDA DE C.V.
25a. Avenida Sur 463
zona 1
Apartado Postal 439
SV-San Salvador
Telephone: +503 22 711700
www.acavisa.com

Guatemala

IMPORTADORA ESCANDINAVA
Apartado postal 2042
GT-Guatemala City
Telephone: +502 23 659270
guatemala@assab.com

Mexico

Head office

ACEROS BOHLER UDDEHOLM S.A.
de C.V.
Calle Ocho No 2, Letra "C"
Fraccionamiento Industrial Alce Blanco
C.P. 52787 Naucalpan de Juarez
MX-Estado de Mexico
Telephone: +52 55 9172 0242
www.bu-mexico.com

Branch office

BOHLER-UDDEHOLM MONTERREY,
NUEVO LEON
Lerdo de Tejada No.542
Colonia Las Villas
MX-66420 San Nicolas de Los Garza,
N.L.
Telephone: +52 81 83 525239

Peru

C.I.P.E.S.A.
Av. Oscar R. Benavides
(ante Colonial) No. 2066
PE-Lima 1
Telephone: +51 1 336 8673
peru@assab.com

U.S.A.

Head Office

UDDEHOLM
4902 Tollview Drive
Rolling Meadows IL 60008
Telephone: 1-847-577-2220
Sales phone: 1-800-638-2520
www.bucorp.com

Region East Warehouse

UDDEHOLM
220 Cherry Street
Shrewsbury MA 01545

Region Central Warehouse

UDDEHOLM
548 Clayton Ct.
Wood Dale IL 60191

Region West Warehouse

UDDEHOLM
9331 Santa Fe Springs Road
Santa Fe Springs, CA 90670

Venezuela

PRODUCTOS HUMAR C.A.
Multicentro Empresarial del Este,
Edf Libertador, Núcleo A.
Piso 9, Of. A-93, Chacao
VE-Caracas 1060
Telephone: +58 212 2655040
humar@assab.com

Other Countries in America

ASSAB INTERNATIONAL AB
Box 42
SE-171 11 Solna, Sweden
Telephone: +46 8 564 616 70
www.assab.se

Asia & Pacific

Australia

BOHLER UDDEHOLM Australia
129-135 McCredie Road
Guildford NSW 2161
Private Bag 14
AU-Sydney
Telephone: +61 2 9681 3100
www.buau.com.au

Bangladesh

ASSAB INTERNATIONAL AB
P.O. Box 17595
Jebel Ali
AE-Dubai
Telephone: +971 488 12165
www.assab.se

North China

Head office

ASSAB Tooling (Beijing) Co Ltd
No.10A Rong Jing Dong Jie
Beijing Economic Development Area
Beijing 100176, China
Telephone: +86 10 6786 5588
www.assabsteels.com

Branch offices

ASSAB Tooling (Beijing) Ltd
Dalian Branch
8 Huanghai Street, Haerbin Road
Economic & Technical Develop. District
Dalian 116600, China
Telephone: +86 411 8761 8080

ASSAB Qingdao Office

Room 2521, Kexin Mansion
No. 228 Liaoning Road, Shibei District
Qingdao 266012, China
Telephone: +86 532 8382 0930

ASSAB Tianjin Office

No.12 Puwangli Wanda Xincheng
Xinyibai Road, Beichen District
Tianjin 300402, China
Telephone: +86 22 2672 0006

Central China

Head office

ASSAB Tooling Technology
(Shanghai) Co Ltd
No. 4088 Humin Road
Xinzhuang Industrial Zone
Shanghai 201108, China
Telephone: +86 21 5442 2345
www.assabsteels.com

Branch offices

ASSAB Tooling Technology
(Ningbo) Co Ltd
No. 218 Longjiaoshan Road
Vehicle Part Industrial Park
Ningbo Economic & Technical Dev.
Zone
Ningbo 315806, China
Telephone: +86 574 8680 7188

ASSAB Tooling Technology

(Chongqing) Co Ltd
Plant C, Automotive Industrial IPark
Chongqing Economic & Technological
Development Zone
Chongqing 401120, China
Telephone: +86 23 6745 5698

South China

Head office

ASSAB Steels (HK) Ltd
Room 1701-1706
Tower 2 Grand Central Plaza
138 Shatin Rural Committee Road
Shatin NT - Hong Kong
Telephone: +852 2487 1991
www.assabsteels.com

Branch offices

ASSAB Tooling (Dongguan) Co Ltd
Northern District
Song Shan Lake Science & Technology
Industrial Park
Dongguan 523808, China
Telephone: +86 769 2289 7888
www.assabsteels.com

ASSAB Tooling (Xiamen) Co Ltd

First Floor Universal Workshop
No. 30 Huli Zone
Xiamen 361006, China
Telephone: +86 592 562 4678

Hong Kong

ASSAB Steels (HK) Ltd
Room 1701-1706
Grand Central Plaza, Tower 2
138 Shatin Rural Committee Road
Shatin NT, Hong Kong
Telephone: +852 2487 1991
www.assabsteels.com

India

ASSAB Sripad Steels LTD
T 303 D.A.V. Complex
Mayur Vihar Ph I Extension
IN-Delhi-110 091
Telephone: +91 11 2271 2736
www.assabsripadsteels.com

ASSAB Sripad Steels LTD

709, Swastik Chambers
Sion-Trombay Road
Chembur
IN-Mumbai-400 071
Telephone: +91 22 2522-7110, -8133

ASSAB Sripad Steels LTD

Padmalaya Towers
Janaki Avenue
M.R.C. Nagar
IN-Chennai-600 028
Telephone: +91 44 2495 2371

Indonesia

Head office

PT ASSAB Steels Indonesia
Jl. Rawagelam III No. 5
Kawasan Industri Pulogadung
Jakarta 13930, Indonesia
Telephone: +62 21 461 1314
www.assabsteels.com

Branch offices

SURABAYA BRANCH
Jl. Berbek Industri 1/23
Surabaya Industrial Estate, Rungkut
Surabaya 60293, East Java, Indonesia
Telephone: +62 31 843 2277

MEDAN BRANCH

Komplek Griya Riatur Indah
Blok A No.138
Jl. T. Amir Hamzah
Halvetia Timur, Medan 20124
Telephone: +62 61 847 7935/6

BANDUNG BRANCH

Komp. Ruko Bumi Kencana
Jl. Titian Kencana Blok E
No.5 Bandung 40233
Telephone: +62 22 604 1364

TANGERANG BRANCH

Pusat Niaga Cibodas
Blok C No. 7 Tangerang
Telephone: +62 21 921 9596, 551 2732

SEMARANG BRANCH

Jl. Imam Bonjol No.155
R.208 Semarang 50124
Telephone: +62 358 8167

Iran

ASSAB INTERNATIONAL AB
P.O. Box 19395
IR-1517 TEHRAN
Telephone: +98 21 888 35392
www.assabiran.com

Israel

PACKER YADPAZ QUALITY
STEELS Ltd
P.O. Box 686
Ha-Yarkon St. 7, Industrial Zone
IL-81106 YAVNE
Telephone: +972 8 932 8182
www.packer.co.il

Japan

UDDEHOLM KK
Atago East Building
3-16-11 Nishi Shinbashi
Minato-ku, Tokyo 105-0003, Japan
Telephone: + 81 3 5473 4641
www.assabsteels.com

Jordan

ENGINEERING WAY Est.
P.O. Box 874
Abu Alanda
JO-AMMAN 11592
Telephone: +962 6 4161962
engineeringway@assab.com

Malaysia

Head office
ASSAB Steels (Malaysia) Sdn Bhd
Lot 19, Jalan Perusahaan 2
Batu Caves Industrial Estate
68100 Batu Caves
Selangor Malaysia
Telephone: +60 3 6189 0022
www.assabsteels.com

Branch offices

BUTTERWORTH BRANCH
Plot 146a
Jalan Perindustri Bukit Minyak 7
Kawasan Perindustri Bukit Minyak
14000 Bukit Mertajam, SPT Penang
Telephone: +60 4 507 2020

JOHOR BRANCH

No. 8, Jalan Persiaran Teknologi
Taman Teknologi
81400 Senai
Johor DT, Malaysia
Telephone: +60 7 598 0011

New Zealand

VIKING STEELS
25 Beach Road, Otahuhu
P.O. Box 13-359, Onehunga
NZ-Auckland
Telephone: +64 9 270 1199
www.ssm.co.nz

Pakistan

ASSAB International AB
P.O. Box 17595
Jebel Ali
AE-Dubai
Telephone: +971 488 12165
www.assab.se

Philippines

ASSOCIATED SWEDISH STEELS
PHILS Inc.
No. 3 E. Rodriguez Jr., Avenue
Bagong Ilog, Pasig City
Philippines
Telephone: +632 671 1953/2048
www.assabsteels.com

Republic of Korea

Head office
ASSAB Steels (Korea) Co Ltd
116B-8L, 687-8, Kojan-dong
Namdong-ku
Incheon 405-310, Korea
Telephone: +82 32 821 4300
www.assabsteels.com

Branch offices

BUSAN BRANCH
14B-5L, 1483-9, Songjeong-dong
Kangseo-ku, Busan 618-270, Korea
Telephone: +82 51 831 3315

DAEGU BRANCH

Room 27, 7-Dong2 F
Industry Materials Bldg.1629
Sangyeog-Dong, Buk-Ku
Korea-Daegu 702-710
Telephone: +82 53 604 5133

Lebanon

WARDE STEEL & METALS SARL MET
Charles Helou Av, Warde Bldg
P.O. Box 165886
LB-Beirut
Telephone: +961 1 447228
lebanon@assab.com

Saudi Arabia

ASSAB INTERNATIONAL AB
P.O. Box 255092
SA-Riyadh 11353
Telephone: +966 1 4466542
saudiarabia@assab.com

Singapore

Head office Pacific
ASSAB Pacific Pte Ltd
171, Chin Swee Road
No. 07-02, SAN Centre
SG-Singapore 169877
Telephone: +65 6534 5600
www.assabsteels.com

Jurong

ASSAB Steels Singapore (Pte) Ltd
18, Penjuru Close
SG-608616 Singapore
Telephone: +65 6862 2200

Sri Lanka

GERMANIA COLOMBO (Ptd) Ltd
451/A Kandy Road
LK-Kelaniya
Telephone: +94 11 2913556
www.iwsholdings.com

Syria

WARDE STEEL & METALS SARL MET
Charles Helou Av, Warde Bldg
P.O. Box 165886
LB-Beirut
Telephone: +961 1 447228
lebanon@assab.com

Taiwan

Head office
ASSAB Steels (Taiwan) Co Ltd
No. 112 Wu Kung 1st Rd.
Wu Ku Industry Zone
TW-Taipei 248-87, Taiwan (R.O.C.)
Telephone: +886 2 2299 2849
www.assabsteels.com

Branch offices

NANTOU BRANCH
No. 10, Industry South 5th Road
Nan Kang Industry Zone
Nantou 540-66, Taiwan (R.O.C.)
Telephone: +886 49 225 1702

TAINAN BRANCH

No. 180, Yen He Street,
Yong Kang City
Tainan 710-82, Taiwan (R.O.C.)
Telephone: +886 6 242 6838

Thailand

ASSAB Steels (Thailand) Ltd
9/8 Soi Theedintai,
Taeparak Road, Bangplee,
Samutprakarn 10540, Thailand
Telephone: +66 2 385 5937,
+66 2 757 5017
www.assabsteels.com

United Arab Emirates

ASSAB INTERNATIONAL AB
P.O. Box 17595
Jebel Ali
AE-Dubai
Telephone: +971 488 12165
www.assab.se

Vietnam

CAM Trading Steel Co Ltd
90/8 Block 5, Tan Thoi Nhat Ward
District 12, Ho Chi Minh City
Vietnam
Telephone: +84 8 5920 920
www.assabsteels.com

Other Asia

ASSAB INTERNATIONAL AB
Box 42
E-171 11 Solna, Sweden
Telephone: +46 8 564 616 70
www.assab.se

Africa

Egypt

UNITED FOR IMPORT AND
INDUSTRIAL SUPPLIES
Montaser Project No 20
Flat No 14
Al Ahram Street-El Taba
EG-Giza Cairo
Telephone: +20 2 7797751
www.assab.se

Kenya

SANDVIK Kenya Ltd
P.O. Box 18264
Post code 00500
KE-Nairobi
Telephone: +254 20 532 866
sandvik@africaonline.co.ke

South Africa

UDDEHOLM Africa (Pty.) Ltd.
P.O. Box 539
ZA-1600 Isando/Johannesburg
Telephone: +27 11 974 2781
www.bohler-uddeholm.co.za

Tunisia

MCM Distribution
4 Bis, Rue 8610 - Z.I.
2035 Chargula 1
TN-Tunis
Telephone: + 216 71 802479
www.mcm.com.tn

Zimbabwe

Representative office:
UDDEHOLM Africa (Pty.) Ltd.
P.O. Box 539
ZA-1600 Isando/Johannesburg
Telephone: +27 11 974 2781
www.assab.se

Other African Countries

ASSAB INTERNATIONAL AB
Box 42
SE-171 11 Solna, Sweden
Telephone: +46 8 564 616 70
www.assab.se



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