

# ORVAR<sup>®</sup> 2 Microdized

Hot work tool steel

COLD WORK

PLASTIC MOULDING

HOT WORK

HIGH PERFORMANCE STEEL



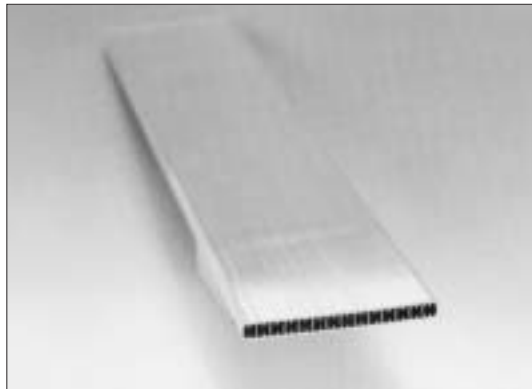
This information is based on our present state of knowledge and is intended to provide general notes on our products and their uses. It should not therefore be construed as a warranty of specific properties of the products described or a warranty for fitness for a particular purpose.

## General

Orvar 2 Microdized is a chromium-molybdenum-vanadium-alloyed steel which is characterized by:

- Good resistance to abrasion at both low and high temperatures
- High level of toughness and ductility
- Uniform and high level of machinability and polishability
- Good high-temperature strength and resistance to thermal fatigue
- Excellent through-hardening properties
- Very limited distortion during hardening.

Typical analysis %	C 0,39	Si 1,0	Mn 0,4	Cr 5,3	Mo 1,3	V 0,9
Standard specification	AISI H13, W.-Nr. 1.2344, EN X40CrMoV5-1					
Delivery condition	Soft annealed to approx. 185 HB					
Colour code	Orange/violet					



## Applications

### TOOLS FOR EXTRUSION

Part	Aluminium, magnesium alloys, HRC	Copper alloys HRC	Stainless steel HRC
Dies Backers, die-holders, liners, dummy blocks, stems	44–50  41–50	43–47  40–48	45–50  40–48
Austenitizing temperature (approx.)	1020–1030°C (1870–1885°F)	1040–1050°C (1900–1920°F)	

### PLASTIC MOULDING APPLICATIONS

Part	Austenitizing temp.	HRC
Injection moulds Compression/transfer moulds	1020–1030°C (1870–1885°F)  Tempering 250°C (480°F)	50–52

### OTHER APPLICATIONS

Application	Austenitizing temp.	HRC
Severe cold punching, scrap shears	1020–1030°C (1870–1885°F) Tempering 250°C (480°F)	50–52
Hot shearing	1020–1030°C (1870–1885°F) Tempering 250°C (480°F) or 575–600°C (1070–1110°F)	50–52 45–50
Shrink rings (e.g. for cemented carbide dies)	1020–1030°C (1870–1885°F) Tempering 575–600°C (1070–1110°F)	45–50
Wear-resisting parts	1020–1030°C (1870–1885°F) Tempering 575°C (1070°F) Nitriding	Core 50–52 Surface ~1000HV <sub>1</sub>

For applications requiring extreme levels of toughness and ductility e.g. die-casting dies, forging dies, the premium-grade H13-steel, Orvar Supreme, is recommended.

# Properties

## PHYSICAL DATA

Unless otherwise is indicated all specimens were hardened 30 minutes at 1025°C (1875°F), quenched in air and tempered 2 + 2 h at 610°C (1130°F). The hardness were 45 ± 1 HRC.

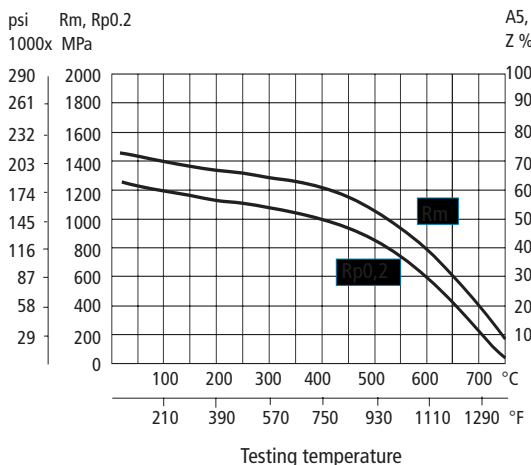
Temperature	20°C (68°F)	400°C (750°F)	600°C (1110°F)
Density kg/m <sup>3</sup> lbs/in <sup>3</sup>	7800 0,281	7700 0,277	7600 0,274
Modulus of elasticity N/mm <sup>2</sup> psi	210 000 30,5 x 10 <sup>6</sup>	180 000 26,1 x 10 <sup>6</sup>	140 000 20,3 x 10 <sup>6</sup>
Coefficient of thermal expansion per °C from 20°C per °F from 68°F	– –	12,6 x 10 <sup>-6</sup> 7,0 x 10 <sup>-6</sup>	13,2 x 10 <sup>-6</sup> 7,3 x 10 <sup>-6</sup>
Thermal conductivity W/m °C Btu in/(ft <sup>2</sup> h°F)	25 176	29 204	30 211

## MECHANICAL PROPERTIES

Approximate tensile strength at room temperature.

Hardness	52 HRC	45 HRC
Tensile strength Rm N/mm <sup>2</sup> kp/mm <sup>2</sup> tsi psi	1820 185 117 263 000	1420 145 92 206 000
Yield point Rp0,2 N/mm <sup>2</sup> kp/mm <sup>2</sup> tsi psi	1520 155 98 220 000	1280 130 83 185 000

Approximate strength at elevated temperatures  
Longitudinal direction.



# Heat treatment

## SOFT ANNEALING

Protect the steel and heat through to 850°C (1560°F). Then cool in the furnace at 10°C (20°F) per hour to 650°C (1200°F), then freely in air.

## STRESS RELIEVING

After rough machining the tool should be heated through to 650°C (1200°F), holding time 2 hours. Cool slowly to 500°C (930°F), then freely in air.

## HARDENING

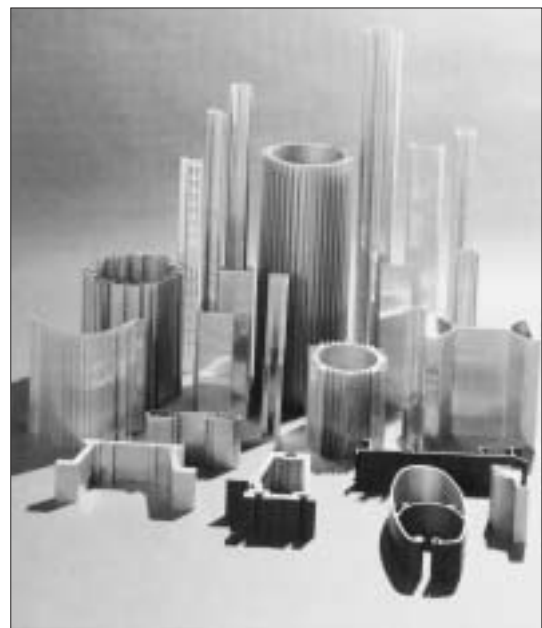
*Pre-heating temperature:* 600–850°C (1110–1560°F), normally in two pre-heating steps.

*Austenitizing temperature:* 1020–1050°C (1870–1920°F), normally 1020–1030°C (1870–1885°F).

Temperature		Soaking* time minutes	Hardness before tempering
°C	°F		
1025	1875	30	53±2 HRC
1050	1920	15	54±2 HRC

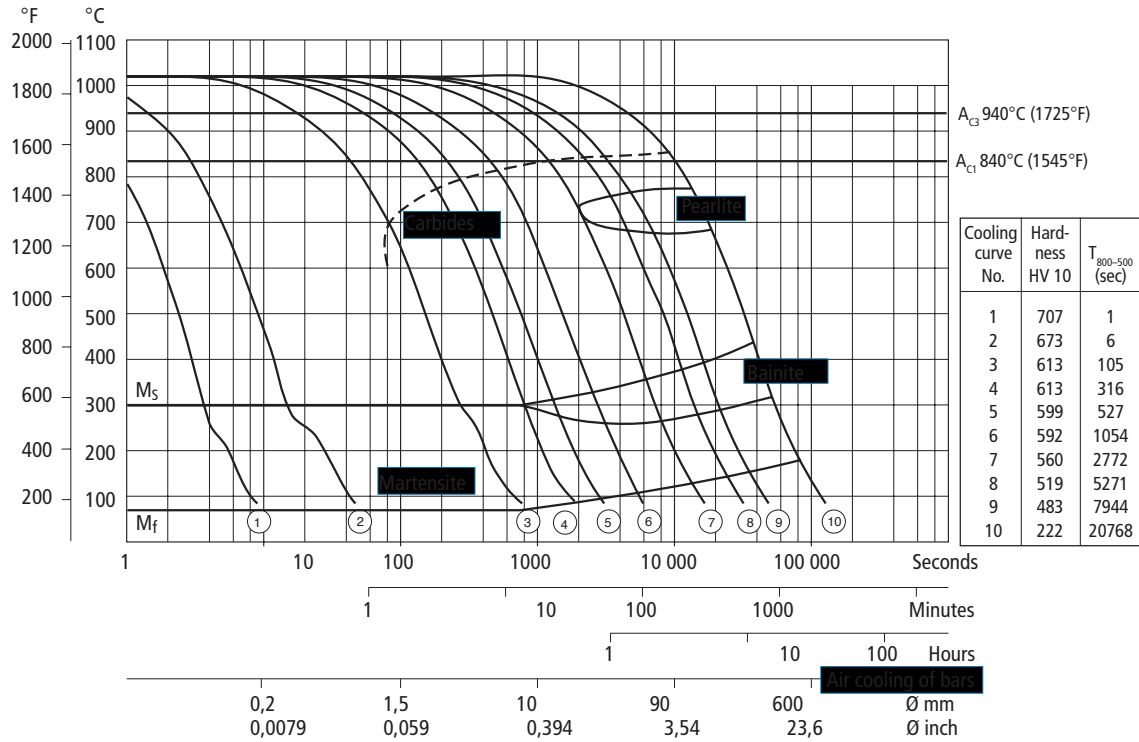
\* Soaking time = time at hardening temperature after the tool is fully heated through.

Protect the part against decarburization and oxidation during hardening.



**CCT graph**

Austenitizing temperature 1020°C (1870°F). Holding time 30 minutes.



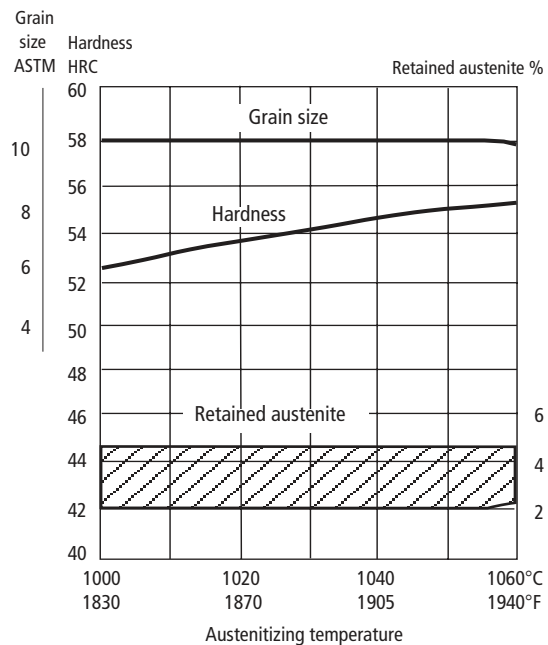
**QUENCHING MEDIA**

- High speed gas/circulating atmosphere
- Vacuum (high speed gas with sufficient positive pressure). An interrupted quench is recommended where distortion control and quench cracking are a concern
- Martempering bath or fluidized bed at 450–550°C (840–1020°F), then cool in air
- Martempering bath or fluidized bed at approx. 180–220°C (360–430°F) then cool in air
- Warm oil.

*Note 1:* Temper the tool as soon as its temperature reaches 50–70°C (120–160°F).

*Note 2:* In order to obtain the optimum properties for the tool, the cooling rate should be fast, but not at a level that gives excessive distortion or cracks.

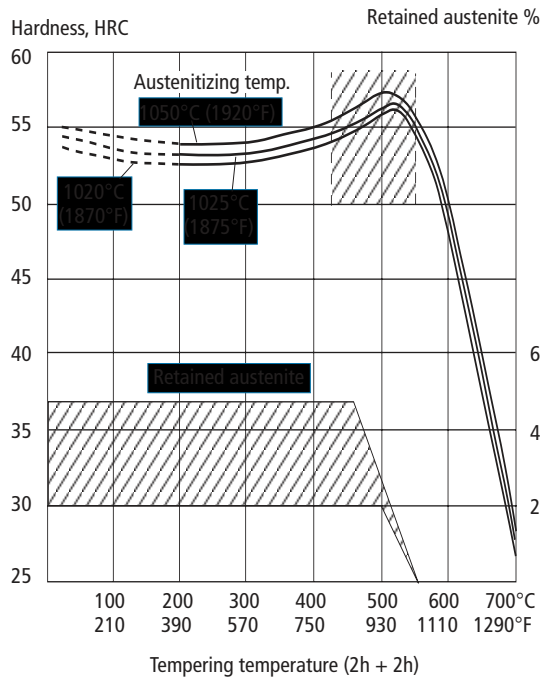
*Hardness, grain size and retained austenite as functions of austenitizing temperature*



### TEMPERING

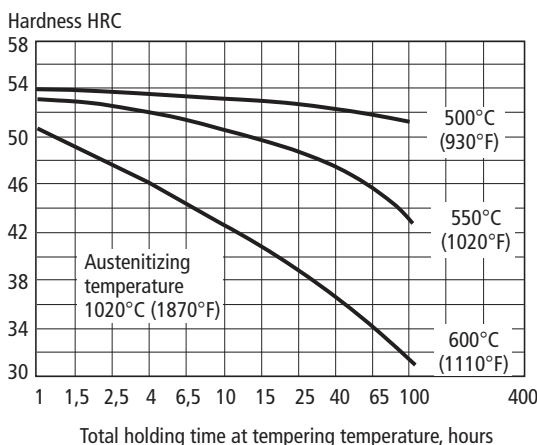
Choose the tempering temperature according to the hardness required by reference to the tempering graph. Temper twice with intermediate cooling to room temperature. Lowest tempering temperature 180°C (360°F). Holding time at temperature minimum 2 hours. Do not temper in the range 425–550°C (800–1020°F).

Tempering graph



Tempering within the range 425–550°C (800–1020°F) is not normally recommended due to the reduction in toughness properties.

Effect of time at tempering temperature

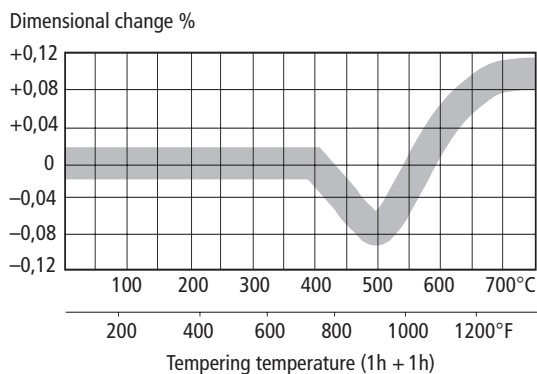


### DIMENSIONAL CHANGES DURING HARDENING

Sample plate, 100 x 100 x 25 mm, 4" x 4" x 1".

		Width %	Length %	Thickness %
Oil hardened from 1020°C (1870°F)	Min.	-0,08	-0,06	±0
	Max.	-0,15	-0,16	+0,30
Air hardened from 1020°C (1870°F)	Min.	-0,02	-0,05	±0
	Max.	+0,03	+0,02	+0,05
Vac hardened from 1020°C (1870°F)	Min.	+0,01	-0,02	+0,08
	Max.	+0,02	-0,04	+0,12

### DIMENSIONAL CHANGES DURING TEMPERING



Note: The dimensional changes in hardening and tempering should be added.

### NITRIDING AND NITROCARBURIZING

Nitriding and nitrocarburizing result in a hard surface layer which is very resistant to wear and erosion. The nitrided layer is, however, brittle and may crack or spall when exposed to mechanical or thermal shock, the risk increasing with layer thickness. Before nitriding, the tool should be hardened and tempered at a temperature at least 25–50°C (45–90°F) above the nitriding temperature.

Nitriding in ammonia gas at 510°C (950°F) or plasma nitriding in a 75% hydrogen/25% nitrogen mixture at 480°C (895°F) both result in a surface hardness of about 1100 HV<sub>0,2</sub>. In general, plasma nitriding is the preferred method because of better control over nitrogen potential; in particular, formation of the so-called white layer, which is not recommended for hot-work service, can readily be avoided. However, careful gas nitriding can give perfectly acceptable results.

Orvar 2 Microdized can also be nitrocarburized in either gas or salt bath. The surface hardness after nitrocarburizing is 900–1000 HV<sub>0,2</sub>.

**DEPTH OF NITRIDING**

Process	Time	Depth	
		mm	inch
Gas nitriding at 510°C (950°F)	10 h 30 h	0,12 0,20	0,0047 0,0079
Plasma nitriding at 480°C (895°F)	10 h 30 h	0,12 0,18	0,0047 0,0071
Nitrocarburizing – in gas at 580°C (1075°F)	2,5 h	0,11	0,0043
– in salt bath at 580°C (1075°F)	1 h	0,06	0,0024

Nitriding to case depths >0,3 mm (0,012 inch) is not recommended for hot-work applications.

Orvar 2 Microdized can be nitrided in the soft-annealed condition. The hardness and depth of case will, however, be reduced somewhat in this case.

**Machining recommendations**

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

More information can be found in the Uddeholm publication "Cutting data recommendations".

**Condition: Sof annealed to approx. 185 HB**

**TURNING**

Cutting data parameters	Turning with carbide		Turning with high speed steel Fine turning
	Rough turning	Fine turning	
Cutting speed (v <sub>c</sub> ) m/min f.p.m.	200–250 656–820	250–300 820–984	25–30 82–98
Feed (f) mm/r i.p.r.	0,2–0,4 0,008–0,016	0,05–0,2 0,002–0,008	0,05–0,3 0,002–0,01
Depth of cut (a <sub>p</sub> ) mm inch	2–4 0,08–0,16	0,5–2 0,02–0,08	0,5–3 0,02–0,12
Carbide designation ISO US	P20–P30 C6–C5 Coated carbide	P10 C7 Coated carbide or cermet	– –

**DRILLING**

**High speed steel twist drill**

Drill diameter		Cutting speed, v <sub>c</sub>		Feed, f	
mm	inch	m/min	f.p.m.	mm/r	i.p.r.
– 5	–3/16	16–18*	52–59*	0,05–0,15	0,002–0,006
5–10	3/16–3/8	16–18*	52–59*	0,15–0,20	0,006–0,008
10–15	3/8–5/8	16–18*	52–59*	0,20–0,25	0,008–0,010
15–20	5/8–3/4	16–18*	52–59*	0,25–0,35	0,010–0,014

\* For coated HSS drill v<sub>c</sub> = 28–30 m/min. (92–98 f.p.m.).

**Carbide drill**

Cutting data parameters	Type of drill		
	Indexable insert	Solid carbide	Brazed carbide <sup>1)</sup>
Cutting speed (v <sub>c</sub> ) m/min f.p.m.	220–240 720–785	130–160 425–525	80–110 260–360
Feed (f) mm/r i.p.r.	0,03–0,10 <sup>2)</sup> 0,001–0,004 <sup>2)</sup>	0,10–0,25 <sup>2)</sup> 0,004–0,010 <sup>2)</sup>	0,15–0,25 <sup>2)</sup> 0,006–0,010 <sup>2)</sup>

<sup>1)</sup> Drill with internal cooling channels and brazed carbide tip.

<sup>2)</sup> Depending on drill diameter.

**MILLING**

**Face and square shoulder milling**

Cutting data parameters	Milling with carbide	
	Rough milling	Fine milling
Cutting speed (v <sub>c</sub> ) m/min f.p.m.	180–260 591–853	260–300 853–984
Feed (f <sub>z</sub> ) mm/tooth inch/tooth	0,2–0,4 0,008–0,016	0,1–0,2 0,004–0,008
Depth of cut (a <sub>p</sub> ) mm inch	2–5 0,08–0,2	–2 –0,08
Carbide designation ISO US	P20–P40 C6–C5 Coated carbide	P10–P20 C6–C7 Coated carbide or cermet

**End milling**

Cutting data parameters	Type of end mill		
	Solid carbide	Carbide indexable insert	High speed steel
Cutting speed (v <sub>c</sub> ) m/min f.p.m.	160–200 525–660	170–230 560–755	35–40 <sup>1)</sup> 115–130 <sup>1)</sup>
Feed (f <sub>z</sub> ) mm/tooth inch/tooth	0,03–0,20 <sup>2)</sup> 0,001–0,008 <sup>2)</sup>	0,08–0,20 <sup>2)</sup> 0,003–0,008 <sup>2)</sup>	0,05–0,35 <sup>2)</sup> 0,002–0,014 <sup>2)</sup>
Carbide designation ISO	–	P20, P30	–

<sup>1)</sup> For coated HSS end mill v<sub>c</sub> = 55–60 m/min. (180–195 f.p.m.).

<sup>2)</sup> Depending on radial depth of cut and cutter diameter.

## GRINDING

A general grinding wheel recommendation is given below. More information can be found in the Uddeholm brochure "Grinding of Tool Steel" and can also be obtained from the grinding wheel manufacturer.

### Wheel recommendation

Type of grinding	Soft annealed condition	Hardened condition
Face grinding straight wheel	A 46 HV	A 46 HV
Face grinding segments	A 24 GV	A 36 GV
Cylindrical grinding	A 46 LV	A 60 KV
Internal grinding	A 46 JV	A 60 IV
Profile grinding	A 100 LV	A 120 KV

## Electrical-discharge machining

If spark-erosion is performed in the hardened and tempered condition, the white re-cast layer should be removed mechanically e.g. by grinding or stoning. The tool should then be given an additional temper at approx. 25°C (50°F) below the previous tempering temperature.

## Welding

Welding of tool steel can be performed with good results if proper precautions are taken regarding elevated temperature, joint preparation, choice of consumables and welding procedure.

Welding method	TIG	MMA
Working temperature	325–375°C 620–710°F	325–375°C 620–710°F
Filler metal	QRO 90 TIG-WELD DIEVAR TIG-WELD	QRO 90 WELD
Cooling rate	20–40°C/h (35–70°F/h) the first 2–3 h then freely in air.	
Hardness after welding	50–55 HRC	50–55 HRC
<b>Heat treatment after welding</b>		
Hardened condition	Temper at 25°C (45°F) below the original tempering temperature.	
Soft annealed condition	Soft-anneal the material at 850°C (1560°F) in protected atmosphere. Then cool in the furnace at 10°C (20°F) per hour to 650°C (1200°F) then freely in air.	

More detailed information can be found in the Uddeholm brochure "Welding of Tool Steel".

## Hard-chromium plating

After plating, parts should be tempered at 180°C (360°F) for 4 hours within 4 hours of plating to avoid the risk of hydrogen embrittlement.

## Photo-etching

Orvar 2 Microdized is particularly suitable for texturing by the photo-etching method. Its high level of homogeneity and low sulphur content ensures accurate and consistent pattern reproduction.

## Polishing

Orvar 2 Microdized exhibits good polishability in the hardened and tempered condition. Polishing after grinding can be effected using aluminium oxide or diamond paste.

Typical procedure:

1. Rough grinding to 180–320 grain size using a wheel or stone.
2. Fine grinding with abrasive paper or powder down to 400–800 grain size.
3. Polish with diamond paste grade 15 (15µm grain size) using a polishing tool of soft wood or fibre.
4. Polish with diamond paste 8–6–3 (8–6–3µm grain size) using a polishing tool of soft wood or fibre.
5. When demands on surface finish are high, grade 1 (1µm grain size) diamond paste can be used for final polishing with a fibre polishing pad.

## Further information

Please contact your local Uddeholm office for further information on the selection, heat treatment, application and availability of Uddeholm tool steels.



## UDDEHOLM EUROPE

### AUSTRIA

UDDEHOLM  
Hansaallee 321  
D-40549 Düsseldorf  
Telephone: +49 211 535 10  
Telefax: +49 211 535 12 80

### BELGIUM

UDDEHOLM N.V.  
Waterstraat 4  
B-9160 Lokeren  
Telephone: +32 9 349 11 00  
Telefax: +32 9 349 11 11

### CROATIA

BOHLER UDDEHOLM Zagreb  
d.o.o. za trgovinu  
Zitnjak b.b  
10000 Zagreb  
Telephone: +385 1 2459 301  
Telefax: +385 1 2406 790

### CZECHIA

BOHLER UDDEHOLM CZ s.r.o.  
Division Uddeholm  
U silnice 949  
161 00 Praha 6 Ruzyně  
Czech Republic  
Telephone: +420 233 029 850,8  
Telefax: +420 233 029 859

### DENMARK

UDDEHOLM A/S  
Kokmose 8, Bramdrupdam  
DK-6000 Kolding  
Telephone: +45 75 51 70 66  
Telefax: +45 75 51 70 44

### ESTONIA

UDDEHOLM TOOLING ESTI OÜ  
Siilikatsiidi 7  
EE-11216 Tallinn  
Telephone: +372 655 9180  
Telefax: +372 655 9181

### FINLAND

OY UDDEHOLM AB  
Ritakuja 1, PL 57,  
FIN-01741 VANTAA  
Telephone: +358 9 290 490  
Telefax: +358 9 2904 9249

### FRANCE

UDDEHOLM S.A.  
12 Rue Mercier, Z.I. de Mitry-Compans  
F-77297 Mitry Mory Cedex  
Telephone: +33 (0)1 60 93 80 10  
Telefax: +33 (0)1 60 93 80 01

#### Branch office

UDDEHOLM S.A.  
77bis, rue de Vesoul  
La Nef aux Métiers  
F-25000 Besançon  
Telephone: +33 381 53 12 19  
Telefax: +33 381 53 13 20

### GERMANY

UDDEHOLM  
Hansaallee 321  
D-40549 Düsseldorf  
Telephone: +49 211 535 10  
Telefax: +49 211 535 12 80

#### Branch offices

UDDEHOLM  
Falkenstraße 21  
D-65812 Bad Soden/TS.  
Telephone: +49 6196 659 60  
Telefax: +49 6196 659 625

### UDDEHOLM

Albstraße 10  
D-73765 Neuhausen  
Telephone: +49 715 898 65-0  
Telefax: +49 715 898 65-25

### GREAT BRITAIN, IRELAND

UDDEHOLM UK LIMITED  
European Business Park  
Taylors Lane, Oldbury  
West Midlands B69 2BN  
Telephone: +44 121 552 55 11  
Telefax: +44 121 544 29 11

Dublin Telephone: +353 1 45 14 01

### GREECE

UDDEHOLM STEEL TRADING  
COMPANY  
20, Athinon Street  
G-Piraeus 18540  
Telephone: +30 2 10 41 72 109/41 29 820  
Telefax: +30 2 10 41 72 767

#### Agency

SKLERO S.A.  
Steel Trading Comp. and  
Hardening Shop  
Frixou 11/Nikif. Ouranou  
G-54627 Thessaloniki  
Telephone: +30 31 51 46 77  
Telefax +30 31 54 12 50  
SKLERO S.A.  
Heat Treatment and Trading of Steel  
Uddeholm Tool Steels  
Industrial Area of Thessaloniki  
P.O. Box 1123  
G-57022 Sindos, Thessaloniki  
Telephone: +30 23 10 79 76 46  
Telefax: +30 23 10 79 76 78

### HUNGARY

UDDEHOLM TOOLING/BOK  
Dunaharaszti, Jedlik Ányos út 25  
H-2331 Dunaharaszti 1.Pf. 110  
Telephone/Telefax: +36 24 492 690

### ITALY

UDDEHOLM div. della Bohler  
Uddeholm Italia S.p.A.  
Via Palizzi, 90  
I-20157 Milano  
Telephone: +39 02 35 79 41  
Telefax: +39 02 390 024 82

### LATVIA

UDDEHOLM TOOLING AB  
Piedrujas street 7  
LV-1073 Riga  
Telephone: +371 7 703 133  
Telefax: +371 7 185 079

### LITHUANIA

UDDEHOLM TOOLING AB  
BE PLIENAS IR METALAI  
T. Masiulio 18b  
LT-52459 Kaunas  
Telephone: +370 37 370613, -669  
Telefax: +370 37 370300

### THE NETHERLANDS

UDDEHOLM B.V.  
Isolatorweg 30  
NL-1014 AS Amsterdam  
Telephone: +31 20 581 71 11  
Telefax: +31 20 684 86 13

### NORWAY

UDDEHOLM A/S  
Jernkroken 18  
Postboks 85, Kalbakken  
N-0902 Oslo  
Telephone: +47 22 91 80 00  
Telefax: +47 22 91 80 01

### POLAND

INTER STAL CENTRUM  
Sp. z o.o./Co. Ltd.  
ul. Kolejowa 291, Dziekanów Polski  
PL-05-092 Lomianki  
Telephone: +48 22 429 2260  
Telefax: +48 22 429 2266

### PORTUGAL

F RAMADA Aços e Industrias S.A.  
P.O. Box 10  
P-3881 Ovar Codex  
Telephone: +351 56 58 61 11  
Telefax: +351 56 58 60 24

### ROMANIA

BÖHLER Romania SRL  
Uddeholm Branch  
Str. Atomistilor Nr 14A  
077125 Magurele Jud Ilfov  
Telephone: +40 214 575007  
Telefax: +40 214 574212

### RUSSIA

UDDEHOLM TOOLING CIS  
25 A Bolshoy pr PS  
197198 St. Petersburg  
Telephone: +7 812 233 9683  
Telefax: +7 812 232 4679

### SLOVAKIA

UDDEHOLM Slovakia  
Nástrojové ocele, s.r.o  
KRÁČINY 2  
036 01 Martin  
Telephone: +421 842 4 300 823  
Telefax: +421 842 4 224 028

### SLOVENIA

UDDEHOLM div. della Bohler  
Uddeholm Italia S.p.A.  
Via Palizzi, 90  
I-20157 Milano  
Telephone: +39 02 35 79 41  
Telefax: +39 02 390 024 82

### SPAIN

UDDEHOLM  
Guifré 690-692  
E-08918 Badalona, Barcelona  
Telephone: +34 93 460 1227  
Telefax: +34 93 460 0558

#### Branch office

UDDEHOLM  
Barrio San Martin de Arteaga, 132  
Pol.Ind. Torrelarragoiti  
E-48170 Zamudio  
(Bizkaia)  
Telephone: +34 94 452 13 03  
Telefax: +34 94 452 13 58

### SWEDEN

UDDEHOLM TOOLING  
SVENSKA AB  
Aminogatan 25  
SE-431 53 Mölndal  
Telephone: +46 31 67 98 50  
Telefax: +46 31 27 02 94

### SWITZERLAND

HERTSCH & CIE AG  
General Wille Strasse 19  
CH-8027 Zürich  
Telephone: +41 44 208 16 66  
Telefax: +41 44 201 46 15

## UDDEHOLM NORTH AMERICA

### USA

UDDEHOLM  
4902 Tollview Drive  
Rolling Meadows, IL 60008  
Sales Phone: +1 800 638 2520  
Sales Fax: +1 630 350 0880

*Region East Warehouse*  
UDDEHOLM – Shrewsbury, MA

*Region Central Warehouse*  
UDDEHOLM – Wood Dale, IL

*Region West Warehouse*  
UDDEHOLM – Santa Fe Springs, CA

### CANADA

UDDEHOLM  
2595 Meadowvale Blvd.  
Mississauga, ON L5N 7Y3  
Telephone: +1 905 812 9440  
Telefax: +1 905 812 8658

#### Branch Warehouses

UDDEHOLM – St. Laurent, QC  
UDDEHOLM – New Westminster, BC

#### Heat Treating

THERMO-TECH – Mississauga, ON

### MEXICO

ACEROS BOHLER UDDEHOLM,  
S.A. de C.V.  
Calle 8 No 2, Letra "C"  
Fraccionamiento Industrial Alce Blanco  
C.P. 52787 Naucalpan de Juarez  
Estado de Mexico  
Telephone: +52 55 9172 0242  
Telefax: +52 55 5576 6837

### UDDEHOLM

Letrado de Tejada No.542  
Colonia Las Villas  
66420 San Nicolas de Los Garza, N.L.  
Telephone: +52 8-352 5239  
Telefax: +52 8-352 5356

## UDDEHOLM SOUTH AMERICA

### ARGENTINA

UDDEHOLM S.A  
Mozart 40  
1619-Centro Industrial Garin  
Garin-Prov. Buenos Aires  
Telephone: +54 332 744 4440  
Telefax: +54 332 745 3222

### BRAZIL

UDDEHOLM ACOS ESPECIAIS Ltda.  
Estrada Yae Massumoto, 353  
CEP 09842-160  
Sao Bernardo do Campo - SP Brazil  
Telephone: +55 11 4393 4560, -4554  
Telefax: +55 11 4393 4561

## UDDEHOLM SOUTH AFRICA

UDDEHOLM Africa (Pty) Ltd.  
P.O. Box 539  
ZA-1600 Isando/Johannesburg  
Telephone: +27 11-974 2781  
Telefax: +27 11-392 2486

## UDDEHOLM AUSTRALIA

BOHLER-UDDEHOLM Australia  
129-135 McCredie Road  
Guildford NSW 2161  
Private Bag 14  
Telephone: +61 2 9681 3100  
Telefax: +61 2 9632 6161

#### Branch offices

Sydney, Melbourne, Adelaide,  
Brisbane, Perth, Newcastle,  
Launceston, Albury, Townsville

### ASSAB

### ASSAB INTERNATIONAL

Skytteholmsvägen 2  
P O Box 42  
SE-171 11 Solna  
Sweden  
Telephone: +46 8 564 616 70  
Telefax: +46 8 25 02 37

#### Subsidiaries

India, Iran, Turkey, United Arab  
Emirates, Saudi Arabia  
*Distributors in*  
Africa, Latin America, Middle East

### ASSAB PACIFIC

ASSAB Pacific Pte. Ltd  
171, Chin Swee Road  
No. 07-02, San Centre  
Singapore 169877  
Telephone: +65 534 56 00  
Telefax: +65 534 06 55

#### Subsidiaries

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