



## SCE-SEA | Rolling Mill Rolls – Long Products

Typical roll configurations, materials and metallurgical properties for long product rolling mills

### Casting Type                      Roll Type                      Dimensions

Nodular ferritic Cast Iron	first	Ø 300 x 1300
Nodular Pearlitic Cast Iron	intermediate	Ø 300 x 1350
Nodular Acicular Cast Iron	finishing	Ø 300 x 1000

**For our Customer order, and follow specification, the Metallurgical laboratory certified and confirmed the parameter below**

**Method casting:**                      centrifugal casted      ( NA ≥350 )                      static casted

#### After Machining

Roll Type	Tensile strength Mpa	Barrel hardness HS	Roll Neck hardness HS
First	≥450	45-55	35-55
Intermediate	≥450	55-65	35-55
Finishing	≥450	62-72	35-55
Backup roll			
Work roll			

Hardness HS	C%	MN%	Si%	Cr%	Ni%	Mo%	Mg%	S%	P%
40-50	3.00-3.30	0.30-0.60	1.50-2.30	0.015max	0.010max	0.030max	≥0.04	1.50-2.00	0.25-0.40
50-60	3.00-3.30	0.30-0.60	1.50-2.30	0.015max	0.010max	0.030max	≥0.04	1.50-2.00	0.25-0.40
60-70	3.10-3.50	0.50-1.00	1.30-1.80	0.015max	0.010max	0.030-0.080	≥0.04	1.50-2.50	0.30-0.60
70-75	3.10-3.50	0.50-1.00	1.30-1.80	0.015max	0.010max	0.030-0.080	≥0.04	1.50-2.50	0.30-0.60

The data shown are indicative and subject to final customer specifications and rolling mill requirements.