

Steel foundry production and materials



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Millucast Oy produces customer specified castings from single pieces into long product series using a wide range of materials.

STAINLESS STEELS

EN	ASTM	SS	Other Standard	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	HB (Brinell)
Stainless							
Typical values unless otherwise stated							
1.4308	CF8	2333		230	470	45	155
1.4309	CF3			250	490	40	155
Acid proof							
1.4408	CF8M	2343		250	520	40	155
1.4409	CF3M			260	530	40	155
Duplex							
1.4462	4A	2377		500	700	30	220
1.4474	3A	2324		450	650	27	220
Martensitic							
1.4317	CA6NMA			740	920	16	290
1.4405		2387		700	900	17	290
Super austenitic							
1.4547	CK3MCuN	2378	SMO254	270	570	40	155

HEAT-RESISTANT STEELS

EN	ASTM	SS		R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	HB (Brinell)
1.4837	HH			250	520	15	155

STEELS FOR HIGH TEMPERATURE SERVICE

EN	ASTM	SS	Other Standard	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	HB (Brinell)
1.7357	WC6	2223		300	500	20	165
1.7379	WC9	2224		320	520	20	180

STEELS FOR QUENCHING AND TEMPERING

EN	ASTM	SS	Other Standard	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	HB (Brinell)
G20Mn5	WCB		GS45	300	500	25	160
25CrMo4		2225		550	750	12	250
			Boron steels	700	800	15	260

WEAR RESISTANT STEELS AND IRONS

EN	ASTM	SS	Other Standard	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	HB (Brinell)
			TA				450-500
			TC				500-600
GJN-HV600	A532CIII		XA				500-600
			Boron steels	800-	950-	12-	300-



Casting weights and batch sizes:

Shell moulding:

weight range of castings 1- approx. 50 kg
ideal for serial production – batch sizes from 50 pcs
max product dimensions 450*450*600 mm

Hand moulding:

weight range of castings 10 - approx. 5000 kg
for smaller production series – batch sizes from 1 piece
max product dimensions 3000*2500*1500 mm

The shape of the product will affect to max casting weight and dimensions.
In cases the product is ideal for casting little heavier castings can be made.

Quality

Miilucast is certified in accordance with ISO 9001:2015, ISO 14001:2015 and OHSAS 18001:2007.
Foundry is also certified material manufacturer according to Pressure Equipment Directive (PED) 2014/68/EU.

Modern 3D- and simulation software's are used in casting design.

Inspection methods covers typical NDT-methods (ultrasonic test UT, magnetic particle test MT and liquid penetrant test PT) and also X-ray test, all in-house.





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