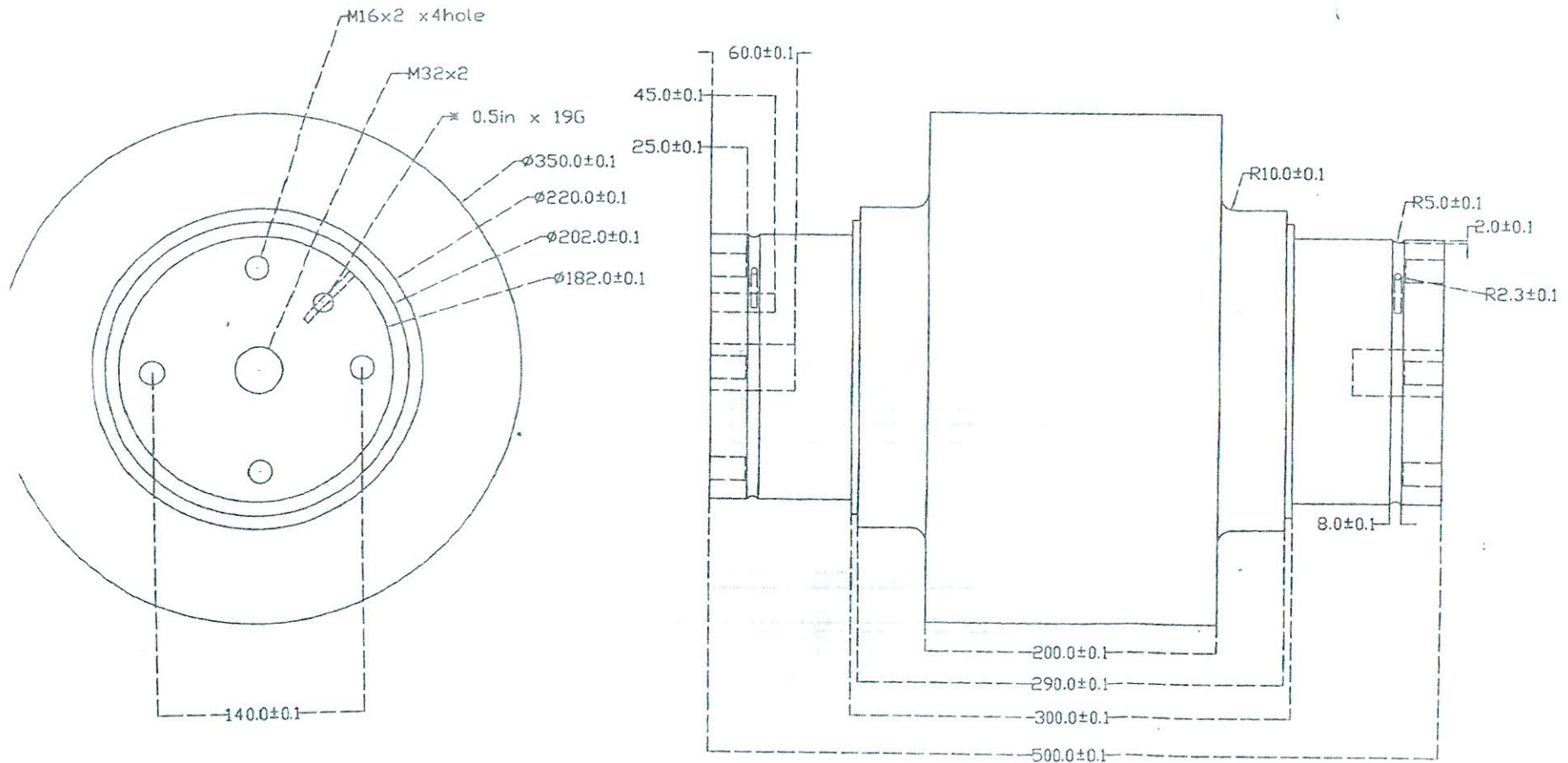


WORKING & BACKUP ROLLS FOR MERCON ROLLING MILL

Sr#	Description	Qty
1	<u>Backup Roll for Cold Rolling Mill</u> (Drawing attached) • Material: Cr3 • Composition: ○ C: 0.82-0.9 ○ Si: 0.3-0.5 ○ Mn: 0.2-0.45 ○ P: ≤ 0.05 ○ S: ≤ 0.01 ○ Cr: 2.8-3.2 ○ Ni: 0.6-0.8 ○ Mo: 0.2-0.4 ○ V: 0.5-0.15 • Hardness: 50-55 HRC • Depth of Hardness Zone: 20-28 mm • Roughness: 2 micrometer • Backup Surface Dia: 350 mm • Roll length: 500 mm	One Set (2 Rolls/set)
2	<u>Working Roll for Cold Rolling Mill</u> (Drawing attached) • Material: Cr5 • Composition: ○ C: 0.35-0.45 ○ Si: 0.3-0.45 ○ Mn: 0.2-0.4 ○ P: ≤ 0.015 ○ S: ≤ 0.01 ○ Cr: 4.8-5.2 ○ Ni: 0.3-0.5 ○ Mo: 0.2-0.4 ○ V: 0.1-0.2 • Hardness: 62-64 HRC • Depth of Hardness Zone: 30-50 mm • Roughness: ≤ 0.40 micrometer • Working Surface Dia: 180 mm • Roll Length: 624 mm	2 Sets (2 Rolls/set)

BACKUP ROLL OF COLD ROLLING MILL



Note:-

1. Dimensions are in mm except for one pipe hole(*OD:0.5inch ,teeth per inch: 19)
2. **R2.3,depth 45mm drill towards center.
3. Material: Cr3
4. Quantity = 1 set i.e. 02 Nos Rolls
5. Hardness 50-55 HRC, Depth of Hardness zone: 20-28 mm.
6. Roughness 2micron meter

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