

CROMAX® C35E

Hard chrome bar



OVAKO

Cromax® C35E is a hard-chrome plated product based on medium-carbon steel. Compared with the traditional C45E-base, C35E offers improved weldability. However, by means of thermo-mechanical processing, the mechanical properties of the C35E used for Cromax products are rendered equivalent to those attainable in C45E.

Average chemical analysis Cromax® C35E (*)

C %	Si %	Mn %	S %	C.E. %(**)
0.37	0.25	0.65	0.02	0.65 max.

*Analysis spread corresponds to HH requirements in EN 10083-1+A1.

**C.E. = % C + % Mn/6 + (% Cu + % Ni)/15 + (% Cr + % Mo + % V)/5

Corresponding standards

The table shows the closest equivalent standard for the steel in Cromax C35E.

Cromax	EN	DIN	BS	AFNOR	SAE/ASTM
C35E	C35E	Ck35	080M36	XC38	1035

Mechanical properties (*)

Size (ϕ), mm	Yield stress, $R_{p0,2}$, N/mm ² , min.	Ultimate tensile stress, R_m , N/mm ² , min.	Elongation, A_5 , %, min.	Hardness, HB
<20	345	590	10	–
20 - 90	345	590	19	165-220

(*) Mechanical properties conform to EN 10083-1+A1 for grade C45E in N (normalised)-condition

Chrome layer

For $\phi \geq 20$ mm, the chrome layer thickness is min. 20 µm.

For smaller sizes, the minimum thickness is 15 µm.

Surface roughness

The surface roughness (Ra) is always less than 0.2 µm and normally in the range 0.05-0.15 µm. Rt (ISO) is always less than 2.0 µm and normally in the range 0.5-1.5 µm.

Surface hardness, induction hardening

The chrome layer hardness is 850 HV_{0,1} min.

Cromax C35E can be supplied in an induction-hardened execution. In such a case, the hardness immediately beneath the chrome layer is 50 HRC min., and the depth of hardening is between 1.0 and 3.0 mm depending on dimension.

However, for applications requiring a surface-hardened execution, Cromax IH 482, induction-hardened hard-chrome bar is recommended.

Straightness

For $\phi < 30$ mm, the maximum deviation is 0.1 mm/0.5 m.

The maximum deviation for larger diameters is 0.1 mm/1.0 m.

Roundness

The out of roundness is maximised at 50% of the diameter tolerance interval.

Diameter tolerance

ISO f7 is standard. Other tolerances can be supplied on request (narrowest range is ISO level 7).

Tolerance ranges

Size, mm	upper	ISO f7, µm	lower
10 - 18	- 16		- 34
> 18 - 30	- 20		- 41
> 30 - 50	- 25		- 50
> 50 - 80	- 30		- 60
> 80 - 120	- 36		- 71

Standard sizes

Dia., mm	kg/m	Dia., mm	kg/m	Dia., inch	kg/m
10	0.62	40	9.86	1/2	1.00
12	0.89	42	10.88	5/8	1.55
14	1.21	45	12.48	3/4	2.23
16	1.58			7/8	3.05
18	2.00	50	15.41		
		55	18.65	1	3.97
20	2.47	56	19.33	1 1/4	6.22
22	2.98			1 3/8	7.52
25	3.85	60	22.19	1 1/2	8.92
28	4.83	63	24.47	1 3/4	12.19
		65	26.05		
30	5.55			2	15.91
32	6.31	70	30.21	2 1/4	20.13
35	7.55	75	34.68	2 1/2	24.87
36	7.99			2 3/4	30.09
38	8.90	80	39.46		
		85	44.54	3	35.81
		90	49.94	3 1/4	42.03
				3 1/2	48.72

Other sizes can be supplied upon request but not outside the above range.

Delivery lengths

Production lengths are between 3.6-7.6 m. Standard is 6.1+0.1/-0 m with the following exceptions. For $\phi \leq 20$ mm, the production length is 3.6+0.2/-0 m. For diameters 20 and 22 mm, the standard production lengths are 5.0+0.1/-0 m and 5.5+0.1/-0 m respectively. Bars with length 7.6+0.1/-0 m can only be supplied for diameters between 40-80 mm.

The "unchromed length" of each bar, i.e. the distance at each end over which the chrome-layer properties and tolerances can not be guaranteed, is at most 0.15 m per end, i.e. 0.3 m in total per bar.

Fixed, cut lengths can be supplied if required, but at a higher price than production lengths.

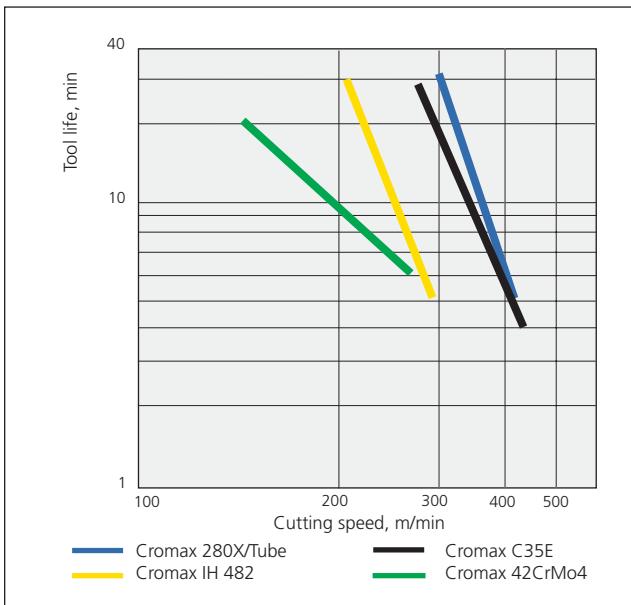
Weldability

Cromax C35E is relatively easy to weld but preheating to 150-200°C is recommended especially for diameters above 40 mm. Suitable consumables are OK 74.78 for MMA welding and OK 12.64 for MAG welding (shielding gas 80% Ar, 20% CO₂).

Cromax C35E can normally be friction welded without problems. However, special procedures may be necessary for larger diameters.

Machinability

The machinability of Cromax products in turning is compared in the diagram below. Coated carbide tool Sandvik SNMG 120408-PM-4015. Feed 0.4 mm/r. Cutting depth 2 mm. Wear criterion 0.4 mm. Cutting fluid: Peralube 0125 5%.



Specific machining recommendations for turning and threading of Cromax C35E are tabulated below.

Operation/parameters	Rough turning	Fine turning	Threading
Feed, mm/r	0.3 – 0.6	0.05 – 0.3	–
Cut depth, mm	2 – 5	0.2 – 2.0	–
Tool (coated)	ISO P15 – P30	ISO P10 – P15	ISO P20 – P30
Speed, m/min	280 – 350	350 – 400	200 – 230

Corrosion resistance

The chromium layer generated in hard-chrome plating contains micro-cracks and its corrosion resistance is thereby limited. Ovako's Cromax products are characterised by a controlled micro-crack distribution with high crack density, which in combination with specially adapted finishing procedures, provides for superior corrosion resistance.

Most corrosion resistance specifications for hard-chrome products are based on salt-spray testing following the ISO 9227 standard or its equivalents (see below), combined with evaluation according to ISO 10289.

ISO 9227	ASTM	DIN 50021	Salt spray type
NSS	B 117	SS	Neutral
AASS	B 287	ESS	Acetic acid
CASS	B 368	CASS	Copper-accelerated acetic acid

While the correlation between these methods is not always clear, our experience is that a given degree of corrosion is reached 2-3 times as fast in the AASS test as in NSS-testing.

Cromax in standard execution is guaranteed to attain rating 9 or better after 40h in AASS test. The same rating will be achieved in NSS test after about 100h.

Packaging

Cromax C35E can be supplied with three different packaging options:

- Paper tubes with the characteristic blue and yellow spiral stripes.
- Grey plastic sleeve, which can be left on as protection during piston-rod manufacture.
- Plastic spacer rings.

For the two latter alternatives, the bars are normally packed in a wooden box for additional protection during transport.

Irrespective of mode of packaging, every Cromax bar is roll-marked with product and batch information so as to facilitate full traceability.

Other Cromax products

Ovako's hard-chrome product programme also comprises:

- Cromax 280X based on a weldable, microalloyed steel,
- induction-hardened bar, Cromax IH 482,
- quenched and tempered bar, Cromax 42CrMo4, and
- Cromax in the form of tube (Cromax Tube).

CROMAX® C, Ni-CROMAX®

When the application demands a higher corrosion resistance than afforded by standard Cromax, then Cromax C or Ni-Cromax execution is recommended.

Cromax C is guaranteed for min. rating 9 after 100h in ISO 9227, AASS. Ni-Cromax is guaranteed not to corrode at all (rating 10) after 350h in AASS or 1 000h in NSS.

In order to distinguish from standard execution, Cromax C is supplied in a red plastic sleeve. Ni-Cromax is characterised by white plastic or a white paper tube.

Ni-Cromax execution is described in more detail in a separate data sheet.

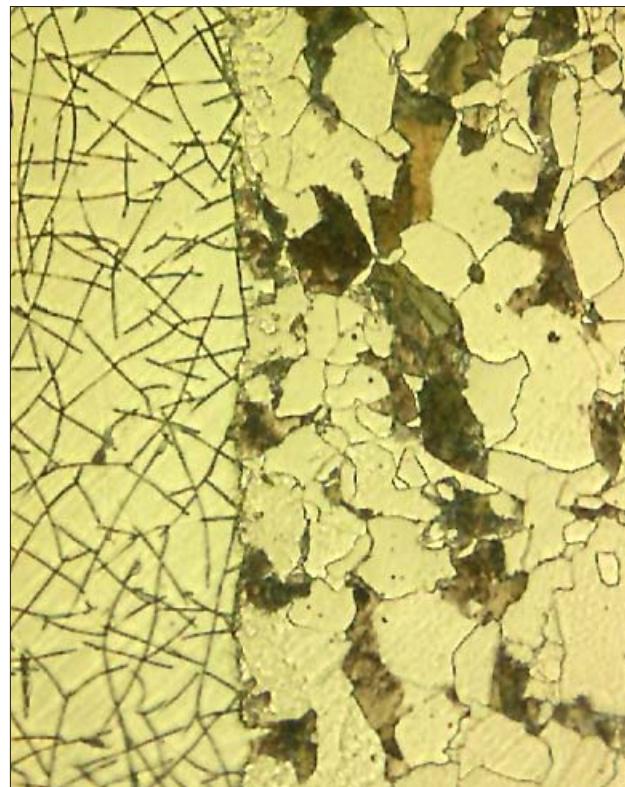
We reserve the right to make changes to dimensions, tolerances and other data given in this sheet.

Ovako is a leading European producer of special steel long products for the automotive and engineering industries. Deliveries in 2005 exceeded 1.6 million tons and comprised low-alloy and carbon steels in the form of bars, wire rod, tubes, rings and pre-components. The company has 16 manufacturing sites and several sales companies in Europe and the USA. Ovako has 4,600 employees.

Ovako Cromax is the major manufacturer in Europe of hard-chrome plated products in the form of bar and tube. The Cromax Group comprises five modern production units, two in Sweden and one in each of Holland, France and Italy.

The majority of the base-material requirements for Cromax manufacture are supplied by Ovako's own steel production units. The high and reproducible quality and superior mechanical characteristics of Cromax products are to a large extent attributable to a complete control over the entire manufacturing chain from steel melting to finished bar.

Ovako Cromax has about 200 employees and a turnover of EUR 60 million.



Ovako Cromax AB
Box 5013
SE-194 05 UPPLANDS VÄSBY
Sweden
Tel. +46 8 622 13 00
Fax. +46 8 622 13 28

Ovako Twente B.V.
Box 867
NL-7600 AW ALMELO
The Netherlands
Tel. +31 546 588 666
Fax. +31 546 588 602

Ovako Hallstahammar AB
Box 505
SE-734 27 HALLSTAHAMMAR
Sweden
Tel. +46 220 23 000
Fax. +46 220 10 207

Ovako Redon SAS
Avenue des Nouies, B.P.10308
F-35603 REDON CEDEX
France
Tel. +33 299 714 168
Fax. +33 299 721 520

Ovako Mora AB
Box 421
SE-792 27 MORA
Sweden
Tel. +46 250 28 400
Fax. +46 250 28 420

Ovako Molinella S.p.A.
Via F.Turati, 11
I-40062 MOLINELLA (BO)
Italy
Tel. +39 051 690 03 32
Fax. +39 051 880 482

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www.ovako.com