

CARBON HOLLOW BAR

2C (254 to 610 mm OD)

Typical Analysis (Ave. values %)	C	Mn	Si	V	S	P
	0.22	1.60	0.35	0.12	0.03	0.03
NEAREST STANDARD	DIN		UNS		ASTM	
	1.5217 20MnV6		K03013		A381	

DESCRIPTION	2C Carbon Hollow Bar. High yield strength aluminium treated fine grained, low alloy calcium treated steels, with improved machinability and welding characteristics.
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APPLICATIONS	All forms of mechanical equipment, such as hydraulic cylinders, gear wheels, shafts, axles, stuffing boxes, lock nuts , spindles, drill jigs, rolls etc.
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MECHANICAL PROPERTIES (as supplied)	Tensile strength	560-750 MPa
	Yeild strength	390 MPa Minimum
	Elong	17%
	Hardness	200-240 HB

TOLERANCES	Outside Diameter	<75 mm +1.00 mm -0 75-100 + 1.20 mm -0 >100 mm + 1.40 mm -0
	Wall	Minimum thickness not more than 5% below nominal thickness
	Straightness	1 in 1000 measured in total length.

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PHYSICAL PROPERTIES	Density (kg/dm ³)	7.85
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HEAT TREATMENT	Normalize	880-900°C. Air cool.
	Anneal	650-700°C. Cool slowly in controlled furnace.
	Carburize	900-950°C. Furnace or Air cool
	Core Refine	840°C. Water quench.
	Harden	800°C Water quench.
	Temper	180-210°C air cool

WELDING	Parts should be welded before Carburizing and Hardening. Preheat to 250-350°C. Filler metals:-Bohler FOX EV63 electrodes.
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SIZE RANGE	2C Carbon Hollow bar	254 mm OD x 154 mm ID to 610 mm OD x 490 mm ID
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Carbon Hollow 2C					
SIZE RANGE	254x154	273x248	340x215	406x306	457x377
	254x174	292x165	344x273	406x316	508x368
	254x182	298x198	356x236	406x326	508x368
	254x204	298x218	356x256	406x346	508x388
	267x187	298x228	356x276	406x356	508x408
	273x173	298x238	356x286	419x299	510x410
	273x183	298x248	356x296	419x309	585x401
	273x193	298x258	356x306	419x319	610x490
	273x201	324x224	368x248	430x310	610x510
	273x209	324x244	368x258	457x317	
	273x213	324x264	368x268	457x327	
	273x223	324x274	406x286	457x357	

Sizes normally stocked in Australia. Some branches may not hold the entire range.
Other sizes available on request

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