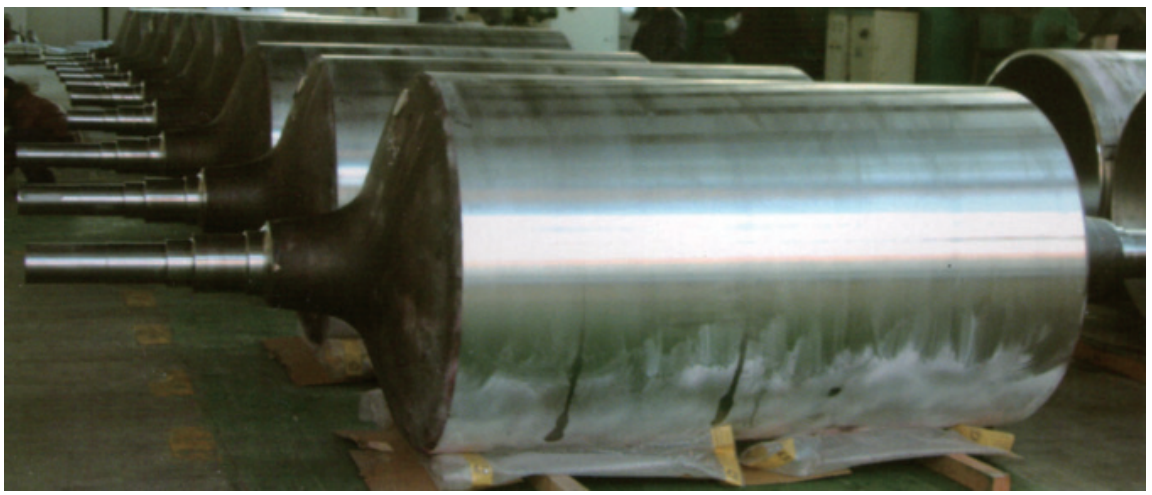
HOTION

HOTION HEARTH ROLLERS

Hearth Rollers

---Keeping Your Annealing Furnace with High Work Efficiency.



Hearth (Furnace) rollers are the most important spare parts in the annealing furnace. Since each annealing furnace needs many hearth rollers. So the working life of hearth rollers are very important for annealing furnace opeartion.

As hearth rollers should bear the temperature more than 800℃ in the annealing furnace, the material of hearth rollers should have high temperature resistance and oxidation resistance. So the material of roll barrel should use high alloy metal with the temperature resistance and wear resistance.

Hearth rollers are consist of roll barrel and two roll neck parts. Roll barrel is produced by centrifuge casting. After casting, roll barrel and roll neck are connected by welding.

The main material of our hearth rollers as below: GX40Cr28Ni48W5, GX40Cr25Ni20+304, GX25Cr18Ni9+35#, GX10Cr20Ni32Nb+GX40Cr20Ni25, GX25Cr18Ni9+25CrMo4, GX40Cr25Ni12+304, GX10Cr20Ni10Nb.

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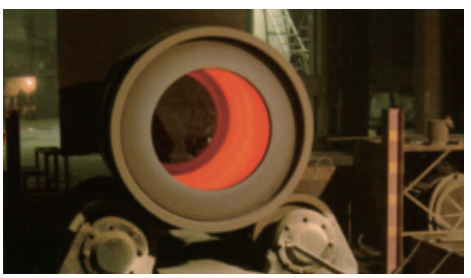
SMELTING FOUNDRY

1. The centrifuge spray paint
2. Check the temperature of molten steel
3. Casting
4. Centrifuge high-speed operation
5. Blank out of the mold

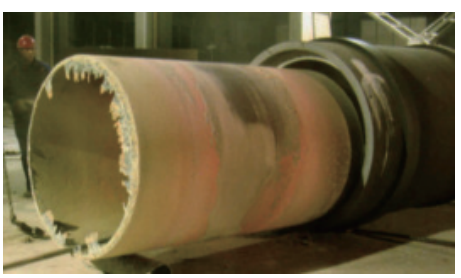
1 The centrifuge spray paint

2 Check the temperature of molten steel

3 Casting



4 Centrifuge high-speed operation



5 Blank out of the mold

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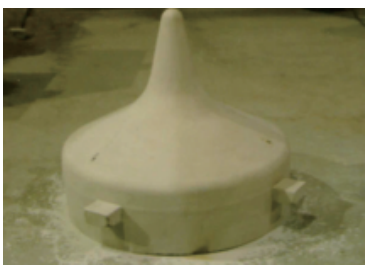
CASTING ROLL NECK PART



1 Mud core roll neck part

2 Steel mold roll neck part

3 Close box roll neck part

4 The molten steel into the mold

5 Casting complete

6 Roll neck part out of the box

7

Semi-finished roll neck part

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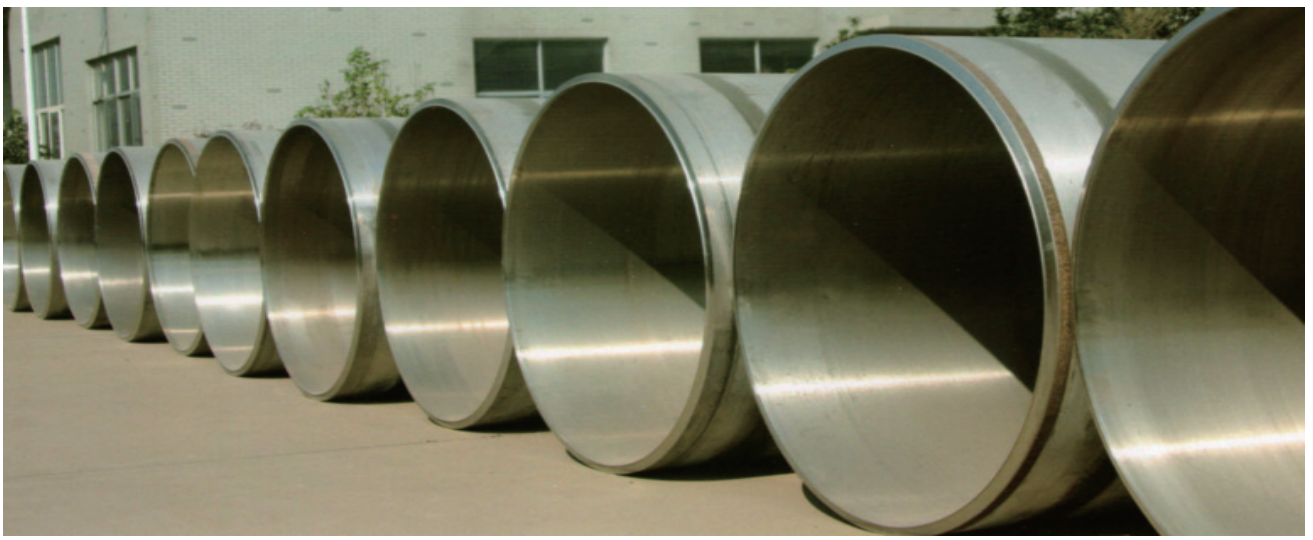
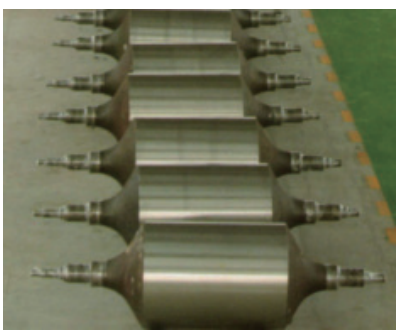
HEARTH ROLL



1 Finished barrel

2 Hearth roll welding

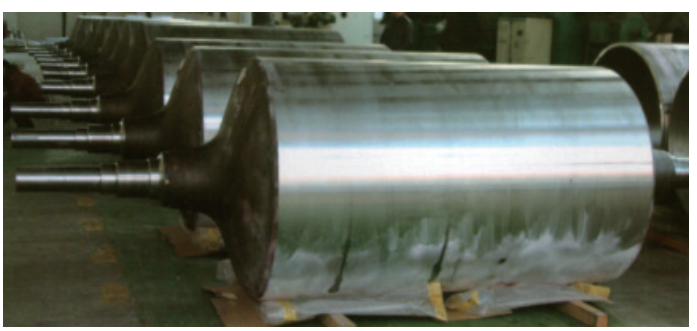
3 6-1000 Hearth roll



4 6-1200 Hearth roll

5

312 units



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TESTING EQUIPMENT

1 Direct reading spectrometer

2 Dynamic balancing machine

3 Thickness gauge

4 Test 1300mm roll profile

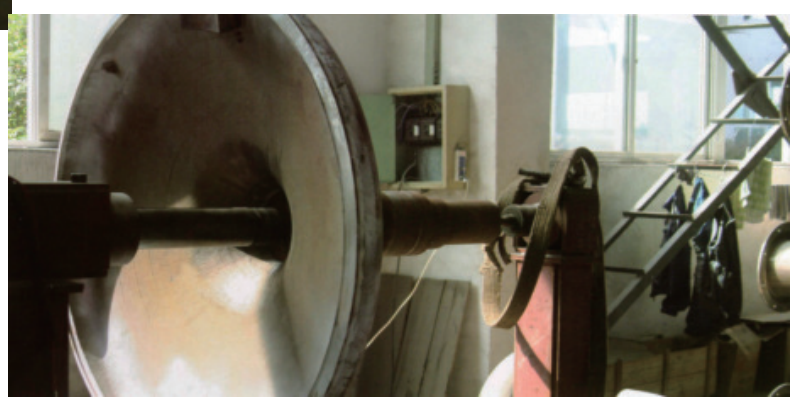
5 X-ray detection machine

6

Tensile Test

7

Neck part static balancing



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