

# CASE STUDY 108

## (HISALT HCSW FOR SHEET PATENTING APPLICATION)



### PROFILE OF COMPANY:

Manufacturer of cold rolling, medium carbon steel & high carbon steel in Gujarat.



### TRIAL CRITERIA

Quenchant Hisalt HCSW to replace lead bath in sheet patenting application.

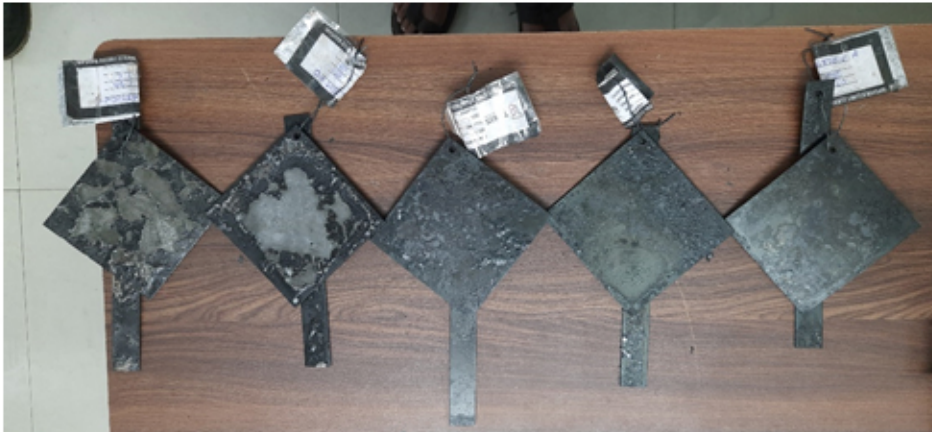


### OPERATING/ APPLICATION DETAILS :

1. Quenchant Selected: Hisalt HCSW
2. Hardening Temperature: 930 °C
3. Soaking Time: 5 Minutes
4. Quenchant Temperature: 500-550 °C
5. Agitation: Nil
6. Material: C80
7. Quenchant volume: 100 Liter
8. Quenching Time: 1 Minutes
9. Microstructure requirement: Banite
10. Hardness required: 35 HRc Min
11. Other requirement: - No crack



### COMPONENT DETAILS



## TRIAL CONCLUSION

Coil No.	Hardening Temp °C	Soaking Time	Salt Temp. °C	Quench Time	Salt Used	Remark Tensile and Micro Result
48505-2-A	900	5 Min.	500	1 Min	Hisalt HCSW	OK
48505-2-B	900	5 Min.	525	1 Min	Hisalt HCSW	OK
48505-2-C	900	5 Min.	550	1 Min	Hisalt HCSW	OK

(Lead bath successfully replaced with HISALT HCSW)

### BENEFITS:



Environment friendly



Cost Economical



No Toxic Fumes