



TECHNICAL SHEET



COLD DRAWN HEXAGONAL BARS

Definition

Cold drawn hexagonal bars are a cold worked product without metal removal, therefore it can show some surface defect. Sizes up to 24 are drawn by wire, the bigger sizes are hot rolled in bars and drawn bar to bar.

Steel grade : 303/1 – F304 – F304L – F316 – F316L – 321/3 – 316T/1 – 430F/3 – 416/1

Specification : CASE : EN 10088/3 – EN 10272 – PED 97/23/CE – ASTM

CASDW2 : ADW2 – ADW10 – AD 2000

Size

6 – 8 – 10 – 12 – 13 – 14 – 17 – 19 – 22 – 24 – 27 – 30 – 32 – 36 – 41 – 46 – 50 – 55 – 60 – 65

Size tolerance

ISO h 11 – DIN 176. Other tolerance available on request

Lengths and tolerances

<i>Size **</i>	<i>Length</i>	<i>Tolerance STD ***</i>	<i>Tolerance Extra STD</i>	<i>Short bars</i>
6 ÷ 24	3 m	+50 – 0	+25 – 0	5%
27 ÷ 65	3-4-6 m	+100 – 0	+50 – 0	5%

** Size in Inches are available on request

*** Available ± 25 mm

Other characteristics

	<i>Twist</i>	<i>Straightness</i>	<i>Ends</i>
STD	4° / m	1 mm ‰	1 Chamfer 45° 1 Square sheared
Extra STD	4° / m	1 mm ‰	1 Chamfer 45° 1 Chamfer 30°

Surface defects

<i>Size</i>	<i>Depth of the defect</i>	<i>Corner radius</i>
≤ 15	Max 0,30 mm	Max 0,3 mm
>15 ≤ 65	Max 0,02 mm x d	Max 0,5 mm

Defects such as pitting and drawing scratching are not included.

Surface defects controlled by Defectomat.

Packaging

Bundle Kg 500 min size up to 24 – Kg 1000 size > 24 mm
Plastic cardboard and containing caps at the ends COGNE code ES2
Wooden box if required COGNE code ES3