



**WAEZHOLZ**  
BRASMETAL

# Cold rolled steel for stone gang saws

Our hardened and tempered steel strip equipped with a ground surface and specially treated edges guarantees the best performance for your saw manufacturing process and application.

Thanks to consistently tight tolerances and homogenous material properties our steel strip is especially suited for cutting marble. For the production of gang saws Waelzholz offers particularly thin steel strip. The advantage for our customers: the reduction of their total manufacturing costs by gaining an additional m<sup>2</sup> per marble block.

Benefits for your saw manufacturing and application:

- High wear resistance for a longer service life
- Special edge treatment to facilitate the adhesion of the diamond segments.
- Optimum weldability and brazability
- Minimal dimensional deviations supporting a homogeneous cutting performance

# Stone saw steel specification

## Material Properties

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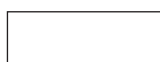
### Standard chemical analyses

Grades	C [%]	Si [%]	Mn [%]	P [%]	S [%]	Cr [%]	Ni [%]
C75S	0.70–0.80	0.15–0.35	0.60–0.90	0.025 max.	0.025 max.	0.40 max.	0.40 max.
75Ni8	0.72–0.78	0.15–0.35	0.30–0.50	0.025 max.	0.025 max.	0.15 max.	1.80–2.10

Other chemical analyses are available upon request.

### Edges

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90° mechanically squared edges

### Standard Hardness

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43 ± 2 HRC

Other hardness levels are available upon request.

### Surface

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White ground surface

## Dimensions and Tolerances

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### Standard dimensions

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[mm]
1.75 x 180
2.00 x 180
2.50 x 180
3.00 x 180
3.50 x 180

Other dimensions are available on request depending on order quantities.

### Thickness tolerances

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[mm]	[mm]
1.50 < 2.00	± 0.030
2.00 < 2.50	± 0.050
2.50 < 3.50	± 0.056
3.50 < 4.00	± 0.063

Special tolerances are available upon request.

### Straightness

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[mm]	[mm]
< 2.00	max. 1.00 in 3 m
≥ 2.00	max. 2.30 in 3 m

Special tolerances are available upon request.

### Transversal flatness

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<0.05 % of strip width

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## Delivery form

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Material is supplied in coil format with an internal diameter of 800 mm and maximal external diameter of 1,500 mm or cut in to length according customers specification.