

This information is based on our present state of knowledge and is intended to provide general notes on our products and their uses. It should not therefore be construed as a warranty of specific properties of the products described or a warranty for fitness for a particular purpose.

Classified according to EU Directive 1999/45/EC
For further information see our "Material Safety Data Sheets".

Edition 1, 11.2007

The latest revised edition of this brochure is the English version,
which is always published on our web site www.uddeholm.com



SS-EN ISO 9001
SS-EN ISO 14001

UDDEHOLM RAMAX HH

Uddeholm Ramax HH provides several benefits:

- The product offers uniform hardness in all dimensions combined with excellent indentation resistance
- It is a corrosion resistant grade which prevents clogging of the water cooling channels that could otherwise affect cycle time consistency.

Uddeholm Ramax HH is supplied at a hardness level that is higher than other corrosion resistant prehardened grades, resulting in a more durable mould and a longer life time.

By combining Uddeholm Ramax HH with one of our other products within the Stainless Concept, you can create a completely stainless mould.

Uddeholm Ramax HH is a part of the Uddeholm Stainless Concept.

General

Uddeholm Ramax HH is a chromium alloyed stainless holder steel, which is supplied in the hardened and tempered condition.

Uddeholm Ramax HH is characterized by

- Good corrosion resistance
- Uniform hardness even in large dimensions
- Good indentation resistance
- Good machinability

These properties combine to give a steel with outstanding production performance. The practical benefits of **good corrosion resistance** can be summarized as follows:

- Lower mould maintenance cost
- Lower production costs since water cooling channels are unaffected by corrosion, ensuring consistent cycle time

The practical benefit of the **relatively high hardness** for a prehardened grade can be summarized as:

- less indentations
- less wear

leading to lower mould maintenance cost and longer life.

Typical analysis %	Cr-Ni-Mo-V alloyed +Sulphur
Delivery condition	Hardened and tempered to ~ 340 HB
Colour code	Black/brown with white line across

Applications

- Holders/bolsters for plastic moulds.
- Plastic and rubber moulds with low requirements on polishability
- Dies for plastic extrusion
- Constructional parts

Properties

Physical data

Hardened and tempered to ~340 HB. Data at room and elevated temperatures.

Temperature	20°C (68°F)	200°C (390°F)
Density kg/m ³ lbs/in ³	7 700 0,280	– –
Modulus of elasticity Mpa psi	215 000 31,2 x 10 ⁶	205 000 29,7 x 10 ⁶
Coefficient of thermal expansion per °C from 20°C per °F from 68°F	– –	10,8 x 10 ⁻⁶ 6,0 x 10 ⁻⁶
Thermal conductivity* W/m °C Btu in/ft ² h °F	– –	24 166
Specific heat capacity J/kg °C Btu/lb°F	460 0,110	–

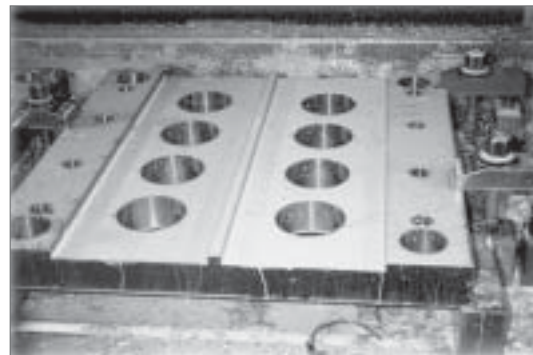
* Thermal conductivity is very difficult to measure. The scatter can be as high as ±15%

Tensile strength

Approximate values. Samples were taken from a bar 255 x 60 mm (10 x 2,4") in length direction. Hardness: ~340 HB.

Testing temperature	20°C (68°F)	200°C (390°F)
Tensile strength R _m , MPa psi	1 140 1,65 x 10 ⁵	1 020 1,48 x 10 ⁵
Yield strength R _{p0,2} MPa psi	990 1,44 x 10 ⁵	920 1,33 x 10 ⁵
Reduction of area Z, %	46	48
Elongation A ₅ , %	12	10

Note: The high sulphur content gives lower mechanical properties in the transverse compared with the longitudinal direction.



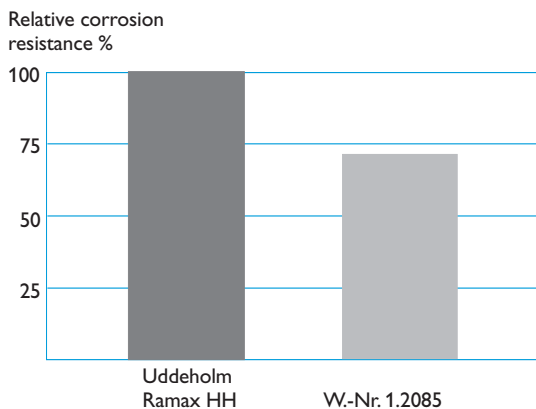
Holder plate.

Corrosion resistance

Holders made from Uddeholm Ramax HH will have good resistance to corrosion caused by humid working and storage conditions and when moulding corrosive plastics under normal production conditions

In the graph below values from potentiodynamic polarization curves has been evaluated to show the difference in general corrosion resistance between Uddeholm Ramax HH and W.-Nr.1.2085.

Specimen size: 20 x 15 x 3 mm (0,8 x 0,6 x 0,12")



Heat treatment

Uddeholm Ramax HH is intended for use in the as-delivered condition i.e. hardened and tempered to ~340 HB.

When the steel is to be heat treated to higher hardness, instructions below are to be followed.

However, note that an increased hardness yields a lower toughness.

Soft annealing

Protect the steel and heat through to 740°C (1365°F). Cool at 15°C (30°F) per hour to 550°C (1020°F), then freely in air.

Stress relieving

After rough machining the tool should be heated through to max. 530°C (985°F), holding time 2 hours, then cool freely in air.

Hardening

Note: The steel should be annealed before hardening.

Preheating temperature: 500–600°C (930–1110°F).

Austenitizing temperature: 980–1020°C (1795–1870°F).

The steel should be heated through to the austenitizing temperature and held at temperature for 30 minutes.

Protect the tool against decarburization and oxidation during the hardening process.

Quenching media

- Oil
- Fluidized bed or salt bath at 250–550°C (480–1020°F), then cool in air blast
- Vacuum with sufficient positive pressure
- High speed gas/circulating atmosphere

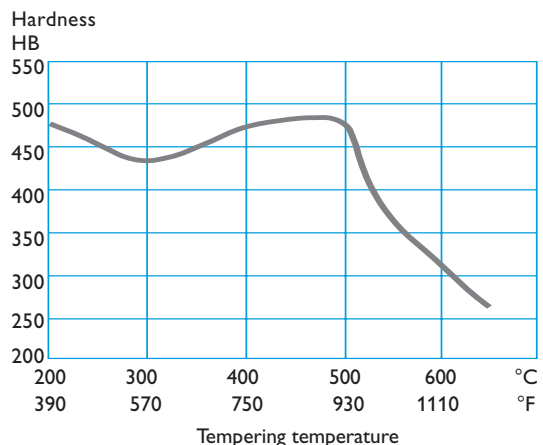
In order to obtain the optimum properties, the cooling rate should be as fast as possible within acceptable distortion limits. Temper the tool as soon as its temperature reaches 50–70°C (120–160°F).

Tempering

Choose the tempering temperature according to the hardness required by reference to the tempering graph. Temper twice with intermediate cooling to room temperature. Lowest tempering temperature 250°C (480°F). Holding time at temperature minimum 2 hours.

Austenitizing temperature: 1000°C (1830°F), 30 min.

Holding time: 2 + 2h



Machining recommendations

The cutting data below are to be considered as guiding values which must be adapted to existing local conditions. More information can be found in the Uddeholm publication "Cutting data recommendations".

Turning

Cutting data parameters	Turning with carbide		Turning with high speed steel
	Rough turning	Fine turning	Fine turning
Cutting speed (v_c) m/min. f.p.m.	110–160 360–525	160–210 525–690	18–23 59–75
Feed (f) mm/r i.p.r.	0,2–0,4 0,008–0,016	0,05–0,2 0,002–0,008	0,05–0,3 0,002–0,01
Depth of cut (a_p) mm inch	2–4 0,08–0,16	0,5–2 0,02–0,08	0,5–3 0,02–0,12
Carbide designation ISO US	P20–P30 C6–C5 Coated carbide	P10 C7 Coated carbide or cermet	–

Milling

FACE AND SQUARE SHOULDER MILLING

Cutting data parameters	Milling with carbide	
	Rough milling	Fine milling
Cutting speed (v_c) m/min f.p.m.	110–160 360–525	160–200 525–656
Feed (f_z) mm/tooth inch/tooth	0,2–0,4 0,008–0,016	0,1–0,2 0,004–0,008
Depth of cut (a_p) mm inch	2–5 0,08–0,2	≤ 2 $\leq 0,08$
Carbide designation ISO US	P20–P40 C6–C5 Coated carbide	P10–P20 C6–C7 Coated carbide or cermet

END MILLING

Cutting data parameters	Type of milling		
	Solid carbide	Carbide indexable insert	High speed steel
Cutting speed (v_c) m/min f.p.m.	70–100 230–328	100–140 328–460	30–35 ¹⁾ 98–115 ¹⁾
Feed (f_z) mm/tooth inch/tooth	0,006–0,20 ²⁾ 0,0002–0,008 ²⁾	0,06–0,20 ²⁾ 0,002–0,008 ²⁾	0,01–0,35 ²⁾ 0,0004–0,014 ²⁾
Carbide designation ISO US	–	P15–P40 C6–C5	–

¹⁾ For coated HSS end mill $v_c = 50–55$ m/min. (164–180 f.p.m.)

²⁾ Depending on radial depth of cut and cutter diameter

Drilling

HIGH SPEED STEEL TWIST DRILL

Drill diameter		Cutting speed (v_c)		Feed (f)	
inch	mm	f.p.m.	m/min	i.p.r.	mm/r
–3/16	≤ 5	46–52*	14–16*	0,002–0,004	0,05–0,10
3/16–3/8	5–10	46–52*	14–16*	0,004–0,008	0,10–0,20
3/8–5/8	10–15	46–52*	14–16*	0,008–0,010	0,20–0,25
5/8–3/4	15–20	46–52*	14–16*	0,010–0,012	0,25–0,30

* For coated HSS drill $v_c = 24–26$ m/min. (79–85 f.p.m.)

CARBIDE DRILL

Cutting data parameters	Type of drill		
	Indexable insert	Solid carbide	Carbide tipped
Cutting speed (v_c) m/min f.p.m.	180–200 590–656	90–110 295–360	60–90 197–295
Feed (f) mm/r i.p.r.	0,05–0,15 ¹⁾ 0,002–0,006 ¹⁾	0,10–0,25 ¹⁾ 0,004–0,01 ¹⁾	0,15–0,25 ¹⁾ 0,006–0,01 ¹⁾

¹⁾ Depending on drill diameter



Machinability is a critical property during manufacturing of holder plates.

Grinding

A general grinding wheel recommendation is given below. More information can be found in the Uddeholm publication “Grinding of Tool Steel”.

Type of grinding	Wheel recommendation
Face grinding straight wheel	A 46 HV
Face grinding segments	A 36 GV
Cylindrical grinding	A 60 KV
Internal grinding	A 60 JV
Profile grinding	A 120 JV

Welding

Good results when welding tool steel can be achieved if proper precautions are taken during welding (elevated working temperature, joint preparation, choice of consumables and welding procedure).

Welding method	TIG (GTAW)		MMA (SMAW)
	Working temperature	200–250°C (390–480°F)	
Welding consumables	STAVAX TIG-WELD	Austenitic stainless steel Type ER312	Austenitic stainless steel Type ER312
Hardness after welding	54–56 HRC	28–30 HRC	28–30 HRC
Hardness after tempering 2 x 2h at 530°C (990°F)	50–52 HRC	28–30 HRC	28–30 HRC
	1 x 2h at 600°C (1220°F)	41–43 HRC	–

A tempering temperature higher than 530°C (990°F) causes a reduction of the base material hardness. Tempering at 600°C (1220°F) reduce the hardness of the base material with 2–3 HRC.



Uddeholm Ramax HH has a high sulphur content, which means an increased risk for hot cracking during welding. To minimize the risk, keep the dilution as low as possible.

Further information is given in the Uddeholm brochure “Welding of Tool Steel”.

Further information

Please contact your local Uddeholm office for further information on the selection, heat treatment and application of Uddeholm tool steels, including the publication “Steels for Moulds”.

Europe

Austria

Representative office
UDDEHOLM
Albstraße 10
DE-73765 Neuhausen
Telephone: +49 7158 9865-0
www.uddeholm.de

Belgium

UDDEHOLM
Europark Oost 7
B-9100 Sint-Niklaas
Telephone: +32 3 780 56 20
www.uddeholm.be

Croatia

BÖHLER UDDEHOLM Zagreb
d.o.o za trgovinu
Zitnjak b.b
10000 Zagreb
Telephone: +385 1 2459 301
Telefax: +385 1 2406 790
www.bohler-uddeholm.hr

Czech Republic

BÖHLER UDDEHOLM CZ s.r.o.
Division Uddeholm
U Silnice 949
161 00 Praha 6, Ruzyně
Telephone: +420 233 029 850,8
www.uddeholm.cz

Denmark

UDDEHOLM A/S
Kokmose 8, Bramdrupdam
DK-6000 Kolding
Telephone: +45 75 51 70 66
www.uddeholm.dk

Estonia

UDDEHOLM TOOLING AB
Silikatsiidi 7
EE-11216 Tallinn
Telephone: +372 655 9180
www.uddeholm.ee

Finland

OY UDDEHOLM AB
Ritakuja 1, PL 57
FI-01741 VANTAA
Telephone: +358 9 290 490
www.uddeholm.fi

France

Head office
UDDEHOLM
Z.I. de Mitry-Compans, 12 rue Mercier,
FR-77297 Mitry Mory Cedex
Telephone: +33 (0)1 60 93 80 10
www.uddeholm.fr

Branch offices

UDDEHOLM S.A.
77bis, rue de Vesoul
La Nef aux Métiers
FR-25000 Besançon
Telephone: +33 (0)381 53 12 19

LE POINT ACIERS
UDDEHOLM - Aciers à outils
Z.I. du Recou, Avenue de Champlevert
FR-69520 GRIGNY
Telephone: +33 (0)4 72 49 95 61

LE POINT ACIERS
UDDEHOLM - Aciers à outils
Z.I. Nord 27, rue François Rochema
FR-01100 OYONNAX
Telephone: +33 (0)4 74 73 48 66

Germany

Head office
UDDEHOLM
Hansaallee 321
DE-40549 Düsseldorf
Telephone: +49 211 5351-0
www.uddeholm.de

Branch offices

UDDEHOLM
Falkenstrasse 21
DE-65812 Bad Soden/TS
Telephone: +49 6196 6596-0

UDDEHOLM
Albstraße 10
DE-73765 Neuhausen
Telephone: +49 7158 9865-0

UDDEHOLM
Friederikenstraße 14b
DE-06493 Harzgerode
Telephone: +49 39484 727 267

Great Britain

UDDEHOLM DIVISION
BOHLER-UDDEHOLM (UK) LIMITED
European Business Park
Taylors Lane, Oldbury
GB-West Midlands B69 2BN
Telephone: +44 121 552 5511
Telefax: +44 121 544 2911
www.uddeholm.co.uk

Greece

STASSINOPOULOS-UDDEHOLM
STEEL TRADING S.A.
20, Athinon Street
GR-Piraeus 18540
Telephone: +30 210 4172 109
www.uddeholm.gr

SKLERO S.A.
Heat Treatment and Trading of Steel
Uddeholm Tool Steels
Industrial Area of Thessaloniki
P.O. Box 1123
GR-57022 Sindos, Thessaloniki
Telephone: +30 2310 79 76 46
www.sklero.gr

Hungary

UDDEHOLM TOOLING/BOK
Dunaharaszti, Jedlik Ányos út 25
HU-2331 Dunaharaszti 1. Pf. 110
Telephone/fax: +36 24 492 690
www.uddeholm.hu

Ireland

Head office:
UDDEHOLM DIVISION
BOHLER-UDDEHOLM (UK) LIMITED
European Business Park
Taylors Lane, Oldbury
UK-West Midlands B69 2BN
Telephone: +44 121 552 5511
Telefax: +44 121 544 2911
www.uddeholm.co.uk
Dublin:
Telephone: +353 1845 1401

Italy

UDDEHOLM
Divisione della Bohler Uddeholm
Italia S.p.A.
Via Palizzi, 90
IT-20157 Milano
Telephone: +39 02 39 49 211
www.uddeholm.it

Latvia

UDDEHOLM TOOLING LATVIA SIA
Piedrujas Street 7
LV-1035 Riga
Telephone: +371 7 702133
Telefax: +371 7 185079

Lithuania

UDDEHOLM TOOLING AB
BE PLIENAS IR METALAI
T. Masiulio 18B
LT-52459 Kaunas
Telephone: +370 37 370613, -669
www.besteel.lt

The Netherlands

UDDEHOLM
Isolatorweg 30
NL-1014 AS Amsterdam
Telephone: +31 20 581 71 11
www.uddeholm.nl

Norway

UDDEHOLM A/S
Jernkroken 18
Postboks 85, Kalbakken
NO-0902 Oslo
Telephone: +47 22 91 80 00
www.uddeholm.no

Poland

BOHLER UDDEHOLM POLSKA
Sp. z o.o./Co. Ltd.
ul. Kolejowa 291, Dziekanów Polski,
PL-05-092 Lomianki
Telephone: +48 22 429 2260, -203, -204
www.uddeholm.pl

Portugal

F RAMADA Açoes e Industrias S.A.
P.O. Box 10
PT-3881 Ovar Codex
Telephone: +351 256 580580
www.ramada.pt

Romania

BÖHLER-UDDEHOLM Romania SRL
Atomistilor Str. No 96-102
077125 - com. Magurele, Jud. Ilfov.
Telephone: +40 214 575007
Telefax: +40 214 574212

Russia

UDDEHOLM TOOLING CIS
9A, Lipovaya Alleya, Office 509
RU-197183 Saint Petersburg
Telephone: +7 812 6006194
www.uddeholm.ru

Slovakia

Bohler-Uddeholm Slovakia s.r.o.
divizia UDDEHOLM
Čsl.Armády 5622/5
SK-036 01 Martin
Telephone: +421 (0)434 212 030
www.uddeholm.sk

Slovenia

Representative office
UDDEHOLM
Divisione della Bohler Uddeholm
Italia S.p.A.
Via Palizzi, 90
IT-20157 Milano
Telephone: +39 02 39 49 211
www.uddeholm.it

Spain

Head office
UDDEHOLM
Guiñfó 690-692
ES-08918 Badalona, Barcelona
Telephone: +34 93 460 1227
www.acerosuddeholm.com

Branch office

UDDEHOLM
Barrio San Martín de Arteaga,132
Pol.Ind. Torrelarragoiti
ES-48170 Zamudio (Bizkaia)
Telephone: +34 94 452 13 03

Sweden

Head office
UDDEHOLM TOOLING SVENSKA AB
Aminogatan 25
SE-431 53 Mölndal
Telephone: +46 31 67 98 50
www.uddeholm.se

Branch offices

UDDEHOLM TOOLING SVENSKA AB
Box 45
SE-334 21 Anderstorp
Telephone: +46 371 160 15

UDDEHOLM TOOLING SVENSKA AB
Box 148
SE-631 03 Eskilstuna
Telephone: +46 16 15 79 00

UDDEHOLM TOOLING SVENSKA AB
Aminogatan 25
SE-431 53 Mölndal
Telephone: +46 31 67 98 70

UDDEHOLM TOOLING SVENSKA AB
Nya Tanneforsvägen 96
SE-582 42 Linköping
Telephone: +46 13 15 19 90

UDDEHOLM TOOLING SVENSKA AB
Derbyvägen 22
SE-212 35 Malmö
Telephone: +46 40 22 32 05

UDDEHOLM TOOLING SVENSKA AB
Honnörsgratan 16A
SE-352 36 Växjö
Telephone: +46 470 457 90

Switzerland

HERTSCH & CIE AG
General Wille Strasse 19
CH-8027 Zürich
Telephone: +41 44 208 16 66
www.hertsch.ch

Turkey

Head office
ASSAB Korkmaz Celik A.S.
Organize Sanayi Bölgesi
2. Cadde No: 26 Y. Dudullu
34776 Umraniye
Istanbul Turkey
Telephone: +90 216 420 1926
www.assabkorkmaz.com

America

Argentina

ACEROS BOEHLER UDDEHOLM S.A
Mozart 40
1619-Centro Industrial Garin
Garin-Prov.
AR-Buenos Aires
Telephone: +54 332 7444 440
www.uddeholm.com.ar

Brazil

AÇOS BOHLER-UDDEHOLM DO
BRASIL LTDA- DIV. UDDEHOLM
Estrada Yae Massumoto, 353
CEP 09842-160
BR-Sao Bernardo do Campo - SP Brazil
Telephone: +55 11 4393 4560, 4554
www.uddeholm.com.br

Canada

Head Office & Warehouse
UDDEHOLM
2595 Meadowvale Blvd.
Mississauga, ON L5N 7Y3
Telephone: +1 905 812 9440
www.bucanada.com

Branch Warehouses

UDDEHOLM
3521 Rue Ashby
St. Laurent, QC H4R 2K3
Telephone: +1 514 333 8000

UDDEHOLM

730 Eaton Way - Unit #10
New Westminster, BC V3M 6J9
Telephone: +1 604 525 3354

Heat Treating

THERMO-TECH
2645 Meadowvale Blvd.
Mississauga, ON L5N 7Y4
Telephone: +1 905 812 9440

Colombia

AXXECOL S.A.
Carrera 35 No 13-20
Apartado Aereo 80718
CO-Bogota 6
Telephone: +57 1 2010700
www.axxecol.com

ASTECO S.A.

Carrera 54 No 35-12
Apartado Aereo 663
CO-Medellin
Telephone: +57 4 2320122
www.asteco.com

Dominican Republic

RAMCA, C. POR A.
P-2289
P.O. Box 025650
Miami, Fl. 33102
Telephone: +1 809 682 4011
domrep@assab.com

Ecuador

IVAN BOHMAN C.A.
Apartado 1317
Km 6 1/2 Via a Daule
Guayaquil
Telephone: +593 42 254111

IVAN BOHMAN C.A.

Casilla Postal 17-01370
Quito
Telephone: +593 2 2248001

El Salvador

ACAVISA DE C.V.
25a. Avenida Sur 463
zona 1
Apartado Postal 439
SV-San Salvador
Telephone: +503 22 711700
www.acavisa.com

Guatemala

IMPORTADORA ESCANDINAVA
Apartado postal 11C
GT-Guatemala City, Guatemala
Telephone: +502 23 659270
guatemala@assab.com

Mexico

Head office
ACEROS BOHLER UDDEHOLM S.A.
de C.V.
Calle Ocho No 2, Letra "C"
Fraccionamiento Industrial Alce Blanco
C.P. 52787 Naucalpan de Juarez
MX-Estado de Mexico
Telephone: +52 55 9172 0242
www.bu-mexico.com

Branch office

BOHLER-UDDEHOLM MONTERREY,
NUEVO LEON
Lerdo de Tejada No.542
Colonia Las Villas
MX-66420 San Nicolas de Los Garza,
N.L.
Telephone: +52 81 83 525239

Peru

C.I.P.E.S.A.
Av. Oscar R. Benavides
(ante Colonial) No. 2066
PE-Lima 1
Telephone: +51 1 336 8673
peru@assab.com

U.S.A.

Head office and Warehouse
BOHLER-UDDEHOLM
CORPORATION
2505 Millennium Drive
Elgin IL 60124
Telephone: 1-630-883-3000 or
1-800-652-2520
Sales phone: 1-800-638-2520
www.bucorp.com

Region East Warehouse

UDDEHOLM
220 Cherry Street
Shrewsbury MA 01545

Region Central Warehouse

UDDEHOLM
548 Clayton Ct.
Wood Dale IL 60191

Region West Warehouse

UDDEHOLM
9331 Santa Fe Springs Road
Santa Fe Springs, CA 90670

Venezuela

PRODUCTOS HUMAR C.A.
Av. Bolivar, Zona Industrial
La Trinidad
Edificio. Distribuidora Agrofor, C.A.
Piso 3, VE-Caracas 1080
Telephone: +58 212 942 1994 or
+58 212 915 7073
humar@assab.com

Other Countries in America

ASSAB INTERNATIONAL AB
Box 42
SE-171 11 Solna, Sweden
Telephone: +46 8 564 616 70
www.assab.se

Asia & Pacific

Australia

BOHLER UDDEHOLM Australia
129-135 McCredie Road
Guildford NSW 2161
Private Bag 14
AU-Sydney
Telephone: +61 2 9681 3100
www.buau.com.au

Bangladesh

ASSAB INTERNATIONAL AB
P.O. Box 17595
Jebel Ali
AE-Dubai
Telephone: +971 488 12165
www.assab.se

North China

Head office
ASSAB Tooling (Beijing) Co Ltd
No.10A Rong Jing Dong Jie
Beijing Economic Development Area
Beijing 100176, China
Telephone: +86 10 6786 5588
www.assabsteels.com

Branch offices

ASSAB Tooling (Beijing) Ltd
Dalian Branch
8 Huanghai Street, Haerbin Road
Economic & Technical Develop. District
Dalian 116600, China
Telephone: +86 411 8761 8080

ASSAB Qingdao Office
Room 2521, Kexin Mansion
No. 228 Liaoning Road, Shibei District
Qingdao 266012, China
Telephone: +86 532 8382 0930

ASSAB Tianjin Office
No.12 Puwangli Wanda Xincheng
Xinyibai Road, Beichen District
Tianjin 300402, China
Telephone: +86 22 2672 0006

Central China

Head office
ASSAB Tooling Technology
(Shanghai) Co Ltd
No. 4088 Humin Road
Xinzhuang Industrial Zone
Shanghai 201108, China
Telephone: +86 21 5442 2345
www.assabsteels.com

Branch offices

ASSAB Tooling Technology
(Ningbo) Co Ltd
No. 218 Longjiaoshan Road
Vehicle Part Industrial Park
Ningbo Economic & Technical Dev.
Zone
Ningbo 315806, China
Telephone: +86 574 8680 7188

ASSAB Tooling Technology
(Chongqing) Co Ltd
Plant C, Automotive Industrial IPark
Chongqing Economic & Technological
Development Zone
Chongqing 401120, China
Telephone: +86 23 6745 5698

South China

Head office
ASSAB Steels (HK) Ltd
Room 1701-1706
Tower 2 Grand Central Plaza
138 Shatin Rural Committee Road
Shatin NT - Hong Kong
Telephone: +852 2487 1991
www.assabsteels.com

Branch offices

ASSAB Tooling (Dongguan) Co Ltd
Northern District
Song Shan Lake Science & Technology
Industrial Park
Dongguan 523808, China
Telephone: +86 769 2289 7888
www.assabsteels.com

ASSAB Tooling (Xiamen) Co Ltd
First Floor Universal Workshop
No. 30 Huli Zone
Xiamen 361006, China
Telephone: +86 592 562 4678

Hong Kong

ASSAB Steels (HK) Ltd
Room 1701-1706
Grand Central Plaza, Tower 2
138 Shatin Rural Committee Road
Shatin NT, Hong Kong
Telephone: +852 2487 1991
www.assabsteels.com

India

ASSAB Sripad Steels LTD
T 303 D.A.V. Complex
Mayur Vihar Ph I Extension
IN-Delhi-110 091
Telephone: +91 11 2271 2736
www.assabsripadsteels.com

ASSAB Sripad Steels LTD
709, Swastik Chambers
Sion-Trombay Road
Chembur
IN-Mumbai-400 071
Telephone: +91 22 2522-7110, -8133

ASSAB Sripad Steels LTD
Padmalaya Towers
Janaki Avenue
M.R.C. Nagar
IN-Chennai-600 028
Telephone: +91 44 2495 2371

ASSAB Sripad Steels LTD
19X, D. P. P. Road
Naktola Post Office
IN-Kolkata-700 047
Telephone: +91 (33) 400 1645

ASSAB Sripad Steels LTD
Ground floor, Plot No 11-6-8
Opp IDPL Factory Out Gate
Balanagar
IN-Hyderabad-500 037
Telephone: +91 (40) 2377 8148

Indonesia

Head office
PT ASSAB Steels Indonesia
Jl. Rawagelam III No. 5
Kawasan Industri Pulogadung
Jakarta 13930, Indonesia
Telephone: +62 21 461 1314
www.assabsteels.com

Branch offices

SURABAYA BRANCH
Jl. Berbek Industri 1/23
Surabaya Industrial Estate, Rungkut
Surabaya 60293, East Java, Indonesia
Telephone: +62 31 843 2277

MEDAN BRANCH
Komplek Griya Riaturn Indah
Blok A No.138
Jl. T. Amir Hamzah
Halvetia Timur, Medan 20124
Telephone: +62 61 847 7935/6

BANDUNG BRANCH
Komp. Ruko Bumi Kencana
Jl. Titian Kencana Blok E
No.5 Bandung 40233
Telephone: +62 22 604 1364

TANGERANG BRANCH
Pusat Niaga Cibodas
Blok C No. 7 Tangerang
Telephone: +62 21 921 9596, 551 2732

SEMARANG BRANCH
Jl. Imam Bonjol No.155
R.208 Semarang 50124
Telephone: +62 358 8167

Iran

ASSAB INTERNATIONAL AB
P.O. Box 19395
IR-1517 TEHRAN
Telephone: +98 21 888 35392
www.assabiran.com

Israel

PACKER YADPAZ QUALITY
STEELS Ltd
P.O. Box 686
Ha-Yarkon St. 7, Industrial Zone
IL-81106 YAVNE
Telephone: +972 8 932 8182
www.packer.co.il

Japan

UDDEHOLM KK
Atago East Building
3-16-11 Nishi Shinbashi
Minato-ku, Tokyo 105-0003, Japan
Telephone: + 81 3 5473 4641
www.assabsteels.com

Jordan

ENGINEERING WAY Est.
P.O. Box 874
Abu Alanda
JO-AMMAN 11592
Telephone: +962 6 4161962
engineeringway@assab.com

Malaysia

Head office
ASSAB Steels (Malaysia) Sdn Bhd
Lot 19, Jalan Perusahaan 2
Batu Caves Industrial Estate
68100 Batu Caves
Selangor, Malaysia
Telephone: +60 3 6189 0022
www.assabsteels.com

Branch offices

BUTTERWORTH BRANCH
Plot 146a
Jalan Perindustrial Bukit Minyak 7
Kawasan Perindustrial Bukit Minyak
14000 Bukit Mertajam, SPT Penang
Telephone: +60 4 507 2020

JOHOR BRANCH

No. 8, Jalan Persiaran Teknologi
Taman Teknologi
81400 Senai
Johor DT, Malaysia
Telephone: +60 7 598 0011

New Zealand

VIKING STEELS
25 Beach Road, Otahuhu
P.O. Box 13-359, Onehunga
NZ-Auckland
Telephone: +64 9 270 1199
www.ssm.co.nz

Pakistan

ASSAB International AB
P.O. Box 17595
Jebel Ali
AE-Dubai
Telephone: +971 488 12165
www.assab.se

Philippines

ASSOCIATED SWEDISH STEELS
PHILS Inc.
No. 3 E. Rodriguez Jr., Avenue
Bagong Ilog, Pasig City
Philippines
Telephone: +632 671 1953/2048
www.assabsteels.com

Republic of Korea

Head office
ASSAB Steels (Korea) Co Ltd
116B-8L, 687-8, Kojan-dong
Namdong-ku
Incheon 405-310, Korea
Telephone: +82 32 821 4300
www.assabsteels.com

Branch offices

BUSAN BRANCH
14B-5L, 1483-9, Songjeong-dong
Kangseo-ku, Busan 618-270, Korea
Telephone: +82 51 831 3315

DAEGU BRANCH

Room 27, 7-Dong2 F
Industry Materials Bldg.1629
Sangyeog-Dong, Buk-Ku
Korea-Daegu 702-710
Telephone: +82 53 604 5133

Lebanon

WARDE STEEL & METALS SARL MET
Charles Helou Av, Warde Bldg
P.O. Box 165886
LB-Beirut
Telephone: +961 1 447228
lebanon@assab.com

Saudi Arabia

ASSAB INTERNATIONAL AB
P.O. Box 255092
SA-Riyadh 11353
Telephone: +966 1 4466542
saudiarabia@assab.com

Singapore

Head office Pacific
ASSAB Pacific Pte Ltd
171, Chin Swee Road
No. 07-02, SAN Centre
SG-Singapore 169877
Telephone: +65 6534 5600
www.assabsteels.com

Jurong

ASSAB Steels Singapore (Pte) Ltd
18, Penjuru Close
SG-608616 Singapore
Telephone: +65 6862 2200

Sri Lanka

GERMANIA COLOMBO PRIVATE Ltd.
451/A Kandy Road
LK-Kelaniya
Telephone: +94 11 2913556
www.iwsholdings.com

Syria

WARDE STEEL & METALS SARL MET
Charles Helou Av, Warde Bldg
P.O. Box 165886
LB-Beirut
Telephone: +961 1 447228
lebanon@assab.com

Taiwan

Head office
ASSAB Steels (Taiwan) Co Ltd
No. 112 Wu Kung 1st Rd.
Wu Ku Industry Zone
TW-Taipei 248-87, Taiwan (R.O.C.)
Telephone: +886 2 2299 2849
www.assabsteels.com

Branch offices

NANTOU BRANCH
No. 10, Industry South 5th Road
Nan Kang Industry Zone
Nantou 540-66, Taiwan (R.O.C.)
Telephone: +886 49 225 1702
TAINAN BRANCH
No. 180, Yen He Street,
Yong Kang City
Tainan 710-82, Taiwan (R.O.C.)
Telephone: +886 6 242 6838

Thailand

ASSAB Steels (Thailand) Ltd
9/8 Soi Theedintai,
Taeparak Road, Bangplee,
Samutprakarn 10540, Thailand
Telephone: +66 2 385 5937,
+66 2 757 5017
www.assabsteels.com

United Arab Emirates

ASSAB INTERNATIONAL AB
P.O. Box 17595
Jebel Ali
AE-Dubai
Telephone: +971 488 12165
www.assab.se

Vietnam

CAM Trading Steel Co Ltd
90/8 Block 5, Tan Thoi Nhat Ward
District 12, Ho Chi Minh City
Vietnam
Telephone: +84 8 5920 920
www.assabsteels.com

Other Asia

ASSAB INTERNATIONAL AB
Box 42
E-171 11 Solna, Sweden
Telephone: +46 8 564 616 70
www.assab.se

Africa

Egypt

UNITED FOR IMPORT AND
INDUSTRIAL SUPPLIES
Montaser Project No 20
Flat No 14
Al Ahram Street-El Tabia
EG-Giza Cairo
Telephone: +254 20 7797751
www.assab.se

Kenya

SANDVIK Kenya Ltd
P.O. Box 18264
Post code 00500
KE-Nairobi
Telephone: +254 20 532 866
sandvik@africaonline.co.ke

South Africa

UDDEHOLM Africa (Pty.) Ltd.
P.O. Box 539
ZA-1600 Isando/Johannesburg
Telephone: +27 (11) 974 2791
www.bohler-uddeholm.co.za

Tunisia

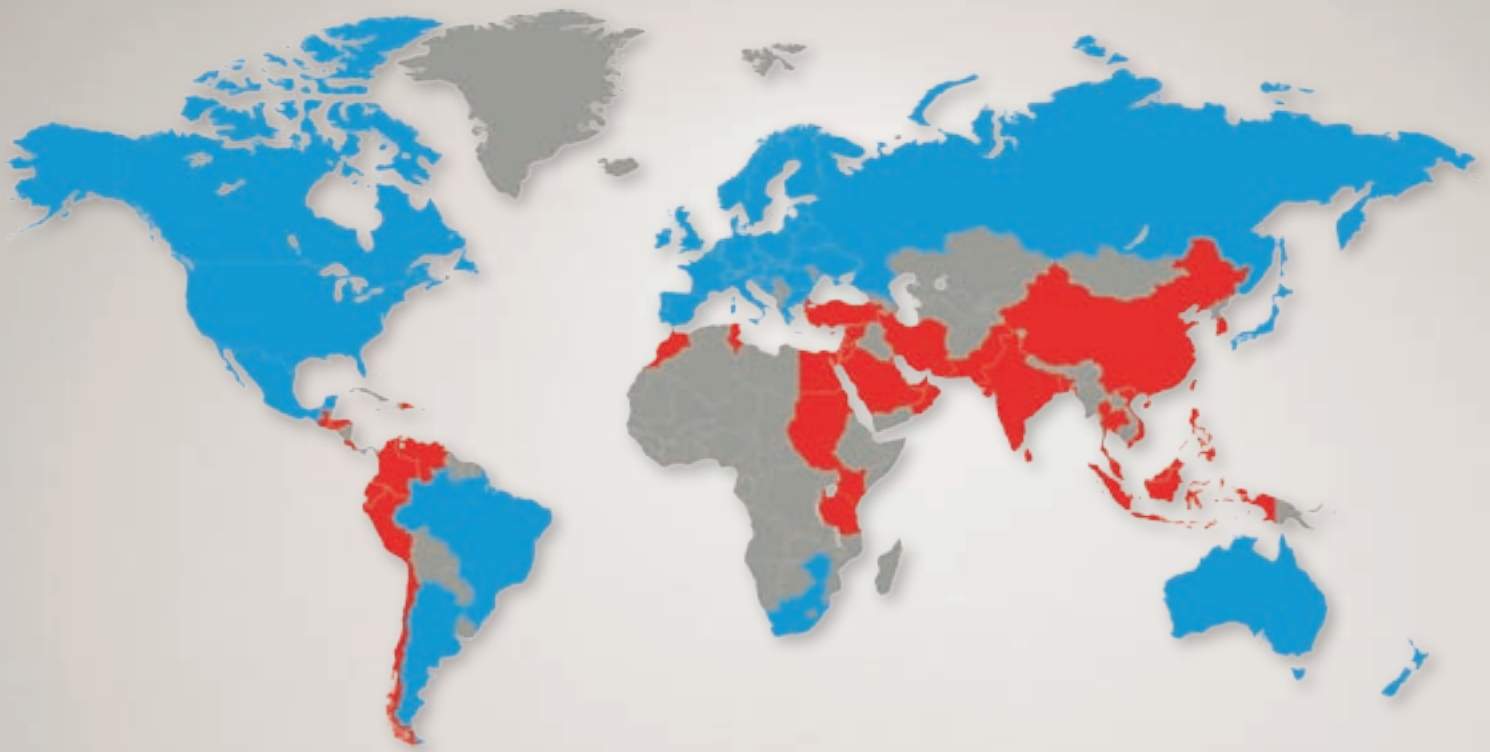
MCM Distribution
4 Bis, Rue 8610 - Z.I.
2035 Chargula 1
TN-Tunis
Telephone: + 216 71 802479
www.mcm.com.tn

Zimbabwe

Representative office:
UDDEHOLM Africa (Pty.) Ltd.
P.O. Box 539
ZA-1600 Isando/Johannesburg
Telephone: +27 11 974 2781
www.bohler-uddeholm.co.za

Other African Countries

ASSAB INTERNATIONAL AB
Box 42
SE-171 11 Solna, Sweden
Telephone: +46 8 564 616 70
www.assab.se



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