## REFERENCE STANDARD

<table>
<thead>
<tr>
<th>Material</th>
<th>AISI</th>
<th>WNr.</th>
<th>JIS</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASSAB DF-2</td>
<td></td>
<td>O1</td>
<td>(1.2510)</td>
</tr>
<tr>
<td>ASSAB DF-3</td>
<td></td>
<td>O1</td>
<td>(1.2510)</td>
</tr>
<tr>
<td>ASSAB XW-5</td>
<td></td>
<td>D6 (D3)</td>
<td>(1.2436)</td>
</tr>
<tr>
<td>ASSAB XW-10</td>
<td></td>
<td>A2</td>
<td>1.2363</td>
</tr>
<tr>
<td>ASSAB XW-41</td>
<td></td>
<td>D2</td>
<td>1.2379</td>
</tr>
<tr>
<td>ASSAB XW-42</td>
<td></td>
<td>D2</td>
<td>1.2379</td>
</tr>
<tr>
<td>CARMO</td>
<td></td>
<td></td>
<td>1.2358</td>
</tr>
<tr>
<td>CALMAX</td>
<td></td>
<td>CALMAX</td>
<td>1.2358</td>
</tr>
<tr>
<td>CALDIE</td>
<td></td>
<td>CALDIE</td>
<td></td>
</tr>
<tr>
<td>ASSAB 88</td>
<td></td>
<td>SLEIPNER</td>
<td></td>
</tr>
<tr>
<td>ASSAB PM 23 SUPERCLEAN</td>
<td></td>
<td>VANADIS 23 SUPERCLEAN</td>
<td>(M3:2)</td>
</tr>
<tr>
<td>ASSAB PM 30 SUPERCLEAN</td>
<td></td>
<td>VANADIS 30 SUPERCLEAN</td>
<td>(M3:2 + Co)</td>
</tr>
<tr>
<td>ASSAB PM 60 SUPERCLEAN</td>
<td></td>
<td>VANADIS 60 SUPERCLEAN</td>
<td>(1.3292)</td>
</tr>
<tr>
<td>VANCRON 40 SUPERCLEAN</td>
<td></td>
<td>VANCRON 40 SUPERCLEAN</td>
<td></td>
</tr>
<tr>
<td>ELMAX SUPERCLEAN</td>
<td></td>
<td>ELMAX SUPERCLEAN</td>
<td></td>
</tr>
<tr>
<td>ASSAB 518</td>
<td></td>
<td>P20</td>
<td>1.2311</td>
</tr>
<tr>
<td>ASSAB 618</td>
<td></td>
<td>P20 Mod.</td>
<td>1.2738</td>
</tr>
<tr>
<td>ASSAB 618 HH</td>
<td></td>
<td>P20 Mod.</td>
<td>1.2738</td>
</tr>
<tr>
<td>ASSAB 618 T</td>
<td></td>
<td>P20 Mod.</td>
<td>1.2738 Mod.</td>
</tr>
<tr>
<td>ASSAB 718 SUPREME</td>
<td></td>
<td>IMPAX SUPREME</td>
<td>P20 Mod.</td>
</tr>
<tr>
<td>ASSAB 718 HH</td>
<td></td>
<td>IMPAX HH</td>
<td>1.2738</td>
</tr>
<tr>
<td>NIMAX</td>
<td></td>
<td>NIMAX</td>
<td></td>
</tr>
<tr>
<td>MIRRAX 40</td>
<td></td>
<td>MIRRAX 40</td>
<td>420 Mod.</td>
</tr>
<tr>
<td>VIDAR 1 ESR</td>
<td></td>
<td>VIDAR 1 ESR</td>
<td>H11</td>
</tr>
<tr>
<td>UNIMAX</td>
<td></td>
<td>UNIMAX</td>
<td></td>
</tr>
<tr>
<td>CORRAX</td>
<td></td>
<td>CORRAX</td>
<td></td>
</tr>
<tr>
<td>ASSAB 2083</td>
<td></td>
<td>420</td>
<td>1.2083</td>
</tr>
<tr>
<td>STAVAX ESR</td>
<td></td>
<td>STAVAX ESR</td>
<td>420 Mod.</td>
</tr>
<tr>
<td>MIRRAX ESR</td>
<td></td>
<td>MIRRAX ESR</td>
<td>420 Mod.</td>
</tr>
<tr>
<td>POLMAX</td>
<td></td>
<td>POLMAX</td>
<td></td>
</tr>
<tr>
<td>RAMAX HH</td>
<td></td>
<td>RAMAX HH</td>
<td>420 F Mod.</td>
</tr>
<tr>
<td>ROYALLOY</td>
<td></td>
<td>ROYALLOY</td>
<td></td>
</tr>
<tr>
<td>PRODAX</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ASSAB 8407 2M</td>
<td></td>
<td>ORVAR 2M</td>
<td>H13</td>
</tr>
<tr>
<td>ASSAB 8407 SUPREME</td>
<td></td>
<td>ORVAR SUPREME</td>
<td>H13 Premium</td>
</tr>
<tr>
<td>DIEVAR</td>
<td></td>
<td>DIEVAR</td>
<td></td>
</tr>
<tr>
<td>HOTVAR</td>
<td></td>
<td>HOTVAR</td>
<td></td>
</tr>
<tr>
<td>QRO 90 SUPREME</td>
<td></td>
<td>QRO 90 SUPREME</td>
<td></td>
</tr>
<tr>
<td>ASSAB 705</td>
<td></td>
<td>4340</td>
<td>1.6582</td>
</tr>
<tr>
<td>ASSAB 709</td>
<td></td>
<td>4140</td>
<td>1.7225</td>
</tr>
<tr>
<td>ASSAB 760</td>
<td></td>
<td>1050</td>
<td>1.1730</td>
</tr>
</tbody>
</table>

ASSAB is a trademark of ASSAB Pacific Pte Ltd.

The information contained herein 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. Each user of ASSAB products is responsible for making its own determination as to the suitability of ASSAB products and services.

Edition D140714
ASSAB 618T is a prehardened plastic mould steel for moulds and tools with very large dimensions and with strength requirements of up to 1200 MPa.

ASSAB 618T is characterised by:

- High level of through-hardenability
- Good machinability
- Good polishing and texturing properties
- Excellent nitriding characteristics
- Good weldability
- High impact toughness

Note: ASSAB 618T is 100% ultrasonic tested.

## Typical analysis %

<table>
<thead>
<tr>
<th>Element</th>
<th>%</th>
</tr>
</thead>
<tbody>
<tr>
<td>C</td>
<td>0.26</td>
</tr>
<tr>
<td>Mn</td>
<td>1.45</td>
</tr>
<tr>
<td>Cr</td>
<td>1.25</td>
</tr>
<tr>
<td>Ni</td>
<td>1.05</td>
</tr>
<tr>
<td>Mo</td>
<td>0.60</td>
</tr>
<tr>
<td>V</td>
<td>0.12</td>
</tr>
<tr>
<td>S</td>
<td>0.002</td>
</tr>
</tbody>
</table>

## Standard specification

None (Patented)

## Delivery condition

Hardened and tempered to 310 - 355 HB

## Colour code

Red / Blue

## Applications

ASSAB 618T is suitable for many different types of applications within the plastic processing industry. Its high level of through-hardenability even for big dimensions over 1000 mm, coupled with high impact toughness, makes ASSAB 618T suitable for large moulds, especially for the automotive industry.

**TYPICAL APPLICATIONS**

Large compression and injection moulds:

- Car bumpers
- Dashboards
- Intake manifolds
- Car bonnets
- Large display panel casings (e.g., TV, computers)
- Home appliances and white goods
- Bottle crates
- Containers
- Chairs
- Dumpsters

A core for moulding of washing machine drum, made of ASSAB 618T inserted with copper beryllium.

Washing machine’s plastic drum. The large and intricately-shaped plastic drum places great demands on the mould steel for high toughness and through hardening characteristics.
Properties

**PHYSICAL PROPERTIES**

Delivery condition.

<table>
<thead>
<tr>
<th>Temperature</th>
<th>20°C</th>
<th>250°C</th>
<th>500°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Density kg/m³</td>
<td>7800</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Modulus of elasticity MPa</td>
<td>204 000</td>
<td>188 000</td>
<td>160 000</td>
</tr>
<tr>
<td>Coefficient of thermal expansion per °C from 20°C</td>
<td>-</td>
<td>12.2 x 10⁻⁴</td>
<td>13.9 x 10⁻⁴</td>
</tr>
<tr>
<td>Thermal conductivity W/m °C</td>
<td>37</td>
<td>41</td>
<td>40</td>
</tr>
<tr>
<td>Specific heat J/kg °C</td>
<td>470</td>
<td>-</td>
<td>-</td>
</tr>
</tbody>
</table>

**MECHANICAL PROPERTIES**

The properties are representative of samples taken from half radius of a forging diameter of 1150 mm. Values of different mechanical properties depend on the dimensions of original material, position and direction of samples, as well as hardness and test temperature.

**Comparison of mechanical properties**

WNr. 1.2738 versus ASSAB 618T

Surface hardness of WNr. 1.2738 = 31 HRC
Surface hardness of ASSAB 618T = 35 HRC
Machining recommendations

The cutting data below are to be considered as guiding values and as starting points for developing your own best practice.

**Condition: Prehardened condition 310-355 HB**

### TURNING⁠¹

<table>
<thead>
<tr>
<th>Cutting data parameters</th>
<th>Turning with carbide</th>
<th>Turning with HSS¹²</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Rough turning</td>
<td>Fine turning</td>
</tr>
<tr>
<td>Cutting speed ((v_c)) m/min</td>
<td>150 - 220</td>
<td>195 - 295</td>
</tr>
<tr>
<td>Feed ((f)) mm/tooth</td>
<td>0.2 - 0.4</td>
<td>0.05 - 0.2</td>
</tr>
<tr>
<td>Depth of cut ((a_p)) mm</td>
<td>2 - 4</td>
<td>0.5 - 2</td>
</tr>
<tr>
<td>Carbide designation ISO</td>
<td>P20 - P30</td>
<td>P20 - P30</td>
</tr>
</tbody>
</table>

¹ High speed steel

² Parameters based on SECO CVD coated grades TP1000/2000/2500/3000

### DRILLING

**High speed steel twist drill**

<table>
<thead>
<tr>
<th>Drill diameter mm</th>
<th>Cutting speed ((v_c)) m/min</th>
<th>Feed ((f)) mm/r</th>
</tr>
</thead>
<tbody>
<tr>
<td>≤ 5</td>
<td>12 - 14⁴</td>
<td>0.05 - 0.15</td>
</tr>
<tr>
<td>5 - 10</td>
<td>12 - 14⁴</td>
<td>0.15 - 0.25</td>
</tr>
<tr>
<td>10 - 15</td>
<td>12 - 14⁴</td>
<td>0.25 - 0.30</td>
</tr>
<tr>
<td>15 - 20</td>
<td>12 - 14⁴</td>
<td>0.30 - 0.35</td>
</tr>
</tbody>
</table>

⁴ For coated HSS drill, \(v_r \sim 18 - 20\ m/min

### MILLING

**Face and square shoulder milling**

<table>
<thead>
<tr>
<th>Cutting data parameters</th>
<th>Milling with carbide</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Rough milling¹</td>
</tr>
<tr>
<td>Cutting speed ((v_c)) m/min</td>
<td>130 - 140</td>
</tr>
<tr>
<td>Feed ((f)) mm/tooth</td>
<td>0.5 - 3.0</td>
</tr>
<tr>
<td>Depth of cut ((a_p)) mm</td>
<td>≤ 2</td>
</tr>
<tr>
<td>Carbide designation ISO</td>
<td>P20 - P40</td>
</tr>
</tbody>
</table>

¹ Parameters based on SECO R217/220.21 high feed cutters with SCET120630T coated inserts

² Parameters based on SECO QuattroMill R217/220.53-09 cutters with SEMX/SEE80973AFTN coated inserts

### End milling

<table>
<thead>
<tr>
<th>Cutting data parameters</th>
<th>Type of milling</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Solid carbide¹</td>
</tr>
<tr>
<td>Cutting speed ((v_c)) m/min</td>
<td>90 - 140</td>
</tr>
<tr>
<td>Feed ((f)) mm/tooth</td>
<td>0.01 - 0.20⁵</td>
</tr>
<tr>
<td>Carbide designation ISO</td>
<td>K10 - P40</td>
</tr>
</tbody>
</table>

ⁱ Based on SECO Jabra end mills

² Based on SECO Turbo type square shoulder indexable insert end mills

³ For coated HSS end mill, \(v_r \sim 25 - 30\ m/min

⁴ Depending on radial depth of cut and cutter diameter

### GRINDING

**Wheel recommendation**

<table>
<thead>
<tr>
<th>Type of grinding</th>
<th>Grinding wheel designation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surface grinding straight wheel</td>
<td>A 46 HV</td>
</tr>
<tr>
<td>Surface grinding segments</td>
<td>A 36 GV</td>
</tr>
<tr>
<td>Cylindrical grinding</td>
<td>A 60 KV</td>
</tr>
<tr>
<td>Internal grinding</td>
<td>A 60 IV</td>
</tr>
<tr>
<td>Profile grinding</td>
<td>A 120 JV</td>
</tr>
</tbody>
</table>

¹ Parameters based on SECO drilling systems

² Parameters for 3XD drilling depth with internal coolant supply

³ Depending on drill diameter
Surface treatment

NITRIDING AND NITROCARBURISING

Nitriding gives a hard surface, which is very resistant to wear and erosion. A nitried surface also increases the corrosion resistance.

For best results, the following steps should be followed:
1. Rough machining
2. Stress tempering at 560°C
3. Grinding
4. Nitriding

The following surface hardness and nitriding depths will be achieved after nitriding:

<table>
<thead>
<tr>
<th>Process</th>
<th>Time</th>
<th>Surface hardness 1</th>
<th>Depth 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gas nitriding at 510°C</td>
<td>36</td>
<td>790 HV</td>
<td>0.40</td>
</tr>
<tr>
<td>Plasma nitriding at 500°C</td>
<td>10</td>
<td>780</td>
<td>0.33</td>
</tr>
<tr>
<td></td>
<td></td>
<td>800</td>
<td>0.30</td>
</tr>
<tr>
<td>Gas nitrocarburing at 570°C</td>
<td>3</td>
<td>740</td>
<td>0.22</td>
</tr>
</tbody>
</table>

1 Unless otherwise specified, nitriding hardness is measured at approximately 20 microns below the surface using micro-Vickers at 0.2 kgf load
2 Nitriding hardness is measured using macro-Vickers at 5 kgf load
3 Nitriding depth is the distance from the surface where hardness is 50 HV higher than the matrix hardness

HARD CHROME PLATING

After plating, the tool should be tempered at 180°C for 4 hours, within 4 hours of plating, to avoid the risk of hydrogen embrittlement

Electrical discharge machining

If spark-erosion, EDM, is performed in the as-delivered condition, the tool should then be given an additional temper at approx. 560°C.

Photo-etching

ASSAB 618T is particularly suitable for texturing by the photo-etching method. Its very low sulphur content ensures accurate and consistent pattern reproduction.

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).

<table>
<thead>
<tr>
<th>Welding method</th>
<th>TIG</th>
<th>MMA</th>
</tr>
</thead>
<tbody>
<tr>
<td>Preheating temperature</td>
<td>350 - 400°C</td>
<td>350 - 400°C</td>
</tr>
<tr>
<td>Filler material</td>
<td>718 TIG-WELD</td>
<td>718 WELD</td>
</tr>
<tr>
<td>Maximum interpass</td>
<td>375°C</td>
<td>375°C</td>
</tr>
<tr>
<td>temperature</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Postweld cooling</td>
<td>20 - 40°C/h for the first two hours and then freely in air</td>
<td></td>
</tr>
<tr>
<td>Hardness after welding</td>
<td>300 - 330 HB</td>
<td>300 - 330 HB</td>
</tr>
<tr>
<td>Heat treatment after welding</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Temper at 600°C for 2 h</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Polishing

ASSAB 618T has very good polishability in its delivery condition. After grinding, polishing can be carried out using aluminium oxide or diamond paste.

TYPICAL PROCEDURE
1. Grind to 0.05 mm from the finished size.
2. Polish with diamond paste grade 45 to obtain a dull and even surface.
3. Polish with diamond paste grade 15.
4. Polish with diamond paste grade 3, or grade 1 for particularly high demands on surface finish size.

Note: Each steel grade has an optimum polishing time, which largely depends on hardness and polishing technique. Overpolishing can lead to a poor surface finish (e.g., an “orange peel” effect).

Further information

For further information, i.e., steel selection, heat treatment, application and availability, please contact our ASSAB office nearest to you.
REGIONAL HEAD OFFICE

SINGAPORE
ASSAB Pacific Pte Ltd
Tel: +65 6334 5600
Fax: +65 6334 0655
info@assab.com
www.assab.com

CHINA
Beijing
ASSAB Tooling (Beijing) Co., Ltd.
Tel: +86 10 6786 5588
Fax: +86 10 6786 2988
info.beijing@assab.com

Changchun
ASSAB Tooling (Beijing) Co., Ltd., Dalian Branch
Tel: +86 431 8897 8922
Fax: +86 431 8897 8922
info.changchun@assab.com

Changzhou
ASSAB Tooling Technology (Shanghai) Co., Ltd. - Changzhou Branch
Tel: +86 519 8188 0008
Fax: +86 519 8310 2820
info.changzhou@assab.com

Chongqing
ASSAB Tooling Technology (Chongqing) Co., Ltd.
Tel: +86 23 6745 5698
Fax: +86 23 6745 5699
info.chongqing@assab.com

Dalian
ASSAB Tooling (Beijing) Co., Ltd., Dalian Branch
Tel: +86 411 8761 8080
Fax: +86 411 8761 9595
info.dalian@assab.com

Dongguan
ASSAB Tooling (Dong Guan) Co., Ltd.
Tel: +86 769 2299 7888
Fax: +86 769 2299 9312
info.dongguan@assab.com

Guangzhou
ASSAB Tooling (Dong Guan) Co., Ltd., Guangzhou Branch
Tel: +86 020 3482 8891
Fax: +86 020 3482 5329
info.guangzhou@assab.com

Hong Kong
ASSAB Steels (HK) Ltd.
Tel: +852 2487 1991
Fax: +852 2489 0938
info.hongkong@assab.com

Hunan
ASSAB Tooling (Dong Guan) Co., Ltd., Hunan Branch
Tel: +86 731 8452 3986
Fax: +86 731 8452 3986
info.hunan@assab.com

Jiangxi
ASSAB Tooling (Dong Guan) Co., Ltd., Jiangxi Branch
Tel: +86 769 2299 7888
Fax: +86 769 2299 9312
info.jiangxi@assab.com

NINGBO
ASSAB Tooling Technology (Ningbo) Co., Ltd.
Tel: +86 574 8680 7188
Fax: +86 574 8680 7166
info.ningbo@assab.com

Qingdao
ASSAB Tooling (Qingdao) Co., Ltd.
Tel: +86 532 8752 9999
Fax: +86 532 8752 9588
info.qingdao@assab.com

Shanghai
ASSAB Tooling Technology (Shanghai) Co., Ltd.
Tel: +86 21 2416 9688
Fax: +86 21 5442 4244
info.shanghai@assab.com

Suzhou
ASSAB Tooling Technology (Shanghai) Co., Ltd. - Suzhou Branch
Tel: +86 512 6900 0161
Fax: +86 512 6252 9227
info.suzhou@assab.com

Tianjin
ASSAB Tooling (Beijing) Co., Ltd., Tianjin Branch
Tel: +86 22 2370 7808
Fax: +86 22 2370 7806
info.tianjin@assab.com

Wuhan
ASSAB Tooling Technology (Shanghai) Co., Ltd., Wuhan Branch
Tel: +86 27 6934 6326
Fax: +86 27 6934 6326
info.wuhan@assab.com

Xi'an
ASSAB Tooling Technology (Beijing) Co., Ltd., Xi'an Branch
Tel: +86 29 8525 5139
Fax: +86 29 8526 2080
info.xian@assab.com

Yantai
ASSAB Tooling (Qingdao) Co., Ltd.
Tel: +86 535 693 4100
Fax: +86 535 693 4200
info.yantai@assab.com

INDONESIA
Jakarta - Head Office
PT. ASSAB Steels Indonesia
Tel: +62 21 461 3134
Fax: +62 21 461 1306/ 461 1309
info.jakarta@assab.com

Bandung
PT. ASSAB Steels Indonesia
Tel: +62 22 5234 017
Fax: +62 22 5234 020
info.bandung@assab.com

Cikarang
PT. ASSAB Steels Indonesia
Tel: +62 21 461 1314
Fax: +62 21 461 1306/ 461 1309
info.cikarang@assab.com

Medan
PT. ASSAB Steels Indonesia
Tel: +62 61 8477 935
Fax: +62 61 8477 936
info.medan@assab.com

Senarang
PT. ASSAB Steels Indonesia
Tel: +62 24 7071 2574/ 7658 4803
Fax: +62 24 674 7145
info.senarang@assab.com

Surabaya
PT. ASSAB Steels Indonesia
Tel: +62 31 849 9606
Fax: +62 31 843 2040
info.surabaya@assab.com

Tangerang
PT. ASSAB Steels Indonesia
Tel: +62 21 5316 0794
Fax: +62 21 5316 0794
info.tangerang@assab.com

JAPAN
Tokyo - Head Office
Bohler-Uddeholm KK
Tel: +81 3 5526 3771
Fax: +81 3 5526 6110
info@bohler-udeholm.jp

Fukuori
Bohler-Uddeholm KK
Tel: +81 583 43 9240
Fax: +81 583 43 9244
info@bohler-udeholm.jp

Nagoya
Bohler-Uddeholm KK
Tel: +81 52 5797 5081
Fax: +81 52 573 6461
info@bohler-udeholm.jp

Osaka
Bohler-Uddeholm KK
Tel: +81 6 6307 7621
Fax: +81 6 6307 7627
info@bohler-udeholm.jp

KOREA
Incheon - Head Office
ASSAB Steels (Korea) Co., Ltd.
Tel: +82 32 821 4300
Fax: +82 32 821 3311
info.korea@assab.com

Busan
ASSAB Steels (Korea) Co., Ltd.
Tel: +82 51 831 3315
Fax: +82 51 831 3319
info.korea@assab.com

DAEGU
ASSAB Steels (Korea) Co., Ltd.
Tel: +82 53 384 3315
Fax: +82 53 384 3319
info.korea@assab.com

MALAYSIA
Kuala Lumpur - Head Office
ASSAB Steels (Malaysia) Sdn. Bhd.
Tel: +60 3 6189 0022
Fax: +60 3 6189 0044/55
info.kualalumpur@assab.com

Northern Branch
ASSAB Steels (Malaysia) Sdn. Bhd.
Tel: +60 4 507 2070
Fax: +60 4 507 6323
info.penang@assab.com

Southern Branch
ASSAB Steels (Malaysia) Sdn. Bhd.
Tel: +60 7 599 0011
Fax: +60 7 599 4990
info.johor@assab.com

PHILIPPINES
Laguna
ASSAB Pacific Pte Ltd - Philippine Branch
Tel: +63 49 539 0441 to 0442
Fax: +63 49 539 1075
info.philippines@assab.com

SINGAPORE
ASSAB Steels Singapore (Pte) Ltd.
Tel: +65 6862 2200
Fax: +65 6862 0162
info.singapore@assab.com

TAINAN
Taipei - Head Office
ASSAB Steels Taiwan Co., Ltd.
Tel: +886 2 2399 2849
Fax: +886 2 2399 0117
info.taipei@assab.com

Kaohsiung
ASSAB Steels Taiwan Co., Ltd.
Tel: +886 7 624 6600
Fax: +886 7 624 0012
info.kaohsiung@assab.com

NANTOU
ASSAB Steels Taiwan Co., Ltd.
Tel: +886 49 225 1702
Fax: +886 49 225 3173
info.nantou@assab.com

THAILAND
ASSAB Steels (Thailand) Ltd.
Tel: +66 2 757 5017
Fax: +66 2 385 5943
info.thailand@assab.com

VIETNAM
ASSAB Steels (Vietnam) Co. Ltd.
Tel: +84 61 8899 099
Fax: +84 61 8899 191
info.vietnam@assab.com

* Sales office
Choosing the right steel is of vital importance. ASSAB engineers and metallurgists are always ready to assist you in your choice of the optimum steel grade and the best treatment for each application. ASSAB not only supplies steel products with superior quality, we offer state-of-the-art machining, heat treatment and surface treatment services to enhance steel properties to meet your requirement in the shortest lead time. Using holistic approach as a one-stop solution provider, we are more than just another tool steel supplier.

ASSAB and Uddeholm are present on every continent. This ensures you that high-quality tool steels and local support are available wherever you are. Together we secure our position as the world’s leading supplier of tooling materials.

For more information, please visit www.assab.com