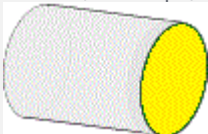


1045 INDUCTION HARDENED HARD CHROME PLATED BAR

1045 is a medium tensile carbon steel supplied in the turned, induction hardened and straightened, precision ground, polished, chrome plated and final polished condition, with a typical base metal tensile strength of 670 Mpa, an induction hardened case of 3.2mm thick approx. to Rc55-65, plus a typical hard chrome plated surface hardness of HV 1000 - 1150. Characterised by an extremely smooth surface finish with excellent wear and corrosion resistance, supported by an induction hardened case offering greater strength and resistance to mechanical damage, coupled with good core strength. 1045 induction hardened hard chrome plated bar is used extensively by the hydraulic and pneumatic industries, for those applications utilising its high surface hardness and excellent resistance to surface impact.

Colour Code	Stocked Sizes	
Yellow (End Caps) 	Metric	25 mm - 110 mm Dia
	Imperial	7/8" - 5"Dia

Related Specifications (Base Material)

Australia	AS 1443 - 1994 1045
Germany	W.Nr 1.0503 C45 W.Nr 1.1191 CK45
Great Britain	BS970 - Part 3 - 1991 080A47 BS970 - Part 1 - 1972 080M46 BS970 - 1955 EN43B
Japan	JIS G 4051 S45C
USA	AISI C1045 ASTM A29/A29M - 91 1045 SAE 1045 UNS G 10450

Chemical Composition (Base Material)

	Min. %	Max %
Carbon	0.43	0.50
Silicon	0.10	0.35
Manganese	0.60	0.90
Phosphorous	0	0.04
Sulphur	0	0.04

Typical (Base Metal) Mechanical Properties - As Supplied Condition

Manufacturing Process	Turned
Tensile Strength Mpa	670
Yield Strength Mpa	470
Elongation In 50mm %	20

Hardness Brinell HB	200							
Typical Properties Induction Hardened Case								
Thickness	3.2mm							
Hardness	Rc 55-65							
Hard Chrome Plating								
Typical Surface Hardness	HV 1000 - 1150							
Typical Surface Smoothness	0.10 - 0.30 umRa (Microns)							
Typical Surface Deposit*	0.025 - 0.050 mm(0.001" - 0.002")							
*Note: Can be supplied up to 0.125 mm against order, subject to minimum quantity requirements.								
Diameter and Straightness Tolerance								
Diameter	mm	Up to 51mm Dia		Over 51 - 102mm Dia		Over 102mm Dia		Straightness
	Inches	Up to 2.0		Over 2.0 - 4.0		Over 4.0		Below 50mm 0.25mm/1000mm Over 50mm 0.30mm/1000mm
Tolerance	mm	+0.00	-0.025	+0.00	-0.050	+0.00	-0.075	
	Inches	+0.00	-0.001	+0.00	-0.002	+0.00	-0.003	
Typical Bar Lengths								
Over 25mm Dia		6000mm						
Bar lengths are approximates only. NB. Bars have 100mm approx. unchromed surface at each end.								
Packaging								
Supplied in cardboard tubes for protection.								
Sawing								
1045 induction hardened hard chrome plated bar, due to the extreme hardness of the induction hardened case, requires special cutting blades or grinding equipment.								
Machining								
1045 induction hardened hard chrome plated bar, due to the extreme hardness of the induction hardened case, requires *ceramic tipped machine tools. Having removed the induction hardened case, the core has very good machinability, similar to 1045 standard bar. To protect the polished chrome surface, soft materials such as copper, aluminium or mild steel should be used as clamping materials and any particles of hard chrome should be removed immediately to avoid scratching. Otherwise all machining operations may be carried out satisfactorily.*Please consult your machine tool supplier.								
Welding								
Welding of 1045 induction hardened hard chrome plated bar is not generally recommended.								

Interlloy believes the information provided is accurate and reliable. However no warranty of accuracy, completeness or reliability is given, nor will any responsibility be taken for errors or omissions.