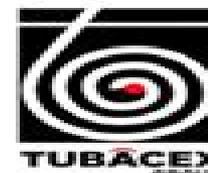


# Analysis of different manufacturing routes for austenitic stainless-steel bars

## Tubacex

Tubacex is a seamless steel manufacturer founded in 1963 and established in Bilbao, Spain. The company provides a wide range of innovative tubular solutions such as tubes, pipes, fittings and special components (tailor-made dimensions and designs). Tubacex gathers several companies located all around the world, allowing to get a leading position on many industries including oil and gas, power generation, petrochemical, fertilizers, aerospace, automotive and engineering. One of the most important asset of the group concerns the fully integrated production: bars production, hot and cold forming and distribution steps are all carried out by Tubacex.



Casting, forging and blooming operations carried out at Tubacex facilities

### Customer

Tubacex, Spain  
www.tubacex.com

### Processes

Ingot casting, forging and blooming

### Challenge

Analyze and compare the quality of two different manufacturing routes for austenitic stainless steel with new ingot design. Focus on porosity and strain results.

### Solutions

Transfer THERCAST® results of the casting operation into FORGE® software for the forging and blooming operations.

**THERCAST®**  
**FORGE®**

## Challenge

Tubacex wants to produce austenitic stainless-steel round bars with a new ingot design to meet high quality requirements, especially in terms of porosity and strain results. With this new ingot design, the productivity in terms of volume will be maximized.

The company has to choose between two different manufacturing routes to maximize the new ingot productivity and to achieve quality requirements. Each of the manufacturing routes begins with the casting operation of a 6,3 tons 316L stainless steel ingot. Then, the ingot is heated prior to the hot forming operation.

The hot forming operation consists in either a forging or a blooming process.

- Forging: it starts with a 340mm square section ingot alternatively held by a manipulator on each side. The ingot is deformed with a series of passes including multiple strokes between a hammer and the anvil. After several passes, the part is rotated by 90 degrees and hammered again before being reheated at the middle of the sequence. Another series of passes comes next until the workpiece presents a 270 mm octagonal cross-section.

# Forging The Chain A Case Study

**G Psacharopoulos**



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