



Die Forging Capability

Closed-die forging of ball valve bodies & covers, gears, flanges and custom parts — Yunhe County, Zhejiang, China

6,000 T

multi-directional presses

5–520 kg

part weight range

Ø600 × 1000 mm

max machining size

15,000 t

forging capacity / year

PRESSES

Press	Force	Forging Weight Range
Multi-directional press No.1	6,000 T (60 MN)	150 – 520 kg
Multi-directional press No.2	3,000 T	30 – 150 kg
Multi-directional press No.3	2,000 T	5 – 30 kg

Largest single forging 520 kg; presses capable of up to 800 kg subject to part-structure review. All three presses are multi-directional.

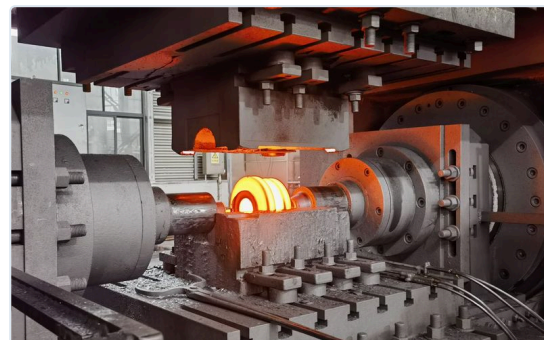
PRODUCTS

- **Ball valve bodies, end caps and covers (bonnets)** — 1/2"–12", Class 150–2500, floating and trunnion-mounted, two-piece and three-piece designs
- **Gear blanks, flanges** and custom closed-die forgings, machined to Ø600 × 1000 mm

MATERIALS

- Carbon & low-temperature steels · alloy steels incl. F91 / F92 · stainless F304 / F316, 420, 17-4 PH
- **Duplex & super duplex** (F51 / F53 / F55) · **nickel alloys** 625 / 718 / 825 · structural steels

Full grade list with standards: see the Materials & Grades card.



Forging on a multi-directional press, Yunhe plant.

UNDER ONE ROOF

- Die design & making · forging · heat treatment · machining
- Heat treatment: quench & temper, solution & ageing — automated control, cycles recorded
- NDT: UT, MT, PT
- In-house lab: spectrometry on every heat, tensile, impact incl. low-temperature bath, hardness, metallography

CERTIFICATIONS & APPROVALS

API Spec 20C · licence No. 20C-0051

NORSOK M650 · special materials

PED 2014/68/EU

AD2000-W0 · TÜV NORD

BV Mode II NR320 (G0247)

ISO 9001 / 14001 / 45001

Documentation: full traceability from heat number to shipment; EN 10204 3.1 inspection certificate as standard with a forging order (3.2 witnessed, on request); UT / MT / PT reports and heat-treatment charts on request. Certificates available on request. · **Quotation usually within 24 hours** of receiving a drawing or specification.