



Krasnoyarsk metallurgical plant KRAMZ



Our experience for your business

Krasnoyarsk Metallurgical Plant is known in Russia and outside the country as KRAMZ – one of the largest enterprises to process aluminium and aluminium alloys.

KRAMZ manufacturers products of more than 35 alloys and their modifications.

We supply semi-finished products out of high aluminium alloys for aviation, ship building, automobile industry and other branches of mechanical engineering.

Our production is constantly improving due to many years experience and know-how in casting, extrusion, forging, as well as equipment modernization and researches.

You can rely on us as on a competent and trustworthy partner.





Casting production

Equipment and technology of casting production allow producing the whole range of aluminium alloys including high alloys of 2000, 5000 and 7000 series.

Equipment:

- melting and casting aggregates, with capacity of 40-60 tons with closed system of melt pouring from the furnace into the distributing mixer;
- systems for cylinder billets casting in casting molds with thermal fittings (NOT-TOP technology) that allow to cast up to 40 billets at the same time;
- devices for continuous modification by alloying bar Al-Ti-B to have close-grained structure;
- equipment and homogenizing technology with the following forced cooling.



Kind of alloy EN 573-3	Diameter, mm	Length, mm
1370, 1050	145, 152, 175, 180, 190, 215, 240	450 - 5000
6063, 6060, 6005, 6463,	120, 127, 145, 152, 162, 178, 190, 203, 215, 228, 254	450 - 5700

Products out of billets with KRAMZ marking can be applied for high technologies



Extruded Production

Main equipment

- Bars and Profiles Shop: Presses of from 800 to 7 000 ton-force and the whole complex of thermal equipment are installed in bar and profile shop
- Tubes Shop: Presses with strength of 1600, 3150, 3500 ten-force, long-stroke mills for tubes cold rolling, equipment for rods and tubes drawing.
- Forging shop: hard vertical presses with strength of 5000, 10000, and 15000 ten-force.

Main products:

- extruded round, square, and flat bars for home market and export;
- round drawn bars for export;
- extruded and cold-deformed tubes for home market;
- special forgings and die-forgings of middle sizes weighing up to 500 kg



Technical peculiarities:

- great quenching capacities (more than 20000 tons) that provide supplies for home market and export;
- technology and equipment for casting, extruding and forging of high alloys that allow manufacturing semi-finished products out of 35 alloys and their 60 modifications;
- production is directed to small sections products for aviation and mechanical engineering;





Die - Tool Production

Die-tool production has high-precision machines with SAD-SAM system for design and manufacture extrusion tools. High quality and short time of tools production are provided by designing without drawing with managing programmes for milling centres and wire sawing machines.

Equipment:

Milling centres

Sigma – 600P (Italy),
MAZAK – Nexus410A (Japan)

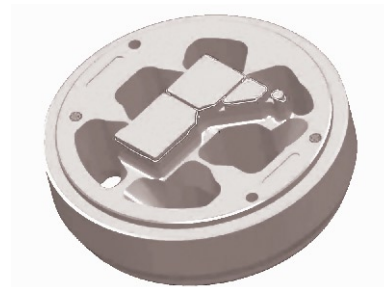
Wire sawing machines

Agie – 200;
Agie Sprint

Electroerosion broaching machines

Agie MONDO

In 2006 they developed DELCAM Power Shape dimensional design system that allows making optimal decisions at the stage of designing

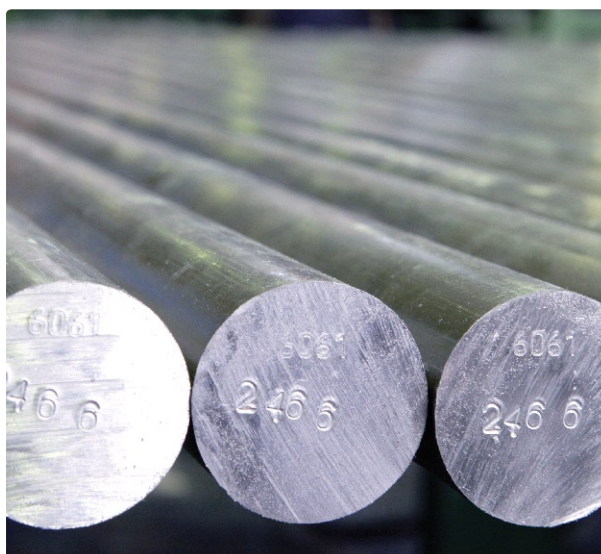




Export products

Extruded bars by EN755 round, square, flat.

Alloy	Temper
EN AW-2007	Ø4, Ø4510, Ø4511
EN AW-2011	Ø6
EN AW-2014	Ø4, Ø4510, Ø4511 Ø6, Ø651, Ø6511
EN AW-2014A	Ø4, Ø4510, Ø4511 Ø6, Ø6510, Ø6511
EN AW-2017A	Ø4, Ø4510, Ø4511
EN AW-2024	Ø3, Ø3510, Ø3511
EN AW-2030	Ø4, Ø4510, Ø4511
EN AW5754A	F, H112, O, H111
EN AW-5083	F, H112, O, H111
EN AW-5086	F, H112, O, H111
EN AW-6012	Ø6, Ø6510, Ø6511
EN AW-6061	O, Ø6
EN AW-6082	Ø4, Ø6
EN AW-7075	Ø6, Ø6510, Ø6511



Drawn Rods by EN754

Alloy	Temper
EN AW-2007	Ø3, Ø351
EN AW-2011	Ø3, Ø8
EN AW-6012	Ø4, Ø6
EN AW-6061	Ø4, Ø6
EN AW-6082	Ø4, Ø6
EN AW-7075	Ø6, Ø651

Dimension-types for all alloys except for 6061

8, 9, 9,53; 10, 11, 11,11; 12, 12,7; 13, 13,23;
14, 14,28; 15, 16, 17, 17,46; 18, 19, 19,05; 20
21, 22, 23, 24, 25, 25,4; 26, 27, 28, 28,58; 29, 30
31, 31,75; 32, 33, 33,33; 34
35, 36, 37, 38, 38,1; 39, 40
41, 41,27; 42, 43, 44, 44,45;
45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55

For alloy 6061

7,94; 12,7; 14,29; 17,46; 19,05; 20,64; 22,23; 24,61
26,99; 33



Products range

Round bars 20 - 250mm

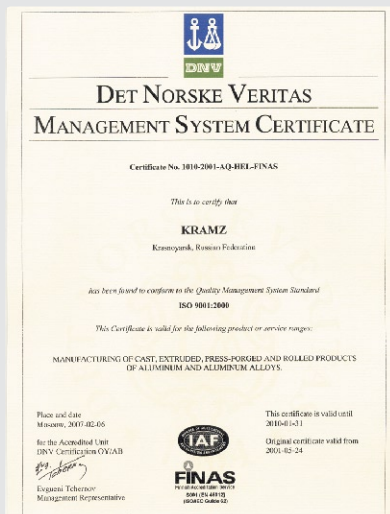
20	20, 21, 22, 23, 24, 25, 25,4; 26, 27, 28, 28,58; 29
30	30, 31, 31,75; 32, 33, 34, 35, 36, 37, 38, 38,1; 39, 39,5
40	40, 42, 42,5; 44, 45, 46, 47, 48, 49
50	50, 50,8; 51, 52, 55, 56, 58, 59,5
60	60, 61, 62, 63, 63,5; 64, 65, 67, 68, 69,85
70	70, 72, 75, 76,2
80	80, 82, 82,5; 84, 85, 88,9
90	90, 91, 92, 94, 95, 95,25
100	100, 101, 101,6; 103, 105, 108, 109, 110, 114,3; 115, 116
120	120, 120,65; 125, 127, 130, 133,35; 135, 139,7
140	140, 142, 145, 147, 150, 152, 152,4; 155, 158,75; 160, 162, 165; 165,1
170	170, 175, 177,8; 180, 185, 190, 190,5; 195
200	200, 201, 203,2; 205; 210, 215, 215,9; 220, 228,6; 225, 230, 240, 250

Square bars 20 - 100mm

	19,05; 20, 22, 25; 25,4
30	30, 31, 32, 35, 36, 38,1
40	40, 44, 45; 45
50	50, 50,8; 55; 57,15
60	60, 63,5; 65
70	70, 75; 76,2
80	80, 82,55; 85; 88,9; 90; 100

Flat bars

12	12ö6; 12ö8; 12ö10
15	15ö5; 15ö8; 15ö10; 15ö12
20	20ö5; 20ö6; 20ö8; 20ö10; 20ö12; 20ö15; 22ö15
25	25ö5; 25ö8; 25ö10; 25ö12; 25ö15; 25ö20
30	30ö4; 30ö5; 30ö6; 30ö8; 30ö10; 30ö12; 30ö15; 30ö20; 30ö25
35	35ö8; 35ö10; 35ö12; 35ö15; 35ö20; 35ö25; 35ö30
40	40ö5; 40ö6; 40ö8; 40ö10; 40ö12; 40ö15; 40ö20; 40ö25; 40ö30; 40ö35
45	45ö8; 45ö12; 45ö15; 45ö20; 45ö25; 45ö30; 45ö40
50	50ö5; 50ö6; 50ö8; 50ö10; 50ö12; 50ö15; 50ö20; 50ö25; 50ö30; 50ö35; 50ö40; 55ö20
60	60ö5; 60ö6; 60ö8; 60ö10; 60ö12; 60ö15; 60ö20; 60ö25; 60ö30; 60ö35; 60ö40; 60ö45; 60ö50
70	70ö8; 70ö10; 70ö15; 70ö20; 70ö25; 70ö30; 70ö35; 70ö40; 70ö50; 70ö55; 70ö60; 75ö25; 75ö35
80	80ö6; 80ö8; 80ö10; 80ö12; 80ö15; 80ö20; 80ö25; 80ö30; 80ö35; 80ö40; 80ö50; 80ö60
90	90ö10; 90ö15; 90ö20; 90ö25; 90ö30; 90ö35; 90ö40; 90ö45; 90ö50; 90ö60; 90ö65; 90ö70; 90ö75
100	100ö5; 100ö6; 100ö8; 100ö10; 100ö12; 100ö15; 100ö20; 100ö25; 100ö30; 100ö35; 100ö40; 100ö50; 100ö60; 100ö70; 100ö80;
110	110ö24; 110ö32
120	120ö5; 120ö10; 120ö15; 120ö20; 120ö25; 120ö30; 120ö40; 120ö50; 120ö60; 120ö70; 120ö80
130	125ö70; 130ö20; 130ö45; 130ö60
140	140ö10; 140ö40;
150	150ö10; 150ö15; 150ö20; 150ö25; 150ö30; 150ö40; 150ö50; 150ö60; 160ö20



The Plant Quality Control system is certified by the international organization DNV for conformance to international standard ISO 9001:2000

Environmental Management system of KraMZ Ltd was elaborated in accordance with requirements ISO 14001:2004



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