



Graphite Carbon Sleeve

For Annealing Furnace for Silicon Steel

The Graphite Carbon sleeve is using high quality coke as raw materials, and high coking modified asphalt as binder, supplement with a small amount of additive. The Graphite Carbon Sleeve has an isophobic internal structure, antioxidant treatment resistant up to 1100°C



Graphite Carbon Sleeve Technical Standards

1. Appearance standard

Diameter of Carbon graphite sleeve surface hole is no more than 1.5mm and the number of holes with diameter between 1.0-1.5mm is less than 3. Graphite sleeve has no surface cracks. Surface cracks is detected by visual inspection, surface roughness and product tag location are manufactured according to the contract drawing specification.

2. Dimensions

Convexity, flatness, diameter (both inside and outside), length, card slot and other specifications of graphite carbon sleeve are manufactured according to the contract

3. Graphite Carbon Sleeve Physical-Chemical Indexes.

| Performance Index | Product Category | | |
|-----------------------------------|--|---|-----------------------------|
| | DWTT | ZWTT | GWTT |
| Bending Strength (Mpa) | ≥ 15 | ≥ 18 | ≥ 25 |
| Compressive Strength (Mpa) | ≥ 30 | ≥ 35 | ≥ 45 |
| Porosity (%) | ≤ 12 | ≤ 10 | ≤ 10 |
| Bulk Density (g/cm ³) | ≥ 1.73 | ≥ 1.75 | ≥ 1.85 |
| Graphitization Degree (%) | 70-90 | 70-90 | 75-90 |
| Shore Hardness (Hs) | 35-50 | 35-50 | 35-50 |
| Maximum Aperture (mm) | ≤ 0.2 | ≤ 0.1 | ≤ 0.05 |
| Using Conditions | Wet and Dry Atmosphere Room temperature – 900°C | Wet and Dry Atmosphere 850°C – 950°C | Dry Atmosphere above 950 °C |

References

| Customer | Country | Size | Quantity supplied/year | Working Time | Working Temperature | Forming Type |
|--------------|-------------|------------|------------------------|-------------------|---------------------|------------------|
| Wuhan Steel | China | 150x1900mm | 200pcs | 3 month | 960-1050°C | Isostatic molded |
| | | 180x1900mm | 145pcs | | | |
| Baosteel | China | 150x1900mm | 100pcs | 3 month | 960-1050°C | Isostatic molded |
| | | 180x1900mm | 80pcs | | | |
| Tisco | China | 140x2000mm | 60pcs | 6 month | 900-1050°C | Isostatic molded |
| Posco Pohang | South Korea | 150x2100mm | 500pcs | 6 month to 1 year | <950°C | Isostatic molded |

Graphite Carbon Sleeve Operation Precautions

1. Carbon Graphite Sleeve is a brittle material. Vibration-impact during transportation and installation is prone to breakage.
2. Iron core deformation (bending) will lead to breakage of the carbon graphite sleeve. Regularly checking and accordingly replacement is necessary.
3. Graphite oxidation reaction starts at 400 °C. Be aware of cooling for preventive maintenance in the dry atmosphere.
4. Keep furnace clean. Furnace dust and metal oxides are the primary cause of nodulation.





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