rothe erde® rings

Seamless rolled rings in the highest precision.
thyssenkrupp rothe erde – Successful with seamless rolled rings.

Over 150 years of experience in steel forming and machining ensures that rothe erde® rings deliver outstanding performance. Our expertise in open-die and drop forging enabled us to apply the technology for seamless rolled rings (radial-axial rolling technology) perfectly from the outset and continuously improve it. By contrast with other methods such as production from heavy plate metal, this manufacturing process offers key economic and technical advantages.

In particular the tangential grain flow typical of rolled rings ensures homogeneous mechanical properties around the entire circumference of the ring. We stock the mostly required materials in various dimensions – including several aluminum alloys – in order to minimize the response time.

Material grades produced via ingot and continuous casting, electroslag remelting and forging enable us to meet a broad spectrum of customer requirements.

rothe erde® rings are available in a wide range of outside diameters from 300 to 8,000 mm.

In addition to their usage in slewing bearings, further applications for rothe erde® rings range from all types of industrial machinery, large gear units, vehicle construction and aerospace to wind turbines and tunnel boring machines. The in-house machining of our rings is the key to this diversity.

State-of-the-art testing facilities guarantee the high quality of our products.
The experience which thyssenkrupp rothe erde has gained over many years enables us to meet all challenges of the markets of today and tomorrow.
thyssenkrupp rothe erde holds all conventional materials in various dimensions and adequate quantities in stock. These materials include ingots and continuous cast grades, preformed and ESR materials as well as non-ferrous metals, in particular standard aluminum alloys. It enables us to meet our customers’ requests and stick to delivery deadlines.

Thanks to our worldwide network, we can quickly procure materials which are not usually held in stock. In many cases we are able to suggest alternative materials with identical application properties. Short throughput times are an important prerequisite for timely delivery. We achieve these by highly flexible order planning and production control.

Optimizing the ring dimensions in the early consultation phase further contributes to this flexibility.

The consequent adaptation of ring dimensions to the application purpose is further assisted by linked CAD and CNC programs. Depending on customer requirements, from the “simple” blank to the ready-to-install component. The very tight manufacturing tolerances can only be achieved by precise adherence to the specified weights when the ingot is cut to length. This is ensured by modern high-powered saws with integrated weighing systems.
Productivity

A structured production system

Our rolling mills are among the most modern manufacturing plants of their type. They are equipped with CNC controls and cover outside diameters from 300 to 8,000 millimeters. They are the core elements of an electronically controlled, rationalized production flow with automatic loading, handling and conveying equipment.

Elaborate CNC ring rolling programs allow previously unattainable reproducibility in the manufacture of seamless rolled rings. The hydraulic presses integrated into the production flows are adapted to the capacities of the respective ring rolling mills. It is therefore possible to select the most suitable and economical production equipment for each ring type, size or quantity required. Preheating furnaces with high precision control and supervising systems allow the processing of each material at its material-specific temperature range. Besides, economical material usage is an important matter during the production process. Optimization during the forming stage contributes to assuring optimum material utilization while saving costs for the customer.

Due to their diversity, the applications of rolled rings require a large number of different cross sections and dimensions. Modern ring rolling technology provides the flexibility to meet such requirements. The limit values indicated are not always transferable to higher-alloyed materials with high deformation resistance. If the ring dimensions reach two limit values in combination, the rollability must be analyzed separately. It is possible to adjust the mechanical properties by appropriate heat treatment for the whole production range.

For further information or for assistance with your particular needs, please contact our sales department.
The achievement of optimum processing and application properties in modern materials relies on material-specific heat treatment processes. In addition to know-how and experience, this requires most advanced technical equipment and procedures. This is the only way to allow a specific extraction of the material qualities demanded for the purpose. Besides the standard processes such as normalizing, annealing, soft annealing, etc., program controlled processes allow precise adherence to time-temperature specifications for special materials. The existing installations also meet the stringent requirements for aviation and space applications.

We not only supply rings “as-rolled” but on request we also carry out all kinds of machining in our highly capable mechanical production section, on request. This includes turning, drilling and especially gear cutting. Internal gear cutting with straight teeth or external gear cutting with straight / angled teeth, and depending on the stresses that must be withstood, with inductive tooth flank or root hardening. Special procedures such as nitriding complete our program.
Universality

A single program for individual applications

A few examples of applications:
- Wind power plants
- High-power gears
- Mechanical engineering
- Offshore technology
- Rings and supporting rings for slewing bearings
- Turbines
- Generators
- Transformers
- Hydraulic motors
- Large valves
- Pipelines
- Textile machinery
- Tanks/pressure vessels
- Gear rings
- Aerospace and spaceflight
- Bulk-feed presses
- Steel mills
Sustainability is a core element of our company strategy:
As part of a global industrial group, thyssenkrupp rothe erde develops innovative product solutions which not only secure long-term successes for our customers, but also make a positive contribution to global development. We are focusing on the future: our decisions are not only guided by economic considerations, but also by ecological and social concerns. Our integrated management system is certified according to the following standards:

- **quality**
  - according to DIN EN ISO 9001
  - according to DIN EN 9100
- **environmental protection**
  - according to DIN EN ISO 14001
- **energy management**
  - according to DIN EN ISO 50001
- **occupational safety**
  - according to DIN EN ISO 45001

Through constant development, we are able to improve our business processes continuously. We perform regular reviews to ensure permanent effectiveness and continuous improvement of all sections. Next to customer demands, we are also able to comply with legal and governmental requirements.

The definition of quality, safety and environmental protection objectives ensures that resources are suitably used, measured and evaluated.

It is important to identify relevant requirements, avoid errors and strictly eliminate sources of error in all function areas during the processing of quotations and orders – from planning through to the shipment of products.

We offer products which are manufactured to the highest standards in terms of quality, occupational safety, ecological and economic aspects.

The spectrum of topics in the area of sustainability ranges from growth, compliance and human rights, to efficiency of resources. We use our engineering expertise to meet the worldwide demand for more goods and services in a better way.

Our promise:
- promote sustainable development with man-oriented management and process control
- enhance the sense of responsibility of serving society and environment protection with antipollution and continuous improvement
- guide our behavior with relative laws and rules
- put prevention first to avoid accidents

Our requirement:
- control of possible risks
- prevent any kind of pollution
- in compliance with the laws and rules

Our pursuit:
- create a safe, healthy and clean working environment
- we are working on the development of new energy and will continue to make our contributions to society
### Unalloyed structural steels

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### High-alloyed steels made in Germany

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All spare parts can be ordered in old standards.

### International standards

Worldwide operations increasingly need to be adapted to international standards. Therefore, it is important to know to what extent identical analyses or application-identical material properties are meeting requirements. The following tables show various international standards applicable for unalloyed structural steels, quenched and tempered steels, high-alloyed steels and wrought aluminum alloys. Considering the multitude of formable materials, these lists cannot be comprehensible. Please contact the thyssenkrupp rothe erde sales department for more information.

Materials

Please contact the thyssenkrupp rothe erde sales department for more information.
### Manufacturing range in medium-alloyed steels

#### Geometrical forms from cylinder to disk shapes:
- **Dₐ max.:** 8,000 mm
- **Dₐ min.:** 300 mm
- **Height H:** 20 - 600 mm
- **Wall thickness S min.:** 20 mm
- **Wall thickness S max.:** 700 mm
- **Weight:** 20 - 30,000 kg

### Production flow

- **Raw material**
- **Sawing**
- **Heating**
- **Upsetting**
- **Punching**
- **Rolling**
- **Heat treatment**
- **Mechanical machining**

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#### Materials

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All the information presented in this brochure has been carefully compiled and reviewed. Thyssenkrupp Rothe Erde cannot be held responsible for any errors or omissions. We reserve the right to make technical modifications and additions in the interests of technical advancement.
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