

Hydraulics Industry

Plasma (Ion) Nitriding in the Hydraulics Industry



Parts:

- **Plungers**
- **Pistons**
- **Cylinder Blocks**
- **Swash Plates**
- **Valve Plates**
- **Gears**
- **Impellers**
- **Shafts**

- **Hydraulic Cylinders** (Piston Rods, Cylinder Barrels)

Requirements:

- For high **Hardness**
- For high **Wear resistance**
- For high **Fatigue strength**
- For **Lower friction**
- For **Corrosion Resistance**

Ion Nitriding Solutions:

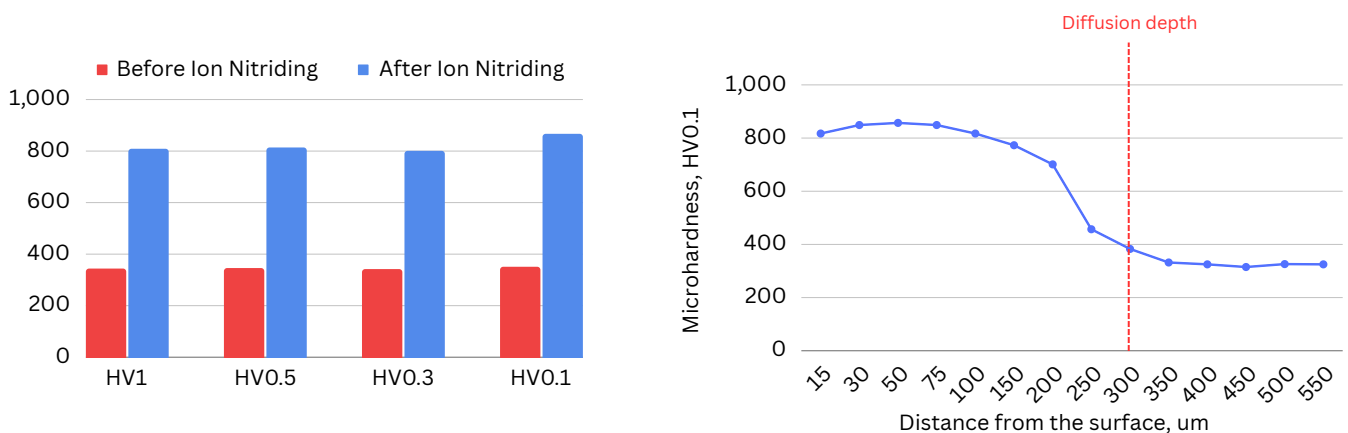
- **Significantly increasing the surface hardness, wear resistance and fatigue life of the parts, improving their lifespan and performance.**
- **Reducing the friction coefficient.**
- **Increasing the corrosion resistance.**
- Post-Oxidation can be done after nitriding in the same process for **further increase in corrosion resistance.**

Improving these parameters **will save from downtime and maintenance costs.**

Steel Grades Used:

Steel Grade	Surface Hardness, HV	Case Depth, um
31CrMoV9	750 - 900	150 - 350
41CrAlMo7-10	900 - 1100	150 - 350
4142 / 42CrMo4	650 - 750	150 - 400
4340	650 - 800	150 - 400
4140	650 - 750	150 - 400
9310	600 - 800	150 - 400
6150 / 51CrV4	650 - 800	150 - 400
5115 / 16MnCr5	650 - 750	150 - 500
5120 / 20MnCr5	650 - 750	150 - 500
304 / X5CrNi18-10	900 - 1200	20 - 80
303 / X10CrNiS18-9	900 - 1200	20 - 80
316 / X5CrNiMo17-12-2	900 - 1200	20 - 80
630 / 17-4PH	950 - 1100	30 - 150
S355J	450 - 600	400 - 600
1045	450 - 600	400 - 600

- Hardness and depth values are recommended for the industry and exact values will depend on the nitriding process parameters.
- This is not a full list of used steel grades



- Example of steel **31CrMoV9** after Ion Nitriding - surface hardness and diffusion depth



Equipment and Technology

Developed state of the art both Hot-Wall and Cold-Wall furnaces for Plasma (Ion) Nitriding.

Know-How and Expertise

We share our knowledge and expertise on nitriding different steel grades and parts, gathered for more than 45 years.

Support

We give full-time support.



Ionitech Ltd.

5 Capitan Ljuben Kondakov st.,
Sofia 1582, Bulgaria
Mobile: +359 887 80 9272
Mobile: +359 889 36 4364
Email: office@ionitech.com
www.ionitech.com