HAVER & BOECKER

DIE DRAHTWEBER

MATERIALS FOR WOVEN WIRE CLOTH.
EXTENSIVE AS THE RANGE OF APPLICATIONS.

MATERIALS FOR WOVEN WIRE CLOTH.

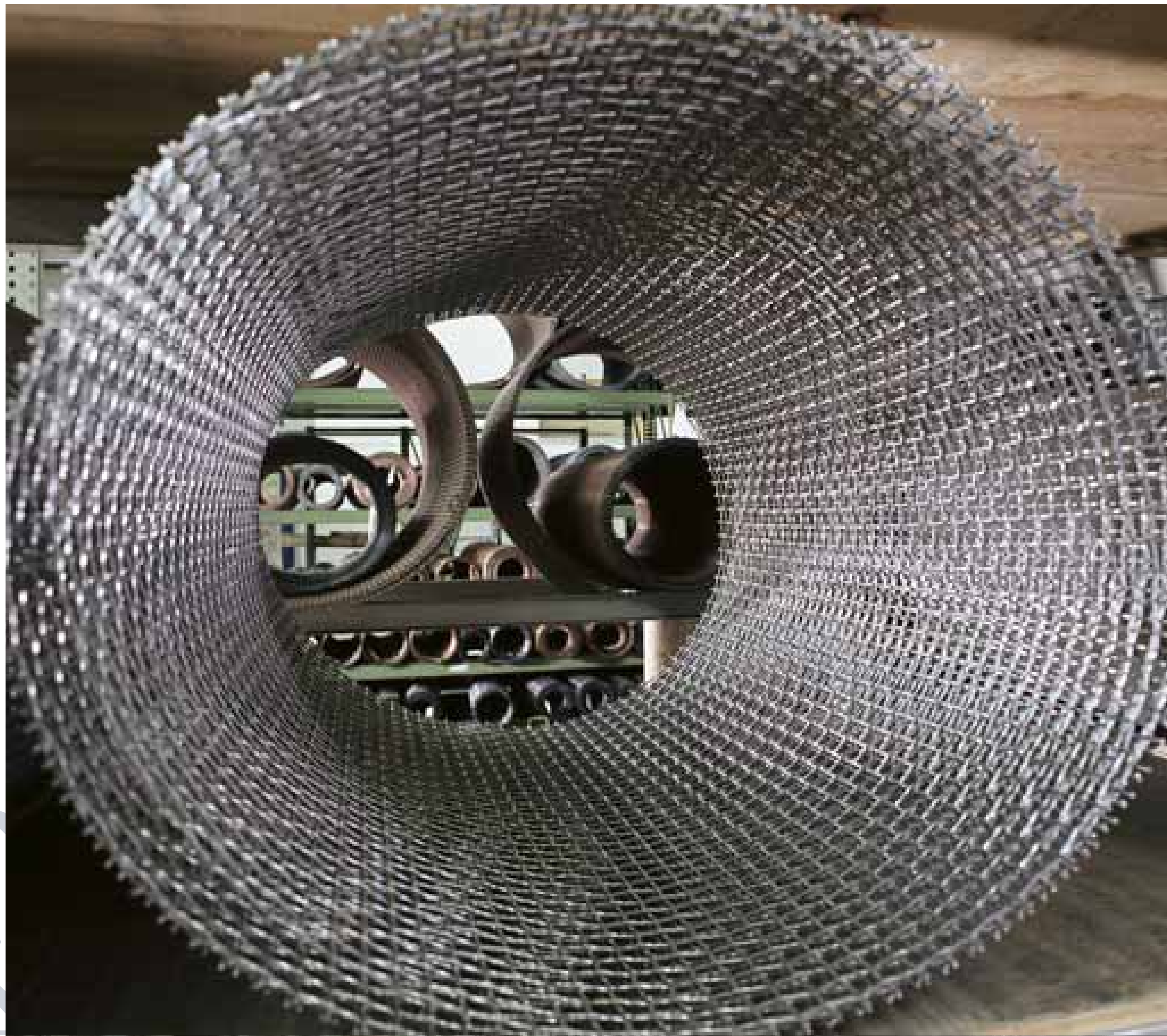
Technical woven wire cloth manufactured by Haver & Boecker is used for screening and filtration in almost every industrial sector: chemical, plastic, automobile, aviation, aerospace, electronics, industrial screening (mining and quarrying), test sieving, food processing industry and a host of other applications. In addition to its technical properties, Haver & Boecker woven wire cloth has a high aesthetic appeal. Architects and designers started combining the two in the early 1990s. The variety of wire mesh types offered by Haver & Boecker is as extensive as the range of applications. From 16 mm diameter wire, to fine wire down to only 0.015 mm diameter, we weave all types of material.

- Steel: blank, galvanized, tinned, lacquered, plastic coated
- Stainless steel: chrome steel, chrome-nickel steel, chrome-nickel-molybdenum steel, heat resisting steel
- Non-ferrous metals: aluminium, nickel, MONEL-Metal, phosphor bronze, brass, copper
- Special materials: titanium, hastelloy, silver, platinum und many others.

The selection of material, quality and processing are of great importance for the properties of the woven wire cloth product. Certain requirements can be fulfilled only by using certain materials. Here the costs for various materials can vary widely. Knowledge about which materials are best suited for particular applications and which processes may be used are especially important for assuring the fulfilment of the requirements for function, stability, safety, and economy.
On the following pages we present the individual materials. A table shows the chemical composition, density, resistance to air, sea water, lye, and acid, as well as tensile strength, heat conducting capacity, and electrical resistance.
Using certified measurement and test procedures, proof is provided that the wire cloth from Haver & Boecker fulfils the respective requirements.

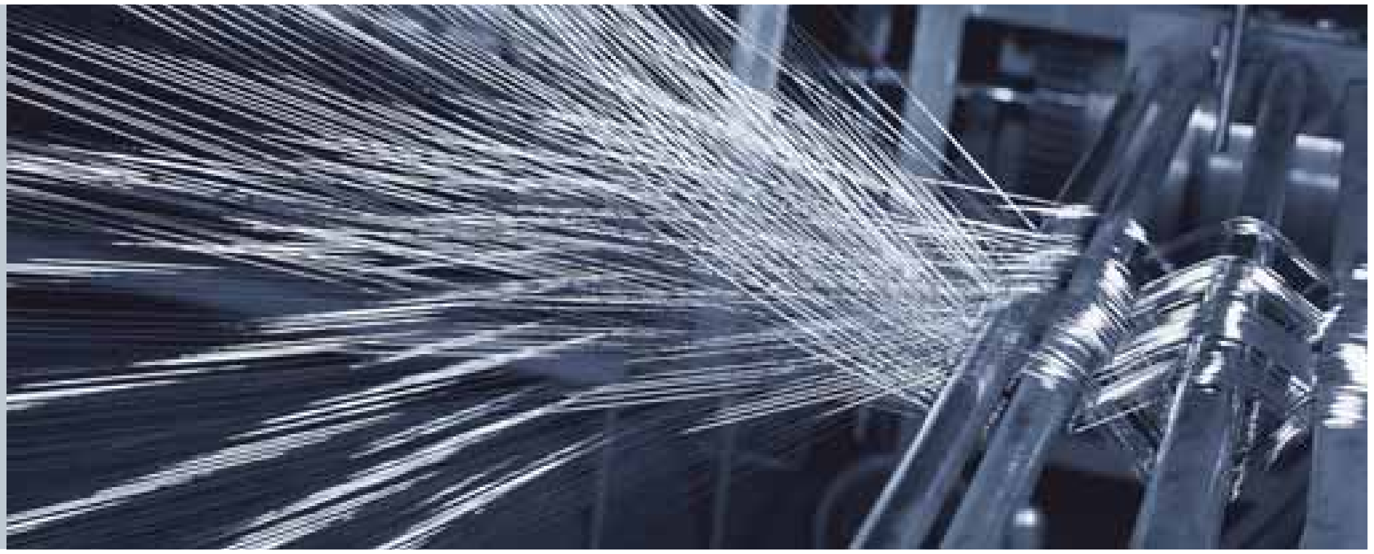
Moreover, we have also developed our own processes for quality assurance. During the reception of wire materials, wire cloth production and before the delivery our laboratory conducts special analyses along with the classic material and quality checks.

Our certified quality management system as to DIN EN ISO 9001:2015 provides additional assurance.
In connection with differentiated quality assurance of incoming wire material until finished product as to DIN ISO 9044 and DIN ISO 9045, first class woven wire cloth quality is guaranteed.



Haver & Boecker began producing wire cloth in Hohenlimburg, Germany, in 1887. Today, we are one of the world's leading wire weaving companies with a global network of branches and manufacturing facilities.

Our work is based upon experience, continuous research and development of our products and manufacturing processes, along with the knowledge and ability of our staff. This combination of tradition and innovation allows us to meet and exceed the high expectations of our customers.



Steel

Plain, low carbon steel (iron) with little resistance to corrosion under „normal" environmental conditions. Haver & Boecker therefore offers woven wire cloth made from plain steel in galvanized, tinned or lacquered finish.

HAVER NIA-Steel

HAVER NIA-Steel is a spring steel with high carbon content and manganese elements. It is extremely resistant to abrasion and vibration and - at the same time - it is elastic. Therefore it is especially suitable for industrial screens.

Martensitic and Precipitation-hardening Stainless Steels

The materials named in the table show a feritic microstructure and are magnetic. Using special heat treatment they can be hardened in order to achieve a higher wear resistance and stability.
The chromium content of the alloy results in good corrosion resistance to „normal" environment conditions.

Austenitic Stainless Steels

Stainless Steel is the most widely used material for our woven wire, covering most applications. These alloys show very good resistance to corrosion under atmospheric conditions. Austenitic stainless steels are not resistant to high-temperature-oxidation. For high-temperature applications, when some discoloration of the surface can appear, i.e. over 450°C (842°F), heat resisting steels should preferably be used.
In cases where comparable corrosion properties are required with a higher strength, we recommend the material No. 1.4310. If the material is to be welded, we recommend austenitic stainless steels with a low carbon content or the material No. 1.4571, stabilized with titanium. Both show a sufficient resistance to intercrystaline corrosion. The material group 1.44.. contains molybdenum and has a higher resistance to chlorous media than the material group 1.43...

Austenitic-Ferritic Steels

So-called compound steels with very good corrosion resistance to sea-water. The alloy constituent molybdenum makes them resistant against pitting or selective corrosion. Compared to the austenitic alloys they have a high tensile strength, making them particularly suitable for applications of the chemical or petro-chemical industry.

Heat Resisting Steel and Heat Conducting Alloys

These steels are resistant to temperatures of up to 1,300°C (2,375°F) in air and show a good resistance to possible heat waste. The coat of aluminium-oxide that forms on the wire surface makes them especially suitable for applications in air. The use of ferritic steels in aggressive or sulphurous surroundings is not recommended. For such applications austenitic heat resisting steels should be used as they show a better resistance to high-temperature-corrosion.

Copper and Copper based Alloys

Copper displays good conducting properties for heat and electricity. It is highly resistant in the atmosphere as well as in sea-water. The corrosion resistance to cyanides, halogenides and ammonia however is poor.
Copper-tin alloys (Phosphor Bronze) are largely wear and tear resistant and show good emergency running properties. This property is important in bearings.
Copper-zinc alloys (Brass) are particularly suitable for sieving and filtration purposes. It is important that the material does not come into contact with ammonia (NH_3), because it may be destroyed by crevice corrosion.

Nickel and Nickel based Alloys

Nickel is resistant to a number of corroding media such as halogenides, caustic alkalines and many organic compounds. It shows good magnetic-, electrical- and heat conducting properties. Woven wire cloth made from a nickel based alloy is produced to meet certain criteria. Special alloy constituents combine a high corrosion resistance to acids and lyes with temperature resistance. Alloy 59 offers a large application field in alkalines and acids.

Titanium and Aluminium based Alloys

Aluminium is a very soft and light material with good corrosion resistance. As for the austenitic materials the corrosion resistance results from a passivation coating that is
formed in the air. ALMg3 and ALMg5 are alloyed with magnesium and have a higher tensile strength than highgrade aluminium (coat).
Titanium is a material with very good corrosion resistance to a number of aggressive media. It is used in the air-, space- and medical industries.
The excellent relation ship between tensile strength and density is comparable to austenitic materials.

Material No.		**Unalloyed** Steel Alloy Composition (Melt Analysis) – Percentage per Mass								
EN 10016	Short Term	C	Si	Mn	Fe	Cr	Cu	Mo	Ni	Others
1.0300	C4D	≤ 0.06	≤ 0.30	0.3-0.6	Rest	≤ 0.20	≤ 0.30	≤ 0.05	≤ 0.25	Al ≤ 0.01
1.0304	C9D	≤ 0.10	≤ 0.30	≤ 0,60	Rest	≤ 0.20	≤ 0.35	≤ 0.08	≤ 0.25	–
1.0586	C50D NIA	0.48-0.53	0.1-0.3	0.5-0.8	Rest	≤ 0.15	≤ 0.25	≤ 0.05	≤ 0.20	Al ≤ 0.01
Material No.		**Ferritic** Stainless Steel Alloy Composition (Melt Analysis) – Percentage per Mass								
EN 10088	AISI[1]	C	Si	Mn	N	Cr	Cu	Mo	Ni	Others
1.4016	430	≤ 0.08	≤ 1.0	≤ 1.0	–	15.5-17.5	–	–	–	–
Material No.		**Martensitic and Precipitation-hardening** Stainless Steel Alloy Composition (Melt Analysis) – Percentage per Mass								
EN 10088	AISI[1]	C	Si	Mn	N	Cr	Cu	Mo	Ni	Others
1.4006	410	0.03-0.12	≤ 1.0	≤ 1.0	–	12.0-14.0	–	–	–	–
1.4034	–	0.43-0.50	≤ 1.0	≤ 1.0	–	12.5-14.5	–	–	–	–
Material No.		**Austenitic** Stainless Steel Alloy Composition (Melt Analysis) – Percentage per Mass								
EN 10088	AISI[1]	C	Si	Mn	N	Cr	Cu	Mo	Ni	Others
1.4301	304	≤ 0.07	≤ 1.0	≤ 2.0	≤ 0.11	17.5-19.5	–	–	8.0-10.5	–
1.4306	304L	≤ 0.03	≤ 1.0	≤ 2.0	≤ 0.11	18.0-20.0	–	–	10.0-12.0	–
1.4310	301	0.05-0.15	≤ 2.0	≤ 2.0	≤ 0.11	16.0-19.0	–	≤ 0.8	6.0-9.5	–
1.4401	316	≤ 0.07	≤ 1.0	≤ 2.0	≤ 0.11	16.5-18.5	–	2.0-2.5	10.0-13.0	–
1.4404	316L	≤ 0.03	≤ 1.0	≤ 2.0	≤ 0.11	16.5-18.5	–	2.0-2.5	10.0-13.0	–
1.4435		≤ 0.03	≤ 1.0	≤ 2.0	≤ 0.11	17.0-19.0	–	2.0-3.0	12.5-15.0	–
1.4439	317LN	≤ 0.03	≤ 1.0	≤ 2.0	0.12-0.22	16.5-18.5	–	4.0-5.0	12.5-14.5	–
1.4539	904L	≤ 0.02	≤ 0.7	≤ 2.0	≤ 0.15	19.0-21.0	1.20-2.00	4.0-5.0	24.0-26.0	–
1.4571	316 Ti	≤ 0.08	≤ 1.0	≤ 2.0	–	16.5-18.5	–	2.0-2.5	10.0-13.0	Ti = 5 X C to 0.7
Material No.		**Austenitic-Ferritic** Stainless Steel Alloy Composition (Melt Analysis) – Percentage per Mass								
EN 10088	AISI[1]	C	Si	Mn	N	Cr	Cu	Mo	Ni	Others
1.4462	318LN	≤ 0.03	≤ 1.0	≤ 2.0	0.10-0.22	21.0-23.0	–	2.5-3.5	4.50-6.50	–
Material No.	Norm	**Heat Resisting Steel** and **Heat Conducting Alloys** Alloy Composition (Melt Analysis) – Percentage per Mass								
		C	Si	Mn	N	Cr	Cu	Fe	Ni	Others
1.4742[2]	DIN 43720	≤ 0.12	0.7-1.4	≤ 1.0	–	17.0-19.0	–	–	–	Al = 0.7-1.2
1.4841[2]	DIN 43720	≤ 0.20	1.5-2.5	≤ 2.0	≤ 0.11	24.0-26.0	–	–	19.0-22.0	–
1.4864[2]	AISI 330	≤ 0.08	0.75-1.50	≤ 2.0	–	17.0-20.0	–	–	34.0-37.0	–
1.4893[2]	–	≤ 0.10	1.7	–	0.17	21.0	–	–	11.0	Ce = 0.05
1.4725[3]	DIN 17470	≤ 0.10	≤ 0.5	≤ 1.0	–	13.0-15.0	–	–	–	Al = 3.5-5.0
1.4765[3]	DIN 17470	≤ 0.10	≤ 1.0	≤ 0.6	–	22.0-25.0	–	–	–	Al = 4.5-6.0
1.4767[3]	DIN 17470	≤ 0.10	≤ 1.0	≤ 1.0	–	19.0-22.0	–	–	–	Al = 4.0-5.5
2.4869[3]	DIN 17470	≤ 0.15	0.5-2.0	≤ 1.0	–	19.0-21.0	≤ 0.5	≤ 1.0	≥ 75.0	Al ≤ 0.30

(1) Parts of the melt analysis do not correspond to EN 10088-3:08-1999. The given AISI-designations are general recommondations.
(2) Heat resisting steels
(3) Heat conducting alloys
(4) Brands or registered trade names
(5) 1 = resistant; 2 = largely resistant; 3 = resistant with some conditions; 4 = little resistant; 5 = poor resistant
(6) At the atmosphere (round values)

Material No.	Density	Resistance[5]				Tensile Strength	Heat Conducting Capacity	Electrical Resistance
EN 10016	kg/dm³	Atmosphere	Seawater	Lyes	Acids	MPa	W / K m	Ω mm²/m
1.0300	7.85	5	5	2-4	4-5	250-450	81	0.13
1.0304	7.85	5	5	2-4	4-5	300-500	–	–
1.0586	7.85	5	5	2-4	4-5	1000-2000	–	–
Material No.	Density	Resistance[5]				Tensile Strength	Heat Conducting Capacity	Electrical Resistance
EN 10088	kg/dm³	Atmosphere	Seawater	Lyes	Acids	MPa	W / K m	Ω mm²/m
1.4016	7.70	2	4	2	3	450-600		
Material No.	Density	Resistance[5]				Tensile Strength	Heat Conducting Capacity	Electrical Resistance
EN 10088	kg/dm³	Atmosphere	Seawater	Lyes	Acids	MPa	W / K m	Ω mm²/m
1.4006	7.70	2	4	2	3-4	450-600	30	0.60
1.4034	7.70	2	4	2	3	450-800	30	0.55
Material No.	Density	Resistance[5]				Tensile Strength	Heat Conducting Capacity	Temperature-Resistance
EN 10088	kg/dm³	Atmosphere	Seawater	Lyes	Acids	MPa	W / K m	°C
1.4301	7.90	1	3	1-2	2-4	500-700	15	450
1.4306	7.90	1	3	1-2	2-4	460-680	15	450
1.4310	7.90	1	3	2	2-4	750-900	15	450
1.4401	7.90	1	2-3	2	2-3	550-710	15	450
1.4404	7.90	1	2-3	2	2-3	490-690	15	450
1.4435	8.00	1	2-3	2	2-3	490-690	15	450
1.4439	8.00	1	1	1-3	2	580-800	14	450
1.4539	8.00	1	1	2	2-3	520-720	12	500
1.4571	8.00	1	1	2	2-3	500-730	19	500
Material No.	Density	Resistance[5]				Tensile Strength	Heat Conducting Capacity	Electrical Resistance
EN 10088	kg/dm³	Atmosphere	Seawater	Lyes	Acids	MPa	W / K m	Ω mm²/m
1.4462	7.80	1	1	2-4	2-4	680-880	15	0.8
Material No.	Density	Resistance[5]				Tensile Strength	Maximum Application Temperature[6]	
	kg/dm³	Atmosphere	Seawater	Lyes	Acids	MPa	° C	°F
1.4742[2]	7.70	1	4	2-5	2-5	500-700	1000	1830
1.4841[2]	7.90	1	3	2-3	2-4	550-800	1150	2100
1.4864[2]	8.00	1	2-3	2-3	3	550-800	1100	2010
1.4893[2]	7.80	1	2	1-2	2-3	650-850	1150	2100
1.4725[3]	7.30	1	4	2-3	2-4	600-800	1000	1830
1.4765[3]	7.10	1	3-4	2-3	2-4	600-800	1300	2370
1.4767[3]	7.20	1	3-4	2-3	2-4	600-800	1200	2190
2.4869[3]	8.30	1	4	2-3	2-4	650-850	1200	2190

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Material No.	Standard	Short Terms	**Copper and Copper based Alloys** Alloy Composition (Melt Analysis) – Percentage in %							
			Fe	Ni	Pb	Al	Cu	Zn	Sn	Others
2.0065	DIN EN 1412	E-Cu58	–	–	–	–	≥ 99.9	–	–	O = 0.005-0.04
2.0040	DIN EN 1412	OF-Cu	–	–	–	–	≥ 99.99	–	–	–
2.0321	DIN 17660	CuZn37	≤ 0.10	≤ 0.3	≤ 0.10	≤ 0.03	62.0-64.0	Rest	≤ 0.10	–
2.0250	DIN 17660	CuZn20	≤ 0.05	≤ 0.2	≤ 0.05	≤ 0.02	79.0-81.0	Rest	≤ 0.05	–
2.1020	DIN 17662	CuSn6	≤ 0.1	≤ 0.3	≤ 0.05	–	Rest	≤ 0.3	5.5-7.0	≤ 0.2
2.0872	DIN 17664	CuNi 90/10	1.3-1.8	10.0-11.0	–	–	Rest	–	–	C ≤ 0.05; Mn 0.5-1.0

Material No.	Standard	Alloy [4]	**Nickel and Nickel based Alloys** Alloy Composition (Melt Analysis) – Percentage in %							
			C	Si	Mn	Cr	Cu	Mo	Ni	Others
2.4060	DIN 17740	200	≤ 0.08	≤ 0.10	≤ 0.3	–	≤ 0.10	–	≥ 99.6	MG ≤ 0.15; Ti ≤ 0.1; Fe ≤ 0.2
2.4066	DIN 17740	200	≤ 0.08	≤ 0.10	≤ 0.3	–	≤ 0.25	–	≥ 99.2	Mg ≤ 0.15; Ti ≤ 0.1; Fe ≤ 0.4
2.4360	DIN 17743	400	≤ 0.15	≤ 0.5	≤ 2.0	–	28.0-34.0	–	≥ 63.0	Al ≤ 0.50; Ti ≤ 0.3; Fe 1.0-2.5
2.4602	N 06022	C22	≤ 0.01	≤ 0.08	≤ 0.5	20.0-22.5	–	12.5-14.5	Rest/Bal.	V≤ 0.35; W 2.5-3.5; Co ≤ 2.5; Fe 2.0-6.0
2.4605	N 06059	59	≤ 0.01	≤ 0.10	≤ 0.5	22.0-24.0	–	15.0-16.5	Rest/Bal.	Co ≤ 0.3; Fe ≤ 1.5; Al 0.1-0.4
2.4610	DIN 17744	C4	≤ 0.01	≤ 0.08	≤ 1.0	14.0-18.0	≤ 0.50	14.0-18.0	Rest/Bal.	Co ≤ 2.0; Fe ≤ 3.0; Ti ≤ 0.7
2.4816	DIN 17742	600	≤ 0.01	≤ 0.5	≤ 1.0	14.0-17.0	≤ 0.50	–	≥ 72.0	Ti ≤ 0.3; B ≤ 0.006; Fe 6.0-10.0
2.4819	DIN 17744	C276	≤ 0.015	≤ 0.08	≤ 1.0	14.5-16.5	≤ 0.50	–	Rest/Bal.	Co ≤ 2.5; Fe 4.0-7.0; W 3.0-4.5
2.4851	DIN 17742	601	≤ 0.10	≤ 0.5	≤ 1.0	21.0-25.0	≤ 0.50	–	58.0-63.0	Al 1.0-1.7; Bi ≤ 0.006; Fe ≤ 18.0
2.4858	DIN 17744	825	≤ 0.025	≤ 0.5	≤ 1.0	19.5-23.5	1.5-3.0	2.5-3.5	38.0-46.0	Ti 0.6-1.2; Al ≤ 0.2; Fe Rest/Bal.; Co ≤ 1.0

Material No.	Standard	Short Term (Int. Alloy Reg. No.)	**Titan- and Aluminium based Alloys** Alloy Composition (Melt Analysis) – Percentage in %							
			Fe	Si	Mn	Al	Mg	Ti	Zn	Cu
3.0205	DIN 1712	Al99	Fe + Si ≤ 1.0		≤ 0.05	≥ 99	≤ 0.05	≤ 0.05	≤ 0.10	≤ 0.05
3.3535	DIN 1725	AlMg3 (5754)	0.40	0.40	–	Rest	2.6-3.6	0.15	0.20	0.10
3.3555	DIN 1725	AlMg5 (5056A)	0.40	0.50	0.10-0.60	Rest	4.5-5.4	0.20	0,20	0.10
			Fe	O	N	H	C	Ti	Zn	Others
3.7025	DIN 17850	Ti1	≤ 0.15	≤ 0.12	≤ 0.05	≤ 0.013	≤ 0.06	Rest	–	≤ 0.4
3.7035	DIN 17850	Ti2	≤ 0.20	≤ 0.18	≤ 0.05	≤ 0.013	≤ 0.06	Rest	–	≤ 0.4

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(6) At the atmosphere (round values)

Material No.	Density	Resistance [5]				Tensile Strength	Heat Conducting Capacity	Electrical Resistance
	kg/dm^3	Atmosphere	Seawater	Lyes	Acids	MPa	W / K m	$\Omega\ mm^2/m$
2.0065	8.94	1	2	1-3	3-5	200-250	393	0,017
2.0040	8.94	1	2	1-3	3-5	200-300	393	0,017
2.0321	8.44	5	5	3	4-5	490-590	120	0,067
2.0250	8.70	4	4	2	2-5	450-550	142	0,053
2.1020	8.82	1	2	3	2-5	480-650	75	0,111
2.0872	8.90	1	1	1-5	2-5	300-400	59	0,150

Material No.	Density	Resistance [5]				Tensile Strength	Heat Conducting Capacity	Electrical Resistance
	kg/dm^3	Atmosphere	Seawater	Lyes	Acids	MPa	W / K m	$\Omega\ mm^2/m$
2.4060	8.40	1	2	1-3	3-5	340-440	79	0.095
2.4066	8.40	1	2-3	1-2	3-5	370-470	71	0.090
2.4360	8.80	1	1	2-3	1-5	450-550	26	0.513
2.4602	8.70	1	1	1-2	1-2	690-890	9	0.114
2.4605	8.50	1	1	1-2	1-2	690-890	10	0.125
2.4610	8.60	1	1	1-3	1-3	700-900	10	0.124
2.4816	8.40	1	2-3	1-2	2-5	550-750	15	0.103
2.4819	8.70	1	1	1-3	1-3	750-950	11	0.125
2.4851	8.10	1	2-3	1-3	1-5	650-850	11	0.119
2.4858	8.10	1	1	1-3	1-2	550-750	11	0.112

Material No.	Density	Resistance [5]				Tensile Strength	Heat Conducting Capacity	Electrical Resistance
	kg/dm^3	Atmosphere	Seawater	Lyes	Acids	MPa	W / K m	$\Omega\ mm^2/m$
3.0205	2.70	2-3	4	4-5	3-5	75-140	204	0.028
3.3535	2.66	2-3	4	4-5	3-5	230-260	140	0.050
3.3555	2.64	2-3	4	4-5	3-5	310-340	116	0.061
3.7025	4.50	2	1-2	3-5	1-4	290-340	17	0.500
3.7035	4.50	2	1-2	3-5	1-4	390-440	17	0.500

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ENVIRONMENTAL STANDARDS AND CERTIFICATIONS.

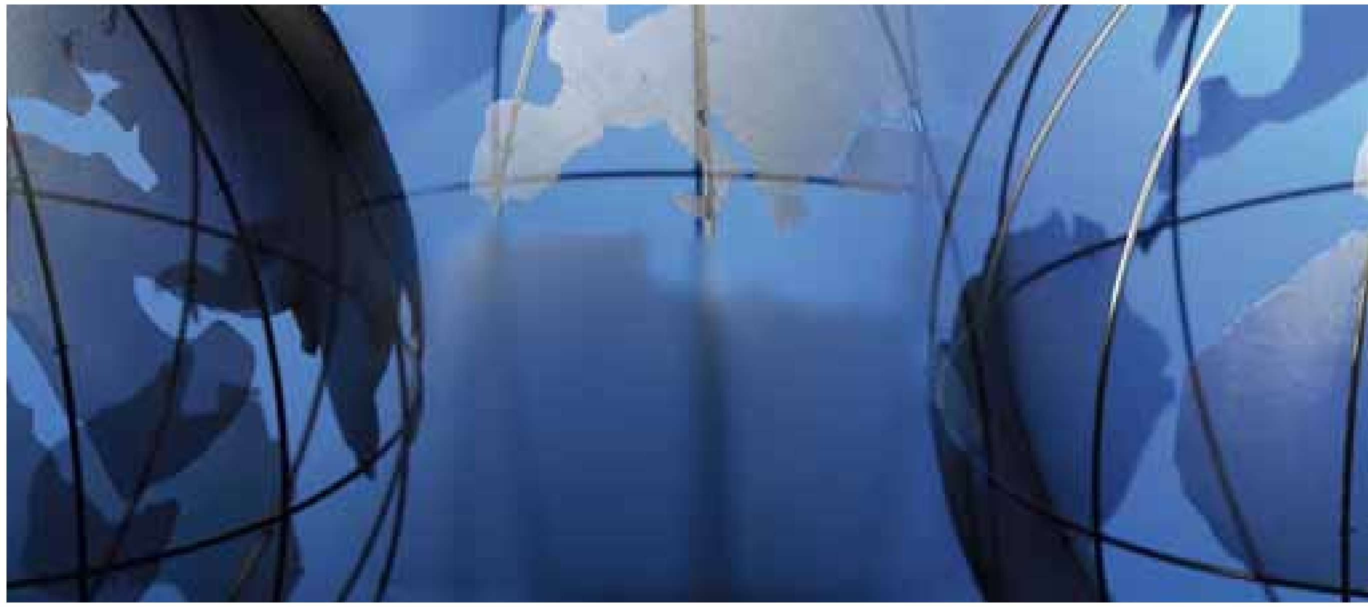
Modern production methods along with the competence of our employees, and first-rate quality assurance ensure a uniformly high level of quality in our products. Numerous individual certifications from independent test organisations also confirm this, along with our DIN EN ISO 9001:2015 certified process-oriented quality management system.

Haver & Boecker was one of the first companies to be certified as to DIN EN ISO 9001 back in 1997. The company's automotive area is also certified according to the especially high standards of ISO TS 16949.

With reference to ISO 14001, the company has also installed an environmental management system. We work closely together with the workers' association, our plant physician centre, and the works council, with this aim continuously in mind.

It goes without saying that Haver & Boecker complies with all the environmental laws and regulations. Environmental aspects contribute to the initial development of processes and products so that potential environmental impact is avoided early on.

NO SITE IS OUT OF SIGHT.



Haver & Boecker has actively influenced the technology of wire weaving since its beginning. As a result of our successful company history, today we are able to offer our customers the benefit of our unrivalled experience, technology and know-how about wire cloth.

Whether science or research, industry or architecture - wherever Haver & Boecker wire cloth is used, our customers benefit from a broad but still unique individual service

With our worldwide weaving network we offer the comforting certainty to be your competent and reliable partner at any time and any place. So as to continue WEAVING IDEAS in time to come.

Haver and Boecker operates production sites in Germany, Great Britain, Belgium, the USA, Canada, Brazil, India and Belarus.

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