HEAT TREATMENT FURNACES

Bogie Hearth Furnace

Car-bottom furnace for annealing, normalising and hardening heavy forgings and castings, up to 1,200°C.



TEMPERATURE
Up to 1,200°C

HEATING
Gas (LPG/PNG/CNG) or electric

INDUSTRIES
Steel forging and casting, power and hydro equipment, heavy engineering

Specifications

Maximum temperature	1,000–1,200°C
Example	7,000 × 1,800 × 1,200 mm inside, 3 zones, 500–950°C within ±5°C
Loading	refractory-lined bogie on rails; two-bogie layouts
Heating	automatic LPG/PNG/CNG burners or electric elements
Airflow	AISI-304/310 radial fans with water-cooled assemblies
Lining	75–250 mm ceramic fibre + 230 mm insulation brick
Door	lift-and-swing with seal
Outer wall	within about 25°C of ambient (example build)
Controls	multi-zone PID with recorder

Typical reference builds

Build	Load	Working size (W x D x H)	Temperature	Heating
Compact	2,000 kg charge	2,000 × 1,200 × 1,000 mm	up to 1,050°C	Electric or PNG/LPG
Standard	5,000 kg charge	3,500 × 1,500 × 1,200 mm	up to 1,100°C	PNG/CNG
Heavy-Duty	15,000 kg charge	7,000 × 1,800 × 1,200 mm	up to 1,200°C	PNG/CNG (multi-zone)

Indicative only: chamber size and heating load (kW or burner rating) are engineered to your load, cycle and site supply.

Features

- Crane loading outside the furnace
- Two-bogie option for continuous working
- Multi-zone control for long loads
- Low outer-wall temperature saves heat
- Erection and commissioning by AHS
- Recorder for heat treatment certificates

Applications

- Annealing and normalising heavy forgings
- Hardening large castings and rolls
- Heat treating hydro and power plant parts
- Annealing large fabrications
- Heat treating die blocks and shafts