



# WH, WHX (XHD) WELDED STEEL MILL CHAINS

**FOR SAWMILLS, PAPER AND PULP INDUSTRY  
AND PANEL PLANTS (OSB, MDF, CHIPBOARD)**

**Welded Steel Mill Chains (FB) are suitable for use under the most adverse conditions. The design as well as materials and heat treatments guarantee the highest fatigue strength, operational reliability and breaking loads.**

We achieve this through wear-resistant heat-treated pins, welded bushes and a strong press fit in the chain plates. For the heavy-duty IBR design, the pins and bushes are first quenched and tempered to increase their tensile strength. In the next step pins and bushes are wear-resistant induction hardened.



**Practical tip:** WHX chains from FB Ketju with press-fit and externally welded bushes increase the operational reliability and service life of the chains and sprockets.



## ADVANTAGES



### High quality and long service life

Thanks to high-quality steels, optimised chain design, process-controlled component production and heat treatment as well as fully automatic chain assembly



### High load capacity and fatigue strength

Link plates with optimal and strong press fit increase resistance to shock loads and lateral loads



### High operational reliability and equipment-uptime

Welded bushes and a strong press fit guarantee high fatigue strength and stability. Additional operational safety and a longer service life are provided by WHX conveyor chains (XHD eXtra Heavy Duty welded steel chains) offering bigger bearing-surfaces and stronger link plates



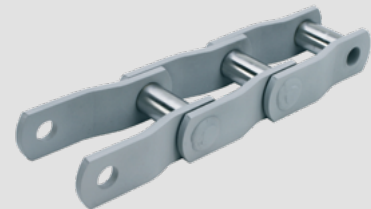
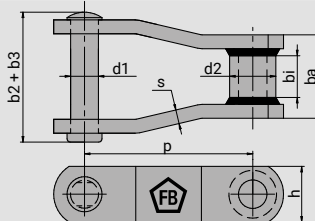
### Ready-to-install solutions - resource-saving, flexible, sustainable and cost-saving

On request, we supply the chains with flights and in chain lengths according to your wishes, adapted to your application parameters. You have less waste, lower costs and less effort

# MATERIALS, HEAT TREATMENTS AND MANUFACTURING PROCESSES

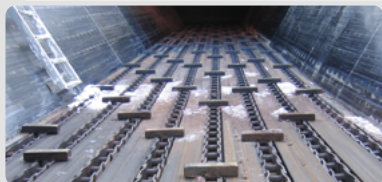
	pins	bushes	linkplates
Materials:		high alloy Mn or Cr steels	
Manufacturing:	WH: quenched and tempered IBR, WHX, XHD: quenched and tempered & induction hardened (WR: quenched and tempered)	WH: quenched and tempered IBR, WHX, XHD : quenched and tempered & induction hardened (WR : no heat treatment)	WH, IBR, WHX, XHD: quenched and tempered IBRS: working surface induction hardened (WR: no heat treatment)
Heat treatment:	one side head, other side riveted optional: welded, strong press fit anti-twist protection, centreless ground	solid bush, welded to the chain plates from the inside, centreless ground	plate holes precision punched or double punched (depending on chain type)

## DIMENSIONS AND BREAKING LOADS



Type	Breaking load	Pitch	Inner width	Pins Ø	Pin length	Bushes Ø	Link plates			kg/m
	F <sub>B</sub>	p	b <sub>i</sub>	d <sub>i</sub>	b <sub>2</sub> + b <sub>3</sub>	d <sub>2</sub>	b <sub>a</sub>	s	h	
	(N)	(mm)	(mm)	(mm)	ca. (mm)	(mm)	(mm)	(mm)	(mm)	
WH78	146.791	66,27	25,4	12,7	76,2	21,3	50,8	6,4	31,8	6,4
<b>WH78XHD</b>	<b>160.136</b>	<b>66,95</b>	<b>25,4</b>	<b>14,2</b>	<b>85,9</b>	<b>25,4</b>	<b>50,8</b>	<b>9,7</b>	<b>31,8</b>	<b>9,4</b>
WH82	160.136	78,11	28,7	14,2	85,9	25,4	57,2	6,4	31,8	7,0
<b>WH82XHD</b>	<b>253.549</b>	<b>78,11</b>	<b>28,7</b>	<b>19,1</b>	<b>95,3</b>	<b>31,8</b>	<b>60,5</b>	<b>9,7</b>	<b>31,8</b>	<b>12,6</b>
WH124	253.549	101,60	38,1	19,1	108,0	31,8	69,9	9,7	38,1	11,6
<b>WH124XHD</b>	<b>542.683</b>	<b>103,20</b>	<b>38,1</b>	<b>25,4</b>	<b>124,0</b>	<b>41,4</b>	<b>76,2</b>	<b>12,7</b>	<b>50,8</b>	<b>21,7</b>
WH111	266.893	120,90	44,5	19,1	122,2	31,8	85,9	9,7	44,5	12,8
WH110	224.635	152,40	47,8	19,1	101,6	31,8	76,2	9,7	38,1	10,4
WH106	266.893	152,40	38,1	19,1	108,0	31,8	69,9	9,7	38,1	9,2
<b>WH106XHD</b>	<b>542.683</b>	<b>153,67</b>	<b>38,1</b>	<b>25,4</b>	<b>124,0</b>	<b>44,5</b>	<b>76,2</b>	<b>12,7</b>	<b>50,8</b>	<b>17,6</b>
<b>WH106XHD-41,15</b>	<b>542.683</b>	<b>153,67</b>	<b>38,1</b>	<b>25,4</b>	<b>124,0</b>	<b>41,1</b>	<b>76,2</b>	<b>12,7</b>	<b>50,8</b>	<b>17,6</b>
WH132	542.683	153,67	69,9	25,4	162,1	44,5	112,0	12,7	50,8	20,8
<b>WH132XHD</b>	<b>542.683</b>	<b>153,67</b>	<b>69,9</b>	<b>25,4</b>	<b>171,5</b>	<b>44,5</b>	<b>118,4</b>	<b>16,0</b>	<b>50,8</b>	<b>22,8</b>
WH150	542.683	153,67	69,9	25,4	165,1	44,5	112,0	12,7	63,5	24,3
WH155	778.439	153,67	69,9	28,7	162,8	44,5	112,8	14,2	63,5	28,3
WH157	778.439	153,67	69,9	28,7	171,5	44,5	117,6	16,0	63,5	29,8
WH159	934.127	155,58	69,9	31,8	171,5	50,8	117,6	16,0	76,2	38,7
WH200	845.162	155,58	69,9	31,8	171,5	50,8	117,6	16,0	63,5	32,9

Subject to dimensional changes



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