Steel Solutions
for protection applications
Our Business

Leading supplier of high quality steels

Subsidiary of ArcelorMittal, Industeel is specialized in the production of hot rolled steel plates, ingots and formed pieces in the largest dimensional range.

Specialized in carbon and stainless steels, Industeel offers a complete range of high quality steel grades designed to meet the most severe specifications.
Our strengths

First-class producer of ballistic protection steel plates

Industeel specificities and advantages in protection steels manufacturing

QUIET PLATES

Thanks to our efficient and soft process quenching, eliminating residual stress, we guarantee quiet plates with:

- No deformation during and after cutting
- Low residual magnetism

FLATNESS

Our unique quenching press machine gives excellent results in terms of guaranteed flatness (95% plates < 1.5 mm/m):

- Easier welding
- Better integration

TIGHT TOLERANCES

In addition to quarto plates, Industeel offers a wide range of coils (up to 10 mm) with tight tolerances (+/-0.2 mm) thus allowing weight reduction.
Our added value

Innovative Steel Solutions for protection applications

Innovation
We design new solutions to respond to specific requirements with innovative and added-value products.

Our Research and Development Center works in cooperation with recognized institutes and organizations (dynamic tests, blast trials, ...) to develop new grades and anticipate future requirements.

Technical Assistance
Our team can support you in the integration of our steel solutions (heat treatments, machining, bending, welding...).

Trials
We have the experience and know-how to design ballistic solutions and perform conventional ballistic trials (with all the main accredited ballistic centers).
Our services
More than a mere plate supplier

Parts or kits
Experienced team of Ballistic experts dedicated to provide you with the best service from the very beginning of your project up to successful completion.

Our complete offer:
- Plates from quarto plates or coils
- Parts for target application with holes or attachments for handling
- Laser cut parts
- Cold or hot bended parts
- Laser welded pieces
- V shape floors, underbelly formed parts
- Specific perforated material

Stock of plates
All you need to start your project on time:
Our stock:
- Various protection steel grades (Mars® 190, 220, 240, 300, 600) available in a wide range of thicknesses
- Samples, prototype parts are also available with short delivery time

Sample with fitting holes
Specific painted sample
Perforated samples
«KIT» Steel solution
Our high quality steel solutions for protection applications

<table>
<thead>
<tr>
<th>STANDARD LEVELS</th>
<th>MARS® 190</th>
<th>MARS® 220</th>
<th>MARS® 240</th>
<th>MARS® 300</th>
<th>PERFO. MARS® 300</th>
<th>MICRO PER-FO. MARS® 300</th>
<th>MARS® 600</th>
<th>DOUBLE OR MULTI-LAYERS MARS®</th>
</tr>
</thead>
<tbody>
<tr>
<td>Civil EN 1522 Standard</td>
<td>FB3-FB4</td>
<td>★★★</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>FB5-FB6</td>
<td>★ ★ ★</td>
<td>★★ ★</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>FB7</td>
<td>★ ★ ★</td>
<td>★★★★</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Military Stanag 4569 (AEP 55)</td>
<td>KE 1 &amp; 2</td>
<td>★ ★</td>
<td>★★ ★</td>
<td>★★★★</td>
<td></td>
<td></td>
<td>★ ★ ★</td>
<td>★★★★</td>
</tr>
<tr>
<td>KE 3</td>
<td>★ ★</td>
<td>★★ ★</td>
<td>★★★</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>KE 4</td>
<td>★ ★</td>
<td>★★★</td>
<td>★★★</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>20 FSP</td>
<td>★★★★</td>
<td>★★★</td>
<td>★★★</td>
<td>★★★★</td>
<td>★★★★</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Mines – IED</td>
<td>★★★★</td>
<td>★★★★</td>
<td>★★★★</td>
<td>★★★★</td>
<td>★★★★</td>
<td>★★★★</td>
<td>★★★★</td>
<td>★★★★</td>
</tr>
</tbody>
</table>

**Hardness – Key factor**

![Diagram showing hardness levels and thicknesses for MARS® grades](image)

- Multi-hit ballistic test for civil applications

Thickneses and grades available for specific needs
Ballistic properties

Used as solid plate stand alone
7.62 mm Ball ammunition x 51
Obliquity 0° Nato
Distance 10 m (33’’)
Required thicknesses for protection

<table>
<thead>
<tr>
<th>Material</th>
<th>Thickness</th>
<th>Impact Sectional View</th>
</tr>
</thead>
<tbody>
<tr>
<td>MARS® 190</td>
<td>10 mm</td>
<td></td>
</tr>
<tr>
<td>MARS® 220</td>
<td>8 mm</td>
<td></td>
</tr>
<tr>
<td>MARS® 240</td>
<td>6 mm</td>
<td></td>
</tr>
<tr>
<td>MARS® 600</td>
<td>5 mm</td>
<td></td>
</tr>
</tbody>
</table>
Rolled Homogeneous Armor
MARS® 190 for targets

ADVANTAGES

Reproduceability
- From one heat to another for each specified grade
- From one target to another in a production line

Homogeneity
- Throughout whole thickness and independently of the thickness
- Over the whole surface of the production line plate and from one plate to another

Compactness
In compliance with most stringent specifications
- A578-659-59
- NEF EN 10160 class S3 and E4

STANDARDS

NFA 36 800 - 1 class CLA (France)
Mil A 12560 Class 3 (USA)
TL 2350 0001 (Germany)
Def Stan 95-13 (UK)

METALLURGICAL PROPERTIES

- Low alloyed steel with 0.25% C & Ni-Cr-Mo-V
- Hardness < 400 HB
- Quenched & Tempered at high temperature

MECHANICAL PROPERTIES TYPICAL VALUES*

<table>
<thead>
<tr>
<th>HB</th>
<th>YS (MPa)</th>
<th>TS (MPa)</th>
<th>A%</th>
<th>KV T-40°C (J)</th>
</tr>
</thead>
<tbody>
<tr>
<td>240</td>
<td>600</td>
<td>800</td>
<td>12</td>
<td>30</td>
</tr>
<tr>
<td>400</td>
<td>900</td>
<td>1000</td>
<td>20</td>
<td>80</td>
</tr>
</tbody>
</table>

(*) = can be adapted as per customer requirement.

PROCESSING TYPICAL GENERALITIES

Cutting
Standard thermal cutting techniques without any special precautions up to 75 mm

Welding
- EAW 20-10-3
- MIG 18-8 Mo without any pre & post heating

THICKNESS RANGE
13 to 600 mm

WIDTH
From parts 150 x 150 mm up to 3300 mm
Rolled Homogeneous Armor

Applications 240 - 400 HB

MARS® 190 for targets is the reference used for analysis, control of munitions performances and for their qualification.

Strict respect of metallurgical properties in all required thicknesses is followed.

- Exceptional range of thickness from 13 up to 600 mm
- Heavy thicknesses can avoid piling of medium thicknesses and eliminate contact layer reactions during projectile penetration
- Delivery in plates, parts with holes or attachments for handling
Rolled Homogeneous Armor
MARS® 190

**ADVANTAGES**

**Easy processing** (for a wide range of thicknesses), while keeping good and multipurpose ballistic properties for any kind of threat

**Adapted metallurgical properties** according to specific requirements (chemical composition, hardness range, thickness range...)

**Excellent homogeneity and reproducibility**

**Available in different classes:**
- Class 1: for structure with maximum resistance to penetration of armor piercing munitions
- Class 2: for floors with maximum resistance to high rates of shock loading

**STANDARDS**

NFA 36 800 - 1 class CLA (France)
Mil A 12560 Class 1 - 2 & 3 (USA)
TL 2350 0000 - Quality G – L – K – H (Germany)
Def Stan 95 24 – Class 1 & 2 (UK)

---

**MECHANICAL PROPERTIES TYPICAL VALUES**

<table>
<thead>
<tr>
<th></th>
<th>HB</th>
<th>YS (MPa)</th>
<th>TS (MPa)</th>
<th>A%</th>
<th>KV T-40°C (J)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Class 1</td>
<td>240 to 400</td>
<td>600 to 900</td>
<td>800 to 1000</td>
<td>12 to 20</td>
<td>30 to 80</td>
</tr>
<tr>
<td>Class 2</td>
<td>300</td>
<td>700</td>
<td>900</td>
<td>15</td>
<td>70</td>
</tr>
</tbody>
</table>

**PROCESSING TYPICAL GENERALITIES**

<table>
<thead>
<tr>
<th></th>
<th>Cutting</th>
<th>Forming</th>
<th>Welding</th>
</tr>
</thead>
<tbody>
<tr>
<td>Class 1-2</td>
<td>Standard thermal cutting techniques without any special precautions up to 75 mm</td>
<td>R = 5 x Th</td>
<td>EAW 20-10-3 MIG 18-8 Mo without any pre &amp; post heating</td>
</tr>
<tr>
<td></td>
<td>V opening: (2 xR) + (3xTh)</td>
<td></td>
<td>More details in our datasheets</td>
</tr>
</tbody>
</table>

**THICKNESS RANGE**

<table>
<thead>
<tr>
<th></th>
<th>Class 1</th>
<th>Class 2</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>4 to 150 mm</td>
<td>4 to 50 mm</td>
</tr>
</tbody>
</table>

**MAXIMUM WIDTH**

<table>
<thead>
<tr>
<th></th>
<th>Class 1</th>
<th>Class 2</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Up to 3300 mm</td>
<td></td>
</tr>
</tbody>
</table>
Rolled Homogeneous Armor

Applications 240 - 400 HB

MARS® 190 ability to meet all technical requirements makes it a material of choice in the most advanced and modern projects, both medium and heavy vehicles, ships and frigates constructions.

EXAMPLES OF APPLICATIONS

- Medium and heavy tank structures
- Floors for all kinds of vehicles
- Ship and frigate construction
- Observation posts, buildings
Medium Hard Armor (MHA)  
MARS® 220

ADVANTAGES

Optimal ballistic protection against mines and IED explosion thanks to its excellent hardness, toughness and ductility properties

Excellent workability particularly bending and welding for building complex designs used for blast protection. (V shape floor)

Available in two levels of grade:
- For floors and undersides of light and medium vehicles from 4 to 50 mm
- For V shape or underbelly of heavy vehicle, from 50 to 80 mm

STANDARDS

NFA 36 800 - 1 class THD1 (France)  
Mil A 12560 Class 4a (USA)  
TL 2350 0000 - Quality O (Germany)  
Def Stan 95 24 - Class 3a (UK)

MARS® 220 sample 15 mm after blast tests (classified results)

METALLURGICAL PROPERTIES

- Hardness 400 to 480 HB
- Quenched & Tempered at low temperature

<table>
<thead>
<tr>
<th>Thickness Range</th>
<th>Property</th>
<th>HB</th>
<th>YS (MPa)</th>
<th>TS (MPa)</th>
<th>A%</th>
<th>KV T-40°C (J)</th>
<th>C eq</th>
</tr>
</thead>
<tbody>
<tr>
<td>From 4 to 50 mm</td>
<td>Low alloyed steel with 0.19 % C &amp; Ni</td>
<td>440</td>
<td>1150</td>
<td>1450</td>
<td>13</td>
<td>48</td>
<td>0.5</td>
</tr>
<tr>
<td>From 50 to 80 mm</td>
<td>Low alloyed steel with 0.22 % C &amp; Ni-Cr</td>
<td>440</td>
<td>&gt;800</td>
<td>&gt;1300</td>
<td>&gt;9</td>
<td>&gt;20</td>
<td>1</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES TYPICAL VALUES

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hardness (HB)</td>
<td>400 to 480</td>
</tr>
<tr>
<td>Yield Strength (YS)</td>
<td>1150</td>
</tr>
<tr>
<td>Tensile Strength (TS)</td>
<td>1450</td>
</tr>
<tr>
<td>Impact Energy (KV)</td>
<td>&gt;800</td>
</tr>
<tr>
<td>Charpy Value (Ceq)</td>
<td>&gt;1300</td>
</tr>
<tr>
<td>Temperature (T-40°C)</td>
<td>&gt;48</td>
</tr>
</tbody>
</table>

PROCESSING TYPICAL GENERALITIES

<table>
<thead>
<tr>
<th>Process</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cutting</td>
<td>Standard thermal cutting techniques without any special precautions up to 50 mm</td>
</tr>
<tr>
<td>Forming</td>
<td>R = 5 x th up to 8 mm</td>
</tr>
<tr>
<td></td>
<td>R = 6 x th up to 16 mm</td>
</tr>
<tr>
<td></td>
<td>V opening : (2 xR) + (3xTh)</td>
</tr>
<tr>
<td>Welding</td>
<td>EAW 20-10-3 MIG 18-8 Mo without any pre &amp; post heating</td>
</tr>
</tbody>
</table>

THICKNESS RANGE

From 4 to 80 mm

MAXIMUM WIDTH

2500 mm

MARS® 220 thick underbelly plates for heavy vehicle floor
Medium Hard Armor (MHA)

Applications 440 HB

MARS® 220 has been qualified by the military as preferred material due to its remarkable resistance to blast during testing on prototypes.

Floors structure from light vehicles up to heavy tanks, add-on armour plates to upgrade existing floor, Mars® 220 replies easily to any undersides configurations.

- Blast and IED protection
- V shape floors for light and medium vehicles
- Bottom sides of medium vehicles
- Underbelly for heavy tank
- Add-on armor on existing floor
High Hard Armor (HHA)
MARS® 240

ADVANTAGES

Well balanced solution between workability and weight saving used in military and civil applications

Tight tolerances (+/-0.2 mm) from very thin thickness 2.5 mm up to medium thickness

Excellent flatness and homogeneity, Mars® 240 sheets are delivered with a guaranteed flatness of 3 mm/m and uniformity of mechanical properties throughout the material

Specific civil levels (FB5 & FB6), special grade (S) has been developed to meet civil market needs

STANDARDS

NFA 36 800 - 1 class THD2 (France)
Mil A 46100 (USA)
TL 2350 0000 - Quality Z(Germany)
Def Stan 95 24 - Class 3 (UK)

METALLURGICAL PROPERTIES

| MARS® 240 | Low alloyed steel with 0.28 % C & Ni-Cr-Mo |

MECHANICAL PROPERTIES TYPICAL VALUES

<table>
<thead>
<tr>
<th>HB (MPa)</th>
<th>YS (MPa)</th>
<th>TS (MPa)</th>
<th>A%</th>
<th>KV T-40°C (J)</th>
<th>C eq</th>
</tr>
</thead>
<tbody>
<tr>
<td>495</td>
<td>1300</td>
<td>1700</td>
<td>12</td>
<td>28</td>
<td>0.7 to 0.9</td>
</tr>
</tbody>
</table>

PROCESSING TYPICAL GENERALITIES

<table>
<thead>
<tr>
<th>Cutting</th>
<th>Forming</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard thermal cutting techniques without any special precautions up to 20 mm</td>
<td></td>
</tr>
<tr>
<td>R = 8 x th up to 8 mm</td>
<td></td>
</tr>
<tr>
<td>R = 9 x th up to 16 mm</td>
<td></td>
</tr>
<tr>
<td>V opening : (2 xR) + (3xTh)</td>
<td></td>
</tr>
<tr>
<td>EAW 20-10-3 MIG 18-8 Mo without any pre &amp; post heating up to 20 mm</td>
<td></td>
</tr>
</tbody>
</table>

THICKNESS RANGE

2.5 to 50 mm in current fabrication > 50 up to 150 mm for specific needs

MAXIMUM WIDTH

2500 mm

Reactive boxes in MARS® 240 starting from 2.5 mm
High Hard Armor (HHA)

Applications 500 HB

Excellent flatness, quiet material (no spring back during cutting) make MARS® 240 a perfect 500 HB solution for all welded constructions, avoiding straightening operations. Tight tolerances permit weight saving, offering the lightest solution for a given level of protection.
ADVANTAGES

600 HB ballistical efficient material

Exceptional performances in penetration resistance making it the best solution for weight saving

Easy integration in multi materials and composite solutions with its incredible flatness of 1 mm/m

Available in two classes:
  • Class 1 (600 HB) replying to current UHH specifications
  • Class 2 (630 HB), replying to ultimate standard used the leading experts

STANDARDS

• NFA 36 800 - 1 class THD 4 & 5 (France)
• Mil A 32 332 Class 1 & 2 (USA)
• TL 2350 0000 - Quality T (Germany)
• Def Stan 95 24 – Class 5 (UK)

METALLURGICAL PROPERTIES

• Low alloyed steel with 0.50% C & Ni-Mo
• Hardness 580 to 650 HB
• Quenched & Tempered at low temperature

MECHANICAL PROPERTIES TYPICAL VALUES

<table>
<thead>
<tr>
<th></th>
<th>HB</th>
<th>YS (MPa)</th>
<th>TS (MPa)</th>
<th>A%</th>
<th>KV</th>
<th>T-40°C (J)</th>
<th>C eq</th>
</tr>
</thead>
<tbody>
<tr>
<td>Class 1</td>
<td>605</td>
<td>1500</td>
<td>2200</td>
<td>9</td>
<td>12</td>
<td>0.9</td>
<td></td>
</tr>
<tr>
<td>Class 2</td>
<td>630</td>
<td>1600</td>
<td>2300</td>
<td>7</td>
<td>9</td>
<td>0.9</td>
<td></td>
</tr>
</tbody>
</table>

PROCESSING TYPICAL GENERALITIES

<table>
<thead>
<tr>
<th>Cutting</th>
<th>Forming</th>
<th>Welding</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard thermal cutting techniques without any special precautions up to 13 mm</td>
<td>Not recommended or with specific precautions</td>
<td>Possible with our recommendations</td>
</tr>
</tbody>
</table>

THICKNESS RANGE

3 to 50 mm in current fabrication
> 50 up to 80 mm for specific needs

MAXIMUM WIDTH

2500 mm
Ultra High Hard Armor (UHH)

Applications 600 HB

Mainly in thin plates (typical thickness of 6 mm) from which more than 10000 big size parts have been laser cut, ready to be fitted on vehicles.

Mars® 300 is a MUST for high tech and light solutions.
Ultra High Hard Armor (UHH)
MARS® 300 Perforated

ADVANTAGES

Equivalent to composite solution like ceramic with a much better multi hit capability and easier integration

620 HB material without loss or heat affected zone from holes drilling operation

Macro and micro perforated concepts where configurations of holes are defined to meet maximum efficiency in terms of caliber ammunition and obliquity of impacts

STANDARDS

NFA 36 800 - 1 class THD 4 & 5 (France)
Mil A 32 332 Class 1 & 2 (USA)
TL 2350 0000 - Quality T (Germany)
Def Stan 95 24 - Class 5 (UK)

METALLURGICAL PROPERTIES

• Low alloyed steel with 0.50 % C & Ni-Mo
• Hardness 580 to 650 HB
• Quenched & Tempered at low temperature

MECHANICAL PROPERTIES TYPICAL VALUES

620 HB

KIT PART FOR TRUCK ROOF

Typical lexicon Holes configuration R & T

PROCESSING TYPICAL GENERALITIES

<table>
<thead>
<tr>
<th>Cutting</th>
<th>Forming</th>
<th>Welding</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard thermal cutting techniques without any special precautions</td>
<td>Not recommended</td>
<td>EAW 20-10-3 MIG 18-8 Mo without any pre &amp; post heating</td>
</tr>
</tbody>
</table>

THICKNESS RANGE

3 to 15 mm

MAXIMUM WIDTH

1600 mm

STANDARD

R ≥ Thickness with T ≥ (R x 1.5)

MICROPERFORATED

R < Thickness with R ≥ (Thickness x 0.5)
Ultra High Hard Armor (UHH)

Applications 620 HB

Projectiles break on impact with the ultra high hard Mars® 300, losing their efficiency and ability to damage the protected structure. Perforated MARS® 300 is a lightweight solution equivalent when used add-on armor.

Perforated MARS® 300 kits are mainly used for light and medium vehicles to improve their protection from a stanag level 2 to stanag level 4.

Perforated MARS® 300 is also used as ventilation grille (engine, cabin).

- Add-on armor on light and medium vehicles
- Kit parts or pieces for specific parts of all vehicles
- Ventilation grilles for all range of vehicles
Ultra High Hard Armor (UHH)

**MARS® 600**

**ADVANTAGES**

New metallurgical concept combining 600 HB hardness level with excellent ductility and toughness close to a 500 HB material. Ultra high hard armor steel with very high ballistic performances and integration possibilities.

First multipurpose 600 HB with an impressive ballistic behavior in terms of deformation capacity, resistance to multi-impacts and and best in its class workability (mainly bending).

**STANDARDS**

NFA 36 800 - 1 class THD 4 (France)
Mil A 32 332 Class 1 (USA)
TL 2350 0000 - Quality T (Germany)
Def Stan 95 24 - Class 5 (UK)

**METALLURGICAL PROPERTIES**

- Low alloyed steel with 0.43 % C & Ni-Mo
- Hardness 580 to 650 HB
- Quenched & Tempered at low temperature

**MECHANICAL PROPERTIES TYPICAL VALUES**

<table>
<thead>
<tr>
<th>HB</th>
<th>YS (MPa)</th>
<th>TS (MPa)</th>
<th>A%</th>
<th>KV T-40°C (J)</th>
<th>C eq</th>
</tr>
</thead>
<tbody>
<tr>
<td>601</td>
<td>1500</td>
<td>2100</td>
<td>10</td>
<td>23</td>
<td>0.75</td>
</tr>
</tbody>
</table>

**PROCESSING TYPICAL GENERALITIES**

- Standard thermal cutting techniques without any special precautions
- R = 12 x th up to 6 mm
- R = 14 x th ≥ 6 mm
- Preparation necessary
- V opening : (2 xR) + (3 xTh)
- 307 (18.8) or 20 10 3
- Welding recommendations must be followed

**THICKNESS RANGE**

3 to 15 mm - Extension possible

**MAXIMUM WIDTH**

2500 mm
Ultra High Hard Armor (UHH)

Applications 600 HB

Mars® 600 is the material of the future that is changing designs of military programs: light weight solution and possible use as a structure. Its great properties offer limitless usage possibilities.

What users say about MARS®600:

« MARS® 600 is not a 600 HB standard, it is MARS® 600 »
(France – 10-2014)

« We have never seen such multi hit capability for a 600 HB »
(Switzerland – 03-2014)

« MARS® 600 is a new solution that we have not until now had »
(Germany – 07-2014)

Examples of Applications

- Light & medium modern vehicle structures
- Cold formed parts for light and medium vehicles
- Solid add-on armor with space
- Front layer of composite solutions
- Insert for individual protection
Where to find our steels

From our production sites

1- INDUSTEEL BELGIUM
266, rue de Châtelet
Marchienne-au-Pont
BELGIUM 6030
Tel: + 32 71 44 16 99

2- INDUSTEEL FRANCE
Le Creusot plant
56, rue Clémenceau – BP 19
F – 71201 LE CREUSOT Cedex
Tel: + 33 3 85 80 53 02

3- Châteauneuf plant
BP 368 Châteauneuf
42803 RIVE-DE-GIER Cedex
Tel: + 33 4 77 75 21 41

From our Mars® distributors

4- URSSA
Aceros Especiales
Calle La Forja, 20
08840 Viladecans
Barcelona
SPAIN
Tel: 0034 93.635.70.50

5- ARCELORMITTAL
Dubai Steel Trading co.
Jebel Ali, South Zone
PO Box 8386
Dubai
UNITED ARAB EMIRATES
Tel: 00971 4.803.6666

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