Our Mission & Vision

MISSION Statement

“To support the nation in the long-run with the best technology and quality to take it towards fulfilling the countries need for steel, for building its infrastructure for a developed India.”

VISION Statement

To be the global leader in technology for heavy machine building and steel rolling plants, alongside offering, support, commitment and quality.”

A. R. Group of Industries
Hot Rolling Mills

Hot rolling is a metalworking process that occurs above the re-crystallization temperature of the material. During the process, material is rolled through a number of passes to form the desired shape. The starting material is usually large pieces of metal, like semi-finished casting products, such as slabs, blooms, and billets.

The company has been providing turn-key solutions for rolling mills, from designing, manufacturing and mill commissioning for Bars and Sections.

A R Group design, manufacture and supply rolling mill equipment to its own designs as well as per clients' designs and specifications, ensuring complete responsibility and guarantee for attaining the earmarked targets with quality material and first-class workmanship.

Rolling Mills are supplied on turn-key basis which calls for a wide range of activities like preparation of feasibility/project reports, lay out planning, design, manufacture & supply of equipment to successful trial run of the mill.

For finished products like:

- ROUND BARS
- TMT/QST BARS
- SECTION
- WIRE RODS
Bar Mills (TMT / QST Bars)

Bar Mills are set up to produce TMT / QST rods from sizes 8 mm to 40 mm. In these plants the raw material used are Billets. The Billet is passed through various stands to get the desired shape and size. The Bar is then passed through a Quenching system for quenching and self tempering to increase the strengths of the bars. We take up projects for Bar Mills up to 1 Million TPA.

Section Mills

Section mills are used in rolling of structural sections which are used for construction and other applications. These sections are of various shapes and sizes with each having different applications. Sections such as angles, channels, beams and rails.

With international support for roll pass design we can undertake projects for specially designed sections for particular applications.

Wire Rod Mills

Wire rod mills are designed to produce bar sections of smaller sizes up to 5.5 mm. This is produced using a “Wire Rod Block Mill”, which consist of twist free cantilevered stands in a single block which are mounted with tungsten cartridge rolls to ensure the accuracy of size and quality of the section. Our block is designed for rolling speeds up to 90 mps.

The finished section can be in straight lengths or coiled form.
Enhancement of Existing
BAR and SECTION Mills

* Automation of manually carried out activities such as:
  - Automatic cooling beds
  - Magnetic short bar separation
  - Automatic Bar Bundling
  - Automatic Bar Counting
  - Bar Tying

* Improving roll pass designs to improve efficiency in rolling, increasing yield and reducing mis-rolls
* Improving capacities of smaller mills by making changes to existing layouts
* Direct feeding of billet from caster to the mill saving on cost of re-heating the billet.
* Increasing the number of sections rolled in an existing mill.
* Installing WIRE ROD BLOCKS to existing bar mills to produce smaller sections of bars.
**Complete Mill Designs**

Rolling is a metal forming process in which metal stock is passed through a pair of rolls. Rolling is classified according to the temperature of the metal rolled.

Our products are innovative, user-friendly and compact, using quality raw material. We are proud to be associated with the technological pioneers of the industry, which provides strong technical backup to us for manufacturing, erecting and commissioning Hot Rolling Mills. So far, we have executed many turnkey projects related to Hot Rolling Mills, including everything from conception to commissioning stage.

Our range of hot rolling mills are extensively used for shaping large pieces of metal, such as slabs or billets. With a right blend of technology and experience, we have successfully executed various projects for installation of First Rate Machine Tools.
For Bar, Section & Wire

Rod Rolling Mill up to 1 Million TPA

3D View of Complete Mill

A. R. Group of Industries
Mill Drives

In a hot rolling mill the metalworking process occurs above the re-crystallization temperature of the material. During this process the material is rolled through a number of passes to form the desired shape.

To achieve the desired tonnage per hour and the desired sizes and shaped there may be a variation in the number of passes, the size of input material and the speed at which the mill operates. All these factors have an effect on the separating force on the mill rolls, the torque and power required.

In order to achieve smooth rolling it is very essential to have well engineered mill drives.

The material being processed passes through a set of rolls which are fitted in a mill stand. These rolls are connected to a set of drive which consists of the motor, which is coupled to a gear box which is further coupled to a pinion stand which is coupled to the mill stand. Depending on the torque and power to be transmitted a flywheel may also be required.
Flywheel:

A flywheel is a rotating mechanical device that is used to store rotational energy. Flywheels have a significant moment of inertia and thus resist changes in rotational speed. The amount of energy stored in a flywheel is proportional to the square of its rotational speed. Energy is transferred to a flywheel by applying torque to it, thereby increasing its rotational speed, and hence its stored energy.

Reduction Gear Box:

A gear box is installed to transfer energy from one device to another in this case the flywheel or the motor to the pinion stand. The gear box is used to increase torque while reducing the speed.

Pinion Stand:

Installed after the reduction gear box; the pinion stand is 2-Hi or 3-Hi, depending upon the number of rolls in the rolling stand. The purpose of the pinion stand is to transmit the power from the gear box to the mill stand.

Gearbox-cum-Pinion Stand:

A gearbox-cum-pinion stand is a combination of the gearbox and the pinion stand into a single set of housing.
Mill Stands | Hot Rolling Equipment

Mill Stands are the most essential equipment in the rolling mill process, a mill stand is usually fitted with 2 rolls through which the processed bar is passed giving it the required shape through the roll grooving as per the roll pass design. There are various designs of mill stand each having different applications to the rolling process.

Conventional Mill Stands

This consists of a roll stand, mill spindles, a pinion stand, a gear reducer and a motor. In case of constant pass line, the roll stand slides on the surface of the sole plate. In a low speed rolling mill with less than 18 m/sec, the pinion stand and gear reducer from a single unit. A cross pin joint is used for the mill spindle and is supported by the spindle carrier during rolling.
Housing less Stands

Housing less mill stand is a pre-stressed stand which is more rigid than the conventional stands, the housing less stand have rigid roll chocks held together by tension screws. The roll chocks are free floating on two tension screws on each side of the mill stand, one is right hand threaded and another one is left hand threaded. This mechanism insures mathematical opening & closing of the roll gap related to the pass line. The roll changing is easy and much quicker with a roll changing device which pulls out the complete roll changing assembly & replaces the cartridge.

The housing less stands are normally arranged in Horizontal-Vertical no twist arrangement which allows no twist rolling which permits larger reduction and smoother rolling as it eliminates twisting oval into round passes as in the conventional oval-to-round sequence which results in less guide wear and simpler guide design.

Advantages of Housing less Stands

- Saving Installation Space: Compact Stand & Easy Handling
- Easy Operation: Fixed Pass Line (Symmetrical roll gap adjustment) and Easy Roll & Stand Change
- Sufficient Reliability: High Rigidity and Easy Maintenance (Upper equipped mill drive unit and stand lifting actuator)
Cantilever Mill Stands

Cantilever compact stands are employed in a wide range of sizes for a vast variety of applications. Preferred fields of application are:

- 1-strand mill lines in horizontal/vertical arrangement.
- In split intermediate trains of two or more strand mill lines.
- As replacement stand for mill train modifications (e.g. in the event of space probies).
- As refinisher stands in wire rod delivery sections.
- In finishing trains.

Advantages of Cantilever Mill Stands

The cantilever compact stands with roll shafts mounted in floating bearings have the following advantages:

Saving Installation Space: Compact Design and Few Components
Minimizing the Down-Time
Built-in quick roll disconnecting mechanism: Quick Roll Changing
Stand shifting mechanism (Option): Quick Size Changing
One-touch setup mill guide (Option): Quick Guide Setting
Easy Operation: Fixed Pass Line (Symmetrical roll gap adjustment) and Easy Access to rolling stock
Sufficient Reliability: Same level rigidity as the Conventional Mill Stand
Short erection time with low erection costs
Special design features

- Stand types with roll diameters from 160 mm to 900 mm.
- Compact design with low weight.
- Ease of operation and maintenance, no necessity for axial roll ring adjustment.
- Rigid stand construction.
- Large roll shaft diameter (roller bearings).
- Low roll bending.
- Stand of cassette Construction.

Cost benefits:

- Reduced space requirement for the mill;
- No guide troughs between roughing train stands necessary;
- Savings with respect to roll ring machining facilities, as small types are sufficient;
- No change parts such as roll assemblies or complete stands;
- Less spare parts;
- Shorter changing times for roll ring and program changes;
- Less personnel in the stand workshop;
- Higher material yield factor.

Universal Mill Stands

A universal stand is a four way rolling stand used in the rolling of section usually beams, where in the section is shaped from all four sides; the stand has sets of a horizontal & a vertical rolls, each in order to roll and shape the desired section.
No Twist | Wire Rod Block

Lo-Twist Wire Rod Block mill is a single strand mill using cantilevered rolls of small diameter arranged alternatively 45° above the horizontal. The 90° relationship between adjacent rolls eliminates twisting oval into round passes as conventional oval sound sequence, a factor which results in less guide wear and simpler guide design.

The outstanding characteristic of the mill design is simplicity. A cluster of four precision helical gears is used to eliminate the need for mill couplings and spindles. This, before, not only enables smooth operation at all times, but also eliminates a constant source of vibration and gauge variation and reduces the overall maintenance required on the mill.

Furthermore, the elimination of twist contributes significantly to improvement in rod tolerance and ease of operation.

Symmetrical roll parting adjustment is provided by means of eccentric sleeves, which support the roll shafts and the work and drive high-capacity sleeve bearings and are equipped with side arms fitted with swivel nuts and connected by an adjusting screw. Movement of the screw adjusts each roll symmetrically towards or away from the pass line and the adjusting screw itself is accessible, whether the cobble screen is in the open or closed position. The combination of symmetrical parting adjustment and orientation of adjacent stands provides a truly straight and constant pass line.
The no-twist rod mill smaller rolls permit a larger reduction of area than would be obtainable in conventional multi-stand finishing mills, due to reduced spread and increased elongation. These rolls are made of tungsten carbide and extremely wear resistant, resulting in longer maintenance of pass shape and assuring higher production of close tolerance rod between roll dressings.

Entry and delivery guides, mounted on the face of the roll housings, are easily accessible for installation and removal. The guide centers are positioned axially with respect to the center of the pass groove and vertically with respect to the pass line by precision slots in the face plate. This reduces the time required to change guides as all guide adjustments are made away from the mill in "targets". A guide which is set in a target is automatically on pass when installed.

Roll pass water is supplied to the manifold on the housing face plate and partially surrounding each roll. Permanently positioned nozzles direct water onto the pass.

All mechanical parts on the finishing mill unit, except for the bevel gears, are interchangeable in any stand. A minimum number of spare stands are, therefore, required for routine maintenance and no set-up stands are needed for roll pass changes, two points which can make an obvious contribution to maintenance and operating economics.
Quenching System

Quenching is the rapid cooling of a workpiece to obtain certain material properties. It prevents low-temperature processes such as phase transformations, from occurring by only providing a narrow window of time in which the reaction is thermodynamically favourable and kinetically accessible. The quenching process reduces the crystallinity and the increases toughness of the metal.

The Quenching Box is designed to provide the best possible Thermo Mechanical Treatment that enhances corrosion resistance as well as mechanical properties including Bending, Tensile strength, Yield Stress, Elongation.

It helps in delivering TMT plus bars with higher meterage per unit weight, thus providing for superior cost savings. Based on latest technology support, the complete system comprises quenching box featuring high pressure injectors & strip direct drive shear & pinch rolls as well as desired instrumentation support.
Pinch Roll & Tail Breaker

Pinch Roll Assembly consists of two rolls, either supported in bearings on both ends or cantilevers type both roll driven by motor through pinion stands.

Purpose of the pinch rolls is to pull the material (hot billet/bars, strips/sheets) when it has left the stand and pushed into the next stand, quenching box or the next processing equipment.

Tail Breaker is basically a pinch roll with a purpose to reduce the bar speed when it has left the stand in order to ensure that the rolling bar stops within the cooling bed length.
Shears

Flying Shears find their use in cutting purpose of bars. Our Shear machines are subject to customization on basis of specification. Equipped to manufacture the most advanced and highly accurate flying shears. We are known for the quality and performance of the machines.

Range of Shears

1. Start Stop flying Shear
2. Continuous Shear
3. Crank Type start stop Flying Shear
4. Crop and Cobble Shear
5. Cold Bar Shear
Slit Rolling Technology

The slitting technology as applied to continuous bar mills enables the production of two or more strands from one billet. Depending on plant configuration the slitting process can be adapted to rolling mills with a minimum of four final stands in continuous installation.

The process gives the following benefits:
- Substantial increase in production
- Reduction in the number of rolling stands
- Reduction in operation costs

The slit rolling process differs from conventional continuous rolling by the use of special roll passes and guides to prepare, shape and longitudinally separate the incoming billet into two or more individual strands for further rolling into the finished size. In principal this process is achieved as follows:
- Reducing the billet conventionally through the roughing and intermediate rolling mill to produce an acceptable section for the first special shaping pass at the forming stand.
- Precise guidance of this stock to the forming stand where it is reduced and shaped to form a symmetrical "forming section".
- Further close guidance and control of the "dog bone" through the separating stand, were the stock is reduced and shaped into a "slit pass", designed to be easily separated into two equal sections of false round.
- A special guide on the delivery side of the separating stand ensures a clean slitting of the bar and now delivers multiple strand of equal sections to their respective finishing lines.
Post Rolling Equipments & Mill Accessories

There are various levels of automation for handling of rolled products. These are post rolling processes from cutting of rolled product up to full automation of loading the product on to dispatch vehicles.

Post rolling shears are used to cut the rolled product into desired sizes and are customized on the basis of speed. They then move on to the automatic cooling bed through twin chain or braking slides.

Post this there are various optional additions such as bar cutting machines, bar typing machines, chain transfers and short ejection systems.

Magnetic mechanism is used for ejection of short bars; similarly magnetic mechanism is used for loading of finished products on to the dispatch vehicle.

We provide complete solutions for post rolling processes and expertise in converting manual handling of bars to automatic handling.
Cooling Bed

The cooling beds are used to uniformly air-cool the bars & profiles and transporting the same in a phased manner from the entry to discharge side. Our cooling beds are specifically designed considering the smallest and the maximum size of the bars being rolled. These cooling systems provide adjustability to the size, shape, and alloy of the profiles with appropriate cooling rate and minimized distortion. This result is high quality profiles and throughput.
Twin Channel

The twin channel is used to collect the TMT bars leaving the Quenching boxes after being sheared by the Flying Shear in two strands. These channel comprises of CI central box, water cooled to prevent warping during rolling, and C-type CI channels which are suspended from a longitudinal structural. The closed C-type channels ensure highest level safety during the operation. This is an excellent system as the bar is carried in the close channel, minimizing the risk of accident. It is the most desirable feature in a high speed rolling system.

Twin Channel at Wave Industries, Dhanora

High Speed Bar Collection System: In case of higher capacity mills, when the finishing speed of the bar is high, the twin channel is replaced with a high speed bar collection system: a drop wall system or a rotating twin channel which can receive more than one finished bar simultaneously.
Other Mill Accessories

Bar Tying Machine: The machine is used to tie the bundle of finished products after rolling and cutting to desire sizes. The desired numbers of bars are bundled together depending upon the weight of the desired bundle.

Roller Tables: Roller tables are conveyor tables, and are installed between stands and the next required process to the bar.

Bar Counter: The machine is installed after shearing of the bar and before the bundling area to automatically count the number of bars to be packed in one bundle.

Reforming Station: Coil collection in the finishing area that collects the coils.

Other Equipments:
- G-Hook conveyor system
- Coil Compactor
- Laying Head
- Coilers
Cold Rolling Mills

Cold rolling occurs with the metal below its recrystallization temperature (usually at room temperature), which increases the strength via strain hardening up to 20%. It also improves the surface finish and holds tighter tolerances. Commonly cold-rolled products include sheets, strips, bars, and rods; these products are usually smaller than the same products that are hot rolled. Because of the smaller size of the workpieces and their greater strength, as compared to hot rolled stock, four-high or cluster mills are used. Cold rolling cannot reduce the thickness of a workpiece as much as hot rolling in a single pass.

Sugar Industry

The company is into manufacturing & supply of equipment to sugar plants. Sugar cane crushing unit consisting of stands and caps are supplied along with their rolls and driving gearbox. Sugar cane transfer conveyors, Reduction Gear Boxes and other equipment on as per the requirement of the customer.
Heavy Machine Building & Fabrication

Heavy Machine Building and Fabrication to custom design as per the required specification for heavy industries like:

1. Power Sector
2. Sugar Industry

For the last 4 decades the company has been building heavy machines and have undertaken heavy fabrication jobs. Our infrastructure and machines have made us the preferred name for major heavy machine builders in the country. Facilities like Horizontal Boring Machines with X-Travel of 9000mm and VTL up to 4000mm we are well equipped to handle machining and fabricating jobs for heavy industries.

We have done jobs for industry leaders, such as Larsen & Toubro Ltd. & TISCO Growth Shop for Steel Plant, Mecon & Flat Products (I) Ltd. for Cold Rolling Mills and BHEL for Power Plants, HINDALCO and ISGEC for Sugar Industry.

Fabrication jobs for MORGAN
Gear and Gear Boxes

A.R. Gears (P) Ltd., is a dedicated gear division, and is known as the leading and most accurate gear and gear box manufacturer in India.

Known for their reliability and performance the gear boxes are well designed to meet industrial applications for various purposes with the combination of design and engineering excellence. We are well equipped to design customized gear boxes. Our European base machines gives accuracy and ensures quality performance of these designs.

Facilities for Gear & Gear Box manufacturing:

1. HOFLER Gear Grinding machines for gears up to 2000 MM & 20 module
2. KISSsoft Gear Design Software
3. Stress relieves and shot blasting
4. Hobbing for up to 5000 mm & 40 Module
5. Advance hard and ground Gear Boxes
6. VTL, WMW, 4Mtrs.
Manufacture Gear Box for:

1. Rolling Mills
2. Sugar Plants
3. Cement Industry
4. Paper Mills
5. Sponge Iron

Range of Gear Boxes

1. Helical Gear Box
2. Worm gear Box
3. Bovol Gear Box
4. Planetary Gear Box
5. Crane Duty Gear Boxes

Crane Duty Gearboxes supplied to HEC, INDIA

A.R. MaxLift is an exclusive range of Crane Duty Gearboxes used in EOT cranes and are designed to work for cranes of heavy lifting loads.
The company has 4 manufacturing workshops which are located in the most valuable industrial area of India’s capital city New Delhi and neighbouring regions, having its head office in New Delhi with workforce of 400 employees.

**Machinery Installed:**

Well equipped machine shop with the most advanced and accurate machines including floor type horizontal boring machines from SKODA, WMW and table type horizontal boring machines from WMW, TOS, COLLETT.

We have a large number of gear hobbing machines to obtain most accurate teeth cutting and smooth mating between gears. These include machine from TOS to cut gears up to diameter of 5000 mm & 40 Machine.

Gear grinding machines from HOFLER and WMW having the capability to grind gears up to a maximum diameter of 1500 mm and 25 module.
Vertical Turner Lathe, WMW for jobs upto 4000mm dia

Skoda Horizontal Boring with X axis of 9000mm

A. R. Group of Industries
Our Technology | AR Engineering

We have experienced workmen and supervision our workshops and an advanced design department along with good facilities for Quality Control and Inspection. Our practice is to make out, if required, Quality Assurance Plans along with customers. We have our own equipment for Ultrasonic testing and other kinds of nondestructive testing as required.

Our works at New Delhi & Ghaziabad are well equipped with sophisticated Plant and Machinery manned by well qualified and experienced Engineers and Technical Staff.

With the help of the infrastructure available, well equipped plant, highly qualified and experienced staff and application of latest technology, we are well poised to produce good quality equipment and also we can execute our orders in the shortest delivery time compared to other equipment Manufacturers in the country.
Maintenance Department

ERP software PRIMO to increase efficiency in operations.

Highly skilled machine engineers to ensure accuracy of machines.
Each manufacturing unit has its own in-house quality control laboratories for testing of raw material and finished goods, and have the necessary equipment to test strength, hardness, accuracy and designs.

**Details of Quality Control**

With customers, an agreed Quality Assurance Plan is drawn up for compliance & to follow up the inspection procedure.

1. Casting, Forging & Rolled stock are proof machined and then subjected to Ultrasonic Testing. Material found O.K. in UST, are accepted for further processing. We have got in house facilities for testing, however third party testing is also carried out.

2. Non Destructive & Tensile testing on test pieces from cast / forged items are carried out. At Govt. Authorized Test Houses.

3. Chemical Test - Wet method or on spectrometer is also done at a Govt. Authorized Test House.

4. Hardness Testing is carried out as a rule by us on all jobs.

5. Vendors for Casting and Forgings are selected who have facilities for testing mentioned at sr. no. '3' & '4' above.

6. Measurements are done for dimensional and positional accuracies as per drawing and relevant standards.

7. Stress relieving after rough machining, is carried out, for some critical items.

8. Fabrication/Welding work is usually carried out in accordance with welding procedures as specified by Indian & International standard. Fabrications are thermally stress relieved by proper heating & cooling cycle. Vibratory Stress Relieving is also carried out, in large components which cannot be accommodated in furnace.
A dedicated team of design engineers, with the constant effort towards improvisation and development of the most advanced designs for engineering products and steel manufacturing machinery.

1. Complete CAD designing facilities and highly qualified design engineers & draft man using AUTOCAD.
2. 3D modeling on AUTOdesk, 3D MAX and SOLID works.
3. Gear designing on kiss soft.
Technology Partners

Over the years, A.R Group has made technological advancements to equipment designs with the support of European technology partners. We have partnered with highly experienced engineering design companies in Germany, England, Canada and USA to committed to our long-run mission of offering the most advanced technology and quality equipment towards the infrastructure needs of the nation.

We manufacture flying shears under the license of H&K India, to cut Thermex QST bars.

Burkhard Heht Consulting

Mr. Burkhard Heht is a highly qualified engineer and has an experience of nearly 40 years and worked for rolling mills all across the world. He is a consultant to A.R Engineering Works for Steel Rolling Mill, for the most advanced German technologies and rolling mill efficiencies.
PH Engineering Design Limited in the U.K. provides technical consultancy and engineering design to steel producers around the world.

Managing Director Mr. Paul Hartley is a Fellow of the Institute of Engineering Designers, a member of the Charter of Engineering Institutes and a Registered Engineering Designer. With over 30 years experience in the steel industry his expertise in steel production is unsurpassed.

The company's mission is to provide cost effective energy efficient technology to the steel sector in order to improve productivity, efficiency and yield. Its aim is to ensure business requirements are achieved within budget.

Deployment and support services are part of each project undertaken with our partners to upgrade plant and equipment and adapt machinery to suit specific requirements to provide lowest capital costs and the shortest time period from order to commissioning.
A.R Engineering has collaborated with Schweitzer Rolling Technology for roll pass design including detailed groove drawing, roll stress calculations and roller set-up sheets.

Schweitzer Rolling Technology offers the highest quality roll pass design to ferrous and non-ferrous hot rolling mills. Services include: roll pass design reviews; productivity studies and training for mill operations, roll designers, and mill set-up personnel, in both roll pass design theory and mill operation; and mill audits.

Well known and highly visible in the market, we have a reputation for providing expert pass designs for the most difficult to produce sections. We guarantee fast personable service at a reasonable price.

Our experience enables us to understand your requirements and exceed your expectations in creating or improving your rolling process. Drawing on a network of engineers and designers from many disciplines, including mechanical engineering, metallurgy, gear drive design, and mill operations, we have the expertise you require to improve the performance and operation of your facility.
Over 50 years of experience on Hot and cold Rolling Mills for carbon, stainless steel, and non-ferrous Rolling Mills. Our precision cold rolling mills have name brand recognition worldwide for gauge accuracy, flatness of strip shape, and ultrathin gauge. Before 90% of the world’s stainless steel strip is used, it is precision rolled to exact thickness using Sendzimir rolling technology — no matter whether it is produced in the USA, Japan, Taiwan, Korea, Thailand, Europe, India, Australia, or South Africa.

T. Sendzimir, Inc. designs and builds high quality rolling mills and various sub-assemblies for 20-High ZR™ Mills and Z-Highs™ such as retrofits to existing rolling mills and new wiping systems for all mills.

A.R Engineering has partnered with Sendzimir Mills for design support for Cold Rolling Mills and to market Sendzimir Mills in India and the Middle-East.
A R GROUP OF INDUSTRIES
Our Valued Customers

INDIA

- TATA Steels
- Jindal Steels
- Essar Steels
- Steel Authority of India
- BHEL – Bharat Heavy Electric Limited
- Shivam India, Durgapur
- Adhunik Ispat, Durgapur
- Amba Steels, Muzaffarnagar
- Aggarwal Iron Foundary, Hyderabad
- Jai Bharat Rolling Mill, Kale Aam
- Varsana Ispat, Gandhidham
- H & K Rolling Mill Engineers, Mumbai
- Global Smelters, Kanpur
- Vinayak Steels, Hyderabad
- Shree Rathi Dakshin, Bhiwadi
- Welspun Steel, Ahmedabad
- MECON
- Vizag Steels
- M. N Dastur
- SMS DEMAG
OVERSEAS

- INTEGRATED STEEL CO., Nigeria (DANGOTE GROUP)
- AMBE STEEL, Nepal
- MANAKSIA STEEL, Georgia
- GTB, COLOMBO, Srilanka
- ASHOK STEELS, Kathmandu Nepal
- Monarch Steels, Nigeria
- Rathi Steels, Nigeria

A. R. Group of Industries