



Specialized in manufacturing
Foundry Ladles
铸造用浇包



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GONGYOU GROUP

工友集团

COMPANY INTRODUCTION

Wei Hai Gongyou Foundry Machinery Co.,Ltd is the subsidiary company of Shandong Gongyou Group Co., Ltd, which is located in the beautiful seashore city—Eihai ,Shandong Province, China . For over thirty years, we are specialized in manufacturing of foundry ladles which have been widely used in the world. As the primary goal, we provide perfect products and services for customers.

Our products consist of casting ladles, transfer ladles, pouring ladles, ladle lining forming mold and ladle pre-heaters. The capacity of the ladle is range from 100 kg to 90000 kg (90 tons).

All the time, we lead the trend of ladle designing and manufacturing. We can not only provide standard capacity of the ladle, but also can meet customer's special requirements for design and manufacture of products.

Hope for your good cooperation!

May our products create value for you!



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(I) Casting/Transfer Ladle

① Lip pouring ladle

We are offering wild range of ladle capacity vary from 0.3t to 90t ,we also manufacture ladles based on client's requirements.

All foundry ladles can be fitted with a motor gear assembly for powered rotation.The rotation speeds can be adjust customer's requirements.

● Foundry ladle--manual drive

Parameter			
Capacity (t)	DIA (mm)	HGT (mm)	Overall dimensions (mm)
0.3	520	540	1100×705×1420
0.5	604	590	1160×780×1445
0.75	670	640	1220×860×1470
1	730	740	1340×990×1670
1.5	820	863	1425×1060×1725
2	908	903	1510×1175×1910
2.5	995	980	1590×1270×2015
3	1042	1025	1770×1340×2205
4	1140	1120	1855×1440×2350
5	1250	1230	2020×1548×2400
6	1310	1300	2150×1610×2900
7	1390	1410	2225×1690×2950
8	1446	1425	2250×1816×3055
10	1544	1592	2520×1915×3225
12	1670	1680	2645×2050×3265
15	1770	1841	3040×2160×3615
20	1960	2100	3220×2360×4005
25	2120	2160	3745×2860×4340
30	2274	2335	3895×3020×4565



● Foundry ladle with motorized gearing



Parameter

Capacity (t)	DIA (mm)	HGT (mm)	Overall dimensions (mm)
5	1250	1230	2030 × 1548 × 2410
6	1310	1300	2280 × 1600 × 2750
8	1446	1425	2455 × 1816 × 3055
10	1544	1592	2580 × 1915 × 3225
15	1770	1841	2800 × 2160 × 3615
16	1796	1834	2885 × 2190 × 3605
20	1960	2100	3220 × 2360 × 4005
25	2120	2160	3585 × 2860 × 4340
30	2274	2335	3740 × 3020 × 4565
35	2397	2435	4100 × 3100 × 4900
40	2480	2520	4170 × 3200 × 4950
45	2592	2640	4300 × 3450 × 5550
50	2670	2730	4390 × 3300 × 5770
55	2740	2900	4500 × 3500 × 6100
60	2780	3150	4700 × 3560 × 6800
70	2890	3300	4950 × 3600 × 6800
75	2910	3500	5000 × 3680 × 6900
90	3292	3680	5500 × 3800 × 7500

② Teapot Spout Ladle

● Teapot Spout Ladle- manual drive



Parameter

Capacity (t)	DIA (mm)	HGT (mm)	Overall dimensions (mm)
0.5	630	720	1200 × 950 × 1495
1	725	910	1345 × 1085 × 1775
2	880	1090	1520 × 1310 × 1995
3	1060	1230	1740 × 1490 × 2320
4	1140	1320	1820 × 1650 × 2485
5	1240	1420	1920 × 1780 × 2510
6	1408	1440	2100 × 1880 × 2850
8	1450	1560	2310 × 1995 × 3120
10	1600	1780	2570 × 2180 × 3340
15	1770	1841	3040 × 2285 × 3715
20	1960	2100	2965 × 2700 × 4050
25	2100	2230	3498 × 2810 × 4420
30	2220	2600	3555 × 2905 × 4780

● Teapot Spout Ladle with motorized gearing



Parameter

Capacity (t)	DIA (mm)	HGT (mm)	Overall dimensions (mm)
8	1450	1560	2390 × 1995 × 3120
10	1600	1780	2620 × 2180 × 3340
15	1770	1841	2800 × 2285 × 3715
20	1960	2100	3010 × 2700 × 4050
25	2100	2230	3550 × 2810 × 4420
30	2220	2600	3660 × 2905 × 4780

Notes: The spout can be made on the basis of your requirements.

(II) Treatment Ladle

① Ductile Iron Treatment Ladle

● Open Top Ladle

Parameter

Capacity (t)	DIA (mm)	HGT (mm)	Overall dimensions (mm)	Remarks
0.3	520	676	1100 × 720 × 1480	Manual
0.5	590	768	1170 × 790 × 1510	Manual
0.75	660	858	1240 × 860 × 1670	Manual
1	710	924	1330 × 950 × 1910	Manual
1.5	800	1040	1420 × 1040 × 2055	Manual
2	880	1144	1500 × 1180 × 2200	Manual
2.5	930	1210	1610 × 1230 × 2350	Manual
3	1010	1320	1690 × 1310 × 2470	Manual
4	1100	1430	1780 × 1400 × 2610	Manual
5	1200	1500	1980 × 1500 × 2820	Manual
			2040 × 1500 × 2820	Motor-driven
8	1360	1700	2375 × 1730 × 3320	Manual
			2435 × 1730 × 3320	Motor-driven
10	1480	1850	2485 × 1850 × 3525	Manual
			2545 × 1850 × 3525	Motor-driven
15	1700	2080	2980 × 2070 × 4010	Manual
			2820 × 2070 × 4010	Motor-driven
20	1920	2304	3205 × 2320 × 4365	Manual
			3040 × 2320 × 4365	Motor-driven
25	2020	2450	3685 × 2700 × 4790	Manual
			3535 × 2700 × 4790	Motor-driven
30	2150	2600	3820 × 2900 × 5160	Manual
			3660 × 2900 × 5160	Motor-driven
35	2250	2815	4000 × 3050 × 5610	Motor-driven
40	2360	2915	4115 × 3100 × 5680	Motor-driven
50	2522	3215	4280 × 3150 × 5820	Motor-driven
60	2746	3694	5100 × 3200 × 7600	Motor-driven
75	2925	3911	5300 × 3300 × 7650	Motor-driven
90	3050	4250	5500 × 3500 × 8000	Motor-driven



Manual



Motor-driven

● Wire Feed Treatment Ladle —ladles for plunging ductile treatment stations



Manual

Motor-driven

Parameter

Capacity (t)	DIA (mm)	HGT (mm)	Overall dimensions (mm)	Remarks
1	650	1272	1300 × 910 × 2233	Manual
2	820	1350	1470 × 1080 × 2375	Manual
2.5	870	1445	1520 × 1145 × 2417	Manual
5	1082	1725	1920 × 1380 × 2910	Manual
8	1230	2185	2200 × 1630 × 3785	Manual/ Motor-driven
10	1340	2240	2400 × 1710 × 3950	Motor-driven
20	1630	2740	3000 × 2030 × 4720	Motor-driven
25	1784	2940	3365 × 2524 × 5115	Motor-driven
35	1950	3360	3780 × 2650 × 5790	Motor-driven

② Tundish Cover Ladles



③ Porous Plug Desulphurising Ladle

Parameter

Capacity (t)	DIA (mm)	HGT (mm)	Overall dimensions (mm)	Remarks
1	846	1195	1424 × 1060 × 2235	Manual
1.5	934	1277	1500 × 1166 × 2395	Manual
2	1000	1342	1680 × 1290 × 2425	Manual
3	1116	1445	1790 × 1416 × 2670	Manual
4	1220	1570	1900 × 1527 × 2880	Manual
5	1355	1637	2210 × 1650 × 2920	Manual
6	1419	1698	2265 × 1760 × 3185	Manual
7	1480	1757	2410 × 1825 × 3335	Manual
8	1532	1800	2460 × 1880 × 3355	Motor-driven
9	1584	1847	2510 × 1900 × 3445	Motor-driven
10	1818	2050	2840 × 2160 × 3740	Motor-driven
15	1835	2350	2860 × 2200 × 4385	Motor-driven
20	1950	2500	2970 × 2350 × 4600	Motor-driven



(III) Steel Ladle–Bottom Pouring Ladle

① Bottom strick for stopper ladle



② Slide ladle



Parameter				
Capacity (t)	DIA (mm)	HGT (mm)	Overall dimensions (mm)	Remarks
0.5	644	740	1050 × 750 × 1600	Contain the hanger
0.75	710	820	1100 × 810 × 1680	Contain the hanger
1	770	900	1225 × 850 × 1955	Contain the hanger
1.5	870	1000	1425 × 1144 × 2150	Contain the hanger
2	950	1100	1560 × 1160 × 2210	Contain the hanger
2.5	1040	1160	1615 × 1180 × 2430	Contain the hanger
3	1132	1210	1688 × 1382 × 2530	Contain the hanger
4	1224	1330	1710 × 1390 × 2700	Contain the hanger
5	1293	1380	1880 × 1410 × 2865	Contain the hanger
6	1408	1440	1980 × 1510 × 3275	Contain the hanger
7	1460	1650	2080 × 1610 × 3405	Contain the hanger
8	1550	1720	2450 × 1655 × 3510	Contain the hanger
10	1670	1920	2530 × 2190 × 3680	Contain the hanger
12	1740	2030	2600 × 2260 × 3790	Contain the hanger
15	1875	2120	2700 × 2290 × 4150	Contain the hanger
20	2051	2344	2815 × 2390 × 4560	Contain the hanger
25	2128	2460	2888 × 2469 × 4900	Contain the hanger
30	2260	2650	2980 × 2710 × 5140	Contain the hanger
35	2390	2740	3140 × 2860 × 5225	Contain the hanger
40	2460	2780	3250 × 2770 × 5360	Contain the hanger \slide gate nozzle
45	2520	2860	3395 × 3075 × 5435	Contain the hanger \slide gate nozzle
50	2600	2980	3500 × 2680 × 6000	Contain the hanger \slide gate nozzle
60	2657	3100	3560 × 2800 × 6500	Contain the hanger \slide gate nozzle
70	3050	3750	4020 × 3160 × 6980	Contain the hanger \slide gate nozzle
90	3230	3800	4500 × 3230	Contain the hanger \slide gate nozzle
120	3400	4000	4650 × 3400	Contain the hanger \slide gate nozzle
150	3604	4250	4900 × 4400	Contain the hanger \slide gate nozzle

③ Dual Ladle-Bottom Pouring and Lip Pouring



Manual



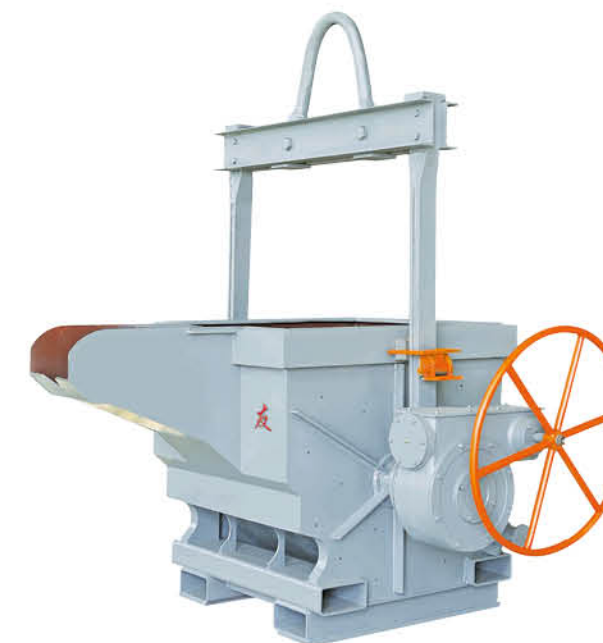
Motor-driven

Parameter

Capacity (t)	DIA (mm)	HGT (mm)	Overall dimensions (mm)	Remarks
0.5	644	740	1230 × 750 × 1600	Manual
0.75	710	820	1300 × 820 × 1640	Manual
1	770	900	1390 × 850 × 1955	Manual
1.5	870	1000	1490 × 1144 × 2150	Manual
2	950	1100	1600 × 1160 × 2210	Manual
2.5	1040	1160	1680 × 1180 × 2430	Manual
3	1132	1210	1800 × 1382 × 2530	Manual/ Motor-driven
4	1224	1330	1900 × 1390 × 2700	Manual/ Motor-driven
5	1293	1380	1970 × 1410 × 2865	Manual/ Motor-driven
6	1408	1440	2275 × 1510 × 3275	Manual/ Motor-driven
7	1460	1650	2335 × 1570 × 3470	Manual/ Motor-driven
8	1550	1720	2450 × 1655 × 3510	Manual/ Motor-driven
10	1670	1920	2560 × 2190 × 3680	Manual/ Motor-driven
12	1740	2030	2610 × 2250 × 3740	Manual/ Motor-driven
15	1875	2120	2650 × 2290 × 4680	Manual/ Motor-driven
20	2051	2344	2830 × 2450 × 4560	Manual/ Motor-driven
25	2128	2460	3650 × 2560 × 4650	Manual/ Motor-driven
30	2260	2650	3740 × 2630 × 4730	Manual/ Motor-driven

(IV) Special Ladles

① Forklift Track Ladle



② Ladle with a Bed



③ Manual Crane Foundry Ladle



Rack and pinion



Worm and worm wheel rack type

Parameter (Manual up and down)

Capacity (Kg)	DIA (mm)	HGT (mm)	Movements itinerary (mm)	Remarks
50	300	320	650-1100	Rack and pinion
100	360	390	650-1100	Rack and pinion
150	390	450	650-1100	Rack and pinion
200	420	470	650-1100	Worm and worm wheel rack type
250	440	520	650-1100	Worm and worm wheel rack type
300	470	550	650-1100	Worm and worm wheel rack type
350	500	570	650-1100	Worm and worm wheel rack type
400	540	580	650-1100	Worm and worm wheel rack type

Parameter (Motor-driven raising)

Capacity (Kg)	DIA (mm)	HGT (mm)	Movements itinerary (mm)	Lifting speed (m/min)
150	390	450	670-950	4.89
200	420	470	670-950	4.89
250	440	520	670-950	4.89
300	470	550	670-950	4.89
350	500	570	670-950	3.66
400	540	580	670-950	3.66

④ Molten Aluminum Ladle



Parameter

Capacity (Kg)	DIA (mm)	HGT (mm)	Overall dimensions (mm)
100	550	560	1130×710×1255
250	700	710	1280×870×1420
300	740	750	1320×910×1510
400	830	840	1410×1010×1660
500	870	890	1490×1070×1760
600	908	920	1520×1100×1920
750	960	950	1570×1180×1940
800	980	970	1600×1210×1950
1500	1230	1220	1910×1460×2250

(V) Refractory Mould (Lining Formers for Ladles)



Notes: The spout can be made on the basis of your requirements.

(VI) Ladle Pre-heaters



- Used for Refractory Preheating and Baking
- Gas:Natural gas/Liquefied petroleum gas
- The heating-rate curve can be predetermined.

(VII) Charging Bucket for Arc Furnace

- Used for Electric Arc Furnace charging
- Its bottom can be opened with “clam shell” doors.

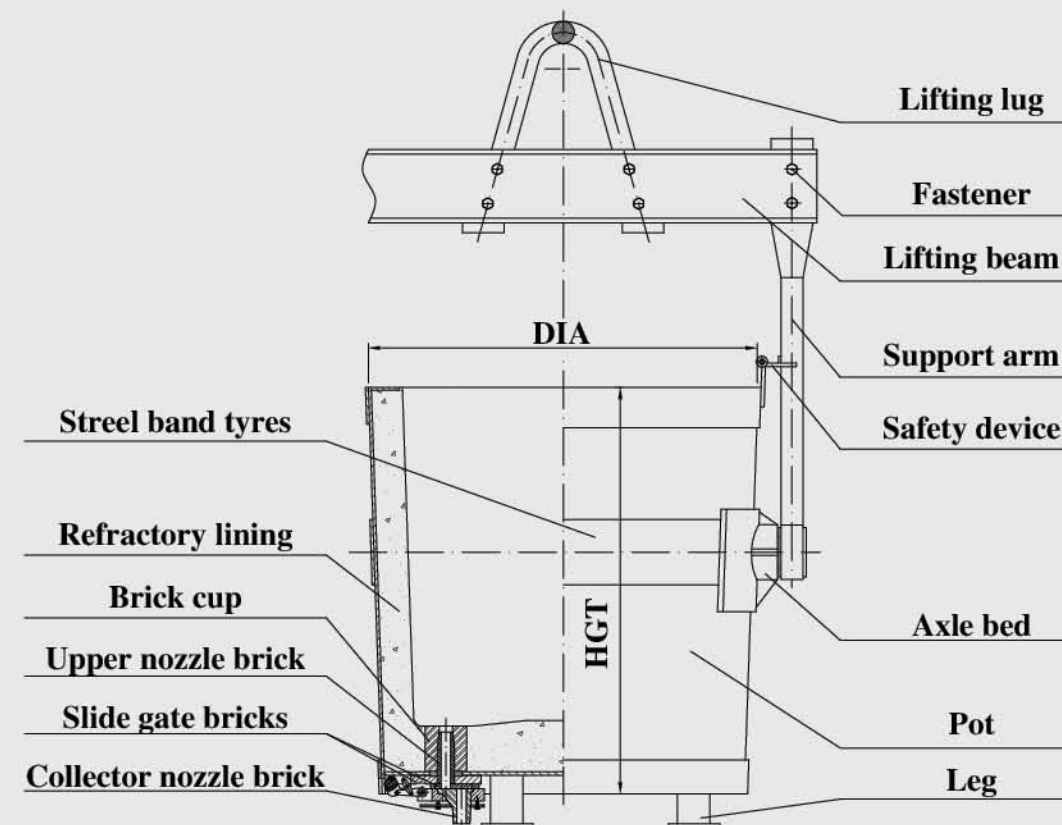
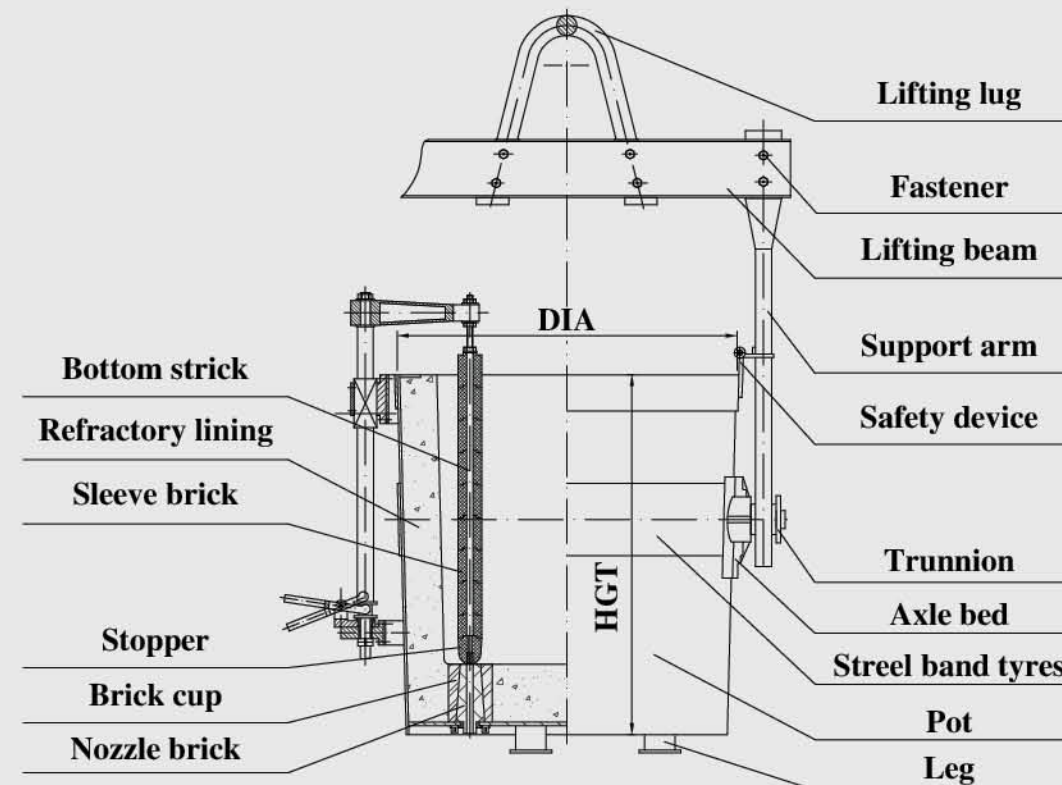
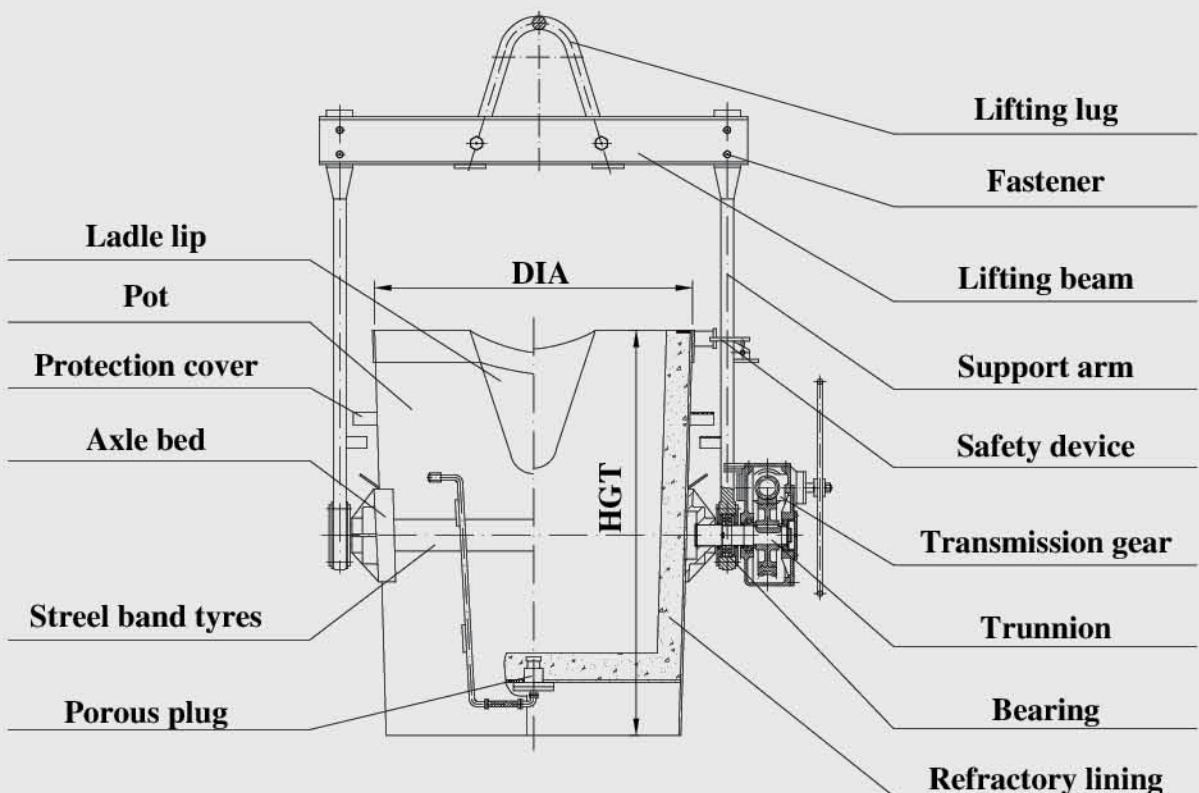
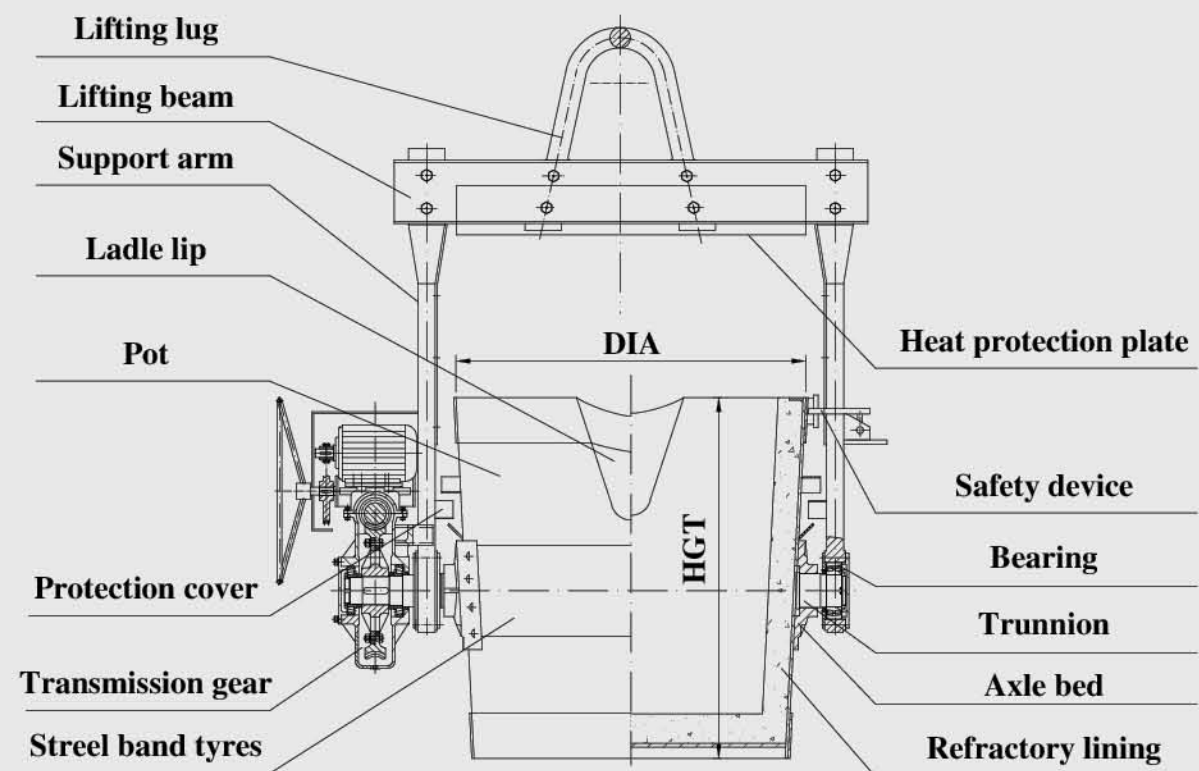


(VIII) Annular Casting Line

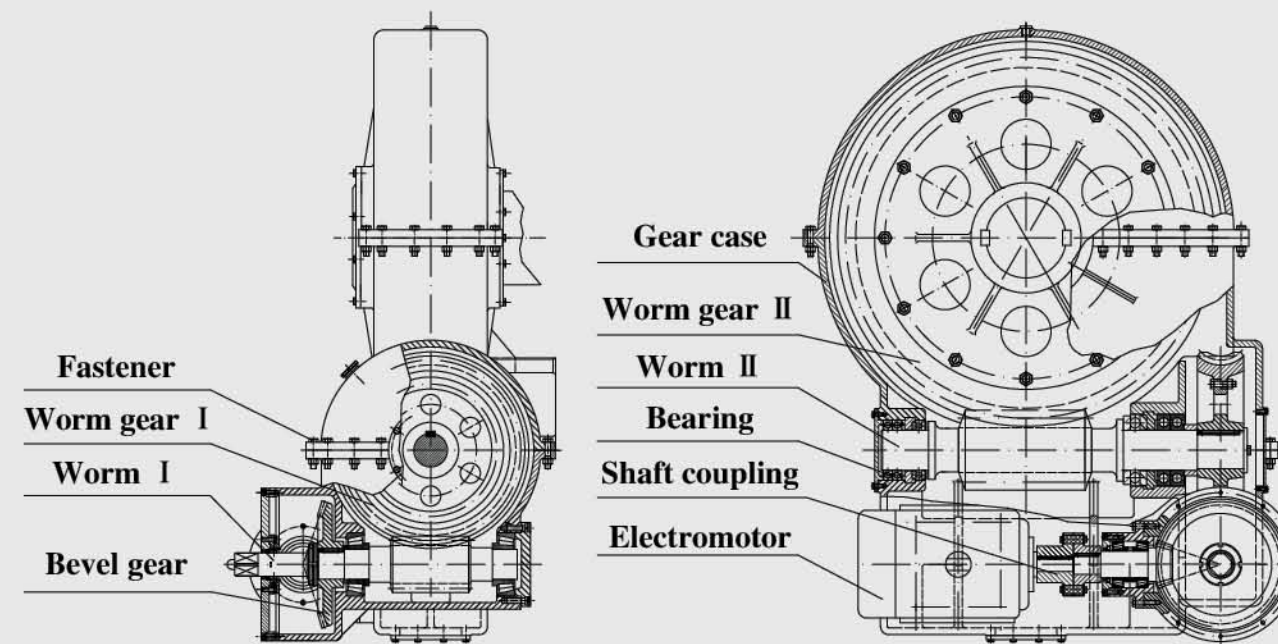
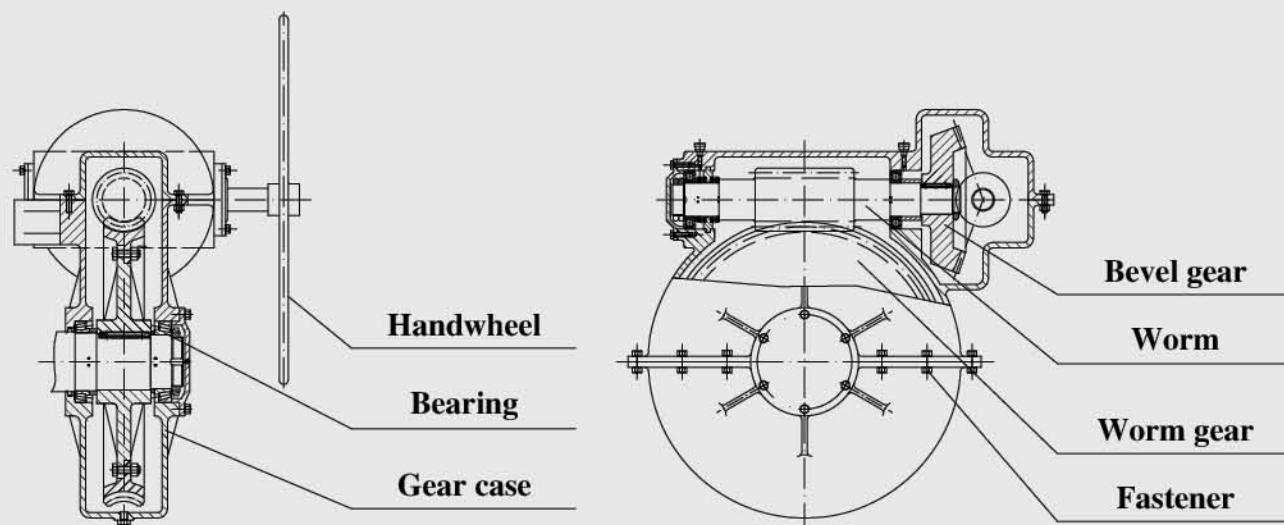


Notes:The casting line can be made on the basis of your requirements.

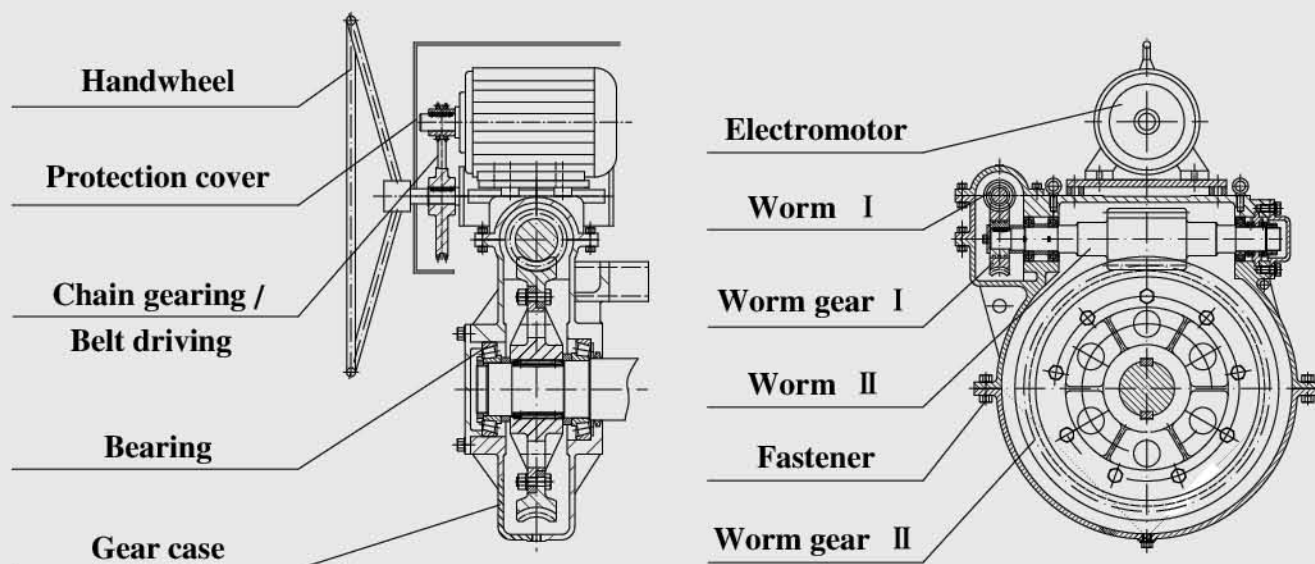
Ladles Structure:



Transmission Gear:



The transmission mechanism is made up primarily of worm and worm gear, which can be self-locking. Without electric or handwheel process, the ladle is irreversible, it can be safe self-locking, not automatically reactive and avoid shaking.



The client instance

