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Conventional melting (EF+LF+VD)

GENERAL:

- oil-hardened and air-quenched PM steel with good full hardened properties
- toughness
- resistance to heat, also to be used as cold work steel
- suitable for pitting and chrome plating
- polishable

APPLICATIONS:

- extruder tools , - support tools, - die holders
- large moulds for the processing of thermoplastics
- pressing spindles
- shrink rings

CHEMICAL ANALYSIS: %

C	Si	Mn	P	S	Cr	Mo	Ni	V
0,50 - 0,60	0,15 - 0,35	0,50 - 0,80	≤ 0,025	≤ 0,025	0,60 - 0,80	0,25 - 0,35	1,50 - 1,80	0,07 - 0,12

PHYSICAL PROPERTIES:

Coefficient of thermal expansion	20-100 °C	20-200 °C	20-300 °C	20-400 °C	20-500 °C
[10 ⁻⁶ m/(m x K)]	11,8	12,7	13,3	14,0	14,3
Thermal conductivity	20 °C	350 °C	700 °C		
[W/(m x K)]	37,5	36,0	32,5		

ULTRASONIC:

ASTM A388 - FBH max. 6 mm (1/4 inch) or
 SEP 1921 – test group 3 – class C , c or
 acc. to your request

CLEANLINESS:

ASTM E45- Method A with type A ≤ 1,5 ,
 B; C and D each ≤ 2 or
 DIN 50602– K4 ≤ 30 or
 acc. to your request

DELIVERY CONDITION:

hardened and tempered

SERVICE HARDNESS:

310 – 345 HB or acc. to your request

STRUCTURE:

fine bainitic structure



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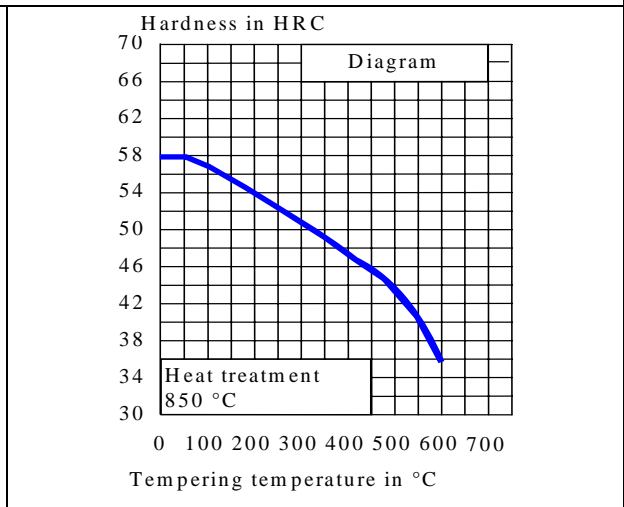
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HEAT TREATMENT:

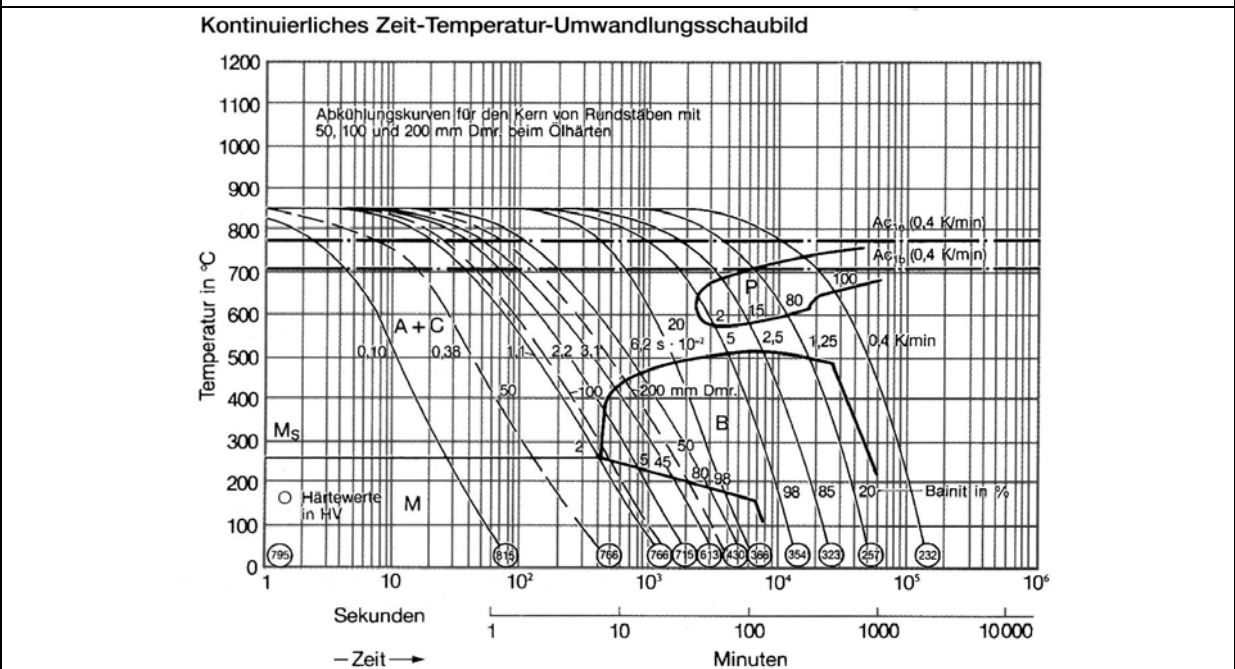
<i>Hot forming</i>	<i>Soft annealing</i>	<i>Hardening</i>	<i>Tempering</i>
1100 – 850 °C	650 – 700 °C	830 – 870 °C	300 – 600 °C #

TEMPERING DIAGRAM:

values in HRC
 tested on samples dia. 25 x 50 mm long
 hardened at 850 °C in oil



CCT GRAPH:



DELIVERY SIZES:

Rounds – up to 1300 mm
 Blocks – up to 1000 mm thickness
 or acc. to your request

The details and values in this data sheet are typical values, no guarantee promises. Changes of the material, the qualities and/or performance data we reserve for us.