

WLK/1.2885/X32CRMOCOV3-3-3



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NAZWA GATUNKU: WLK/1.2885/X32CRMOCOV3-3-3

NAZWA: HOT WORK TOOL STEEL

NORM: PN-86/H-85021

APPLICATION

Steel susceptible to hot pressing tools exposed to severe stresses in contact with die inserts. Tools for high-speed shears (automatic machines and upsetting machines) for hot upsetting and press moulding of nuts, mandrels, stamps, punching tools, bolt heads, pins and rivets and tools for hot forging of rolling bearing rings.

CHEMICAL COMPOSITION:

C	Si	Mn	P	S	Cr	Mo	W	V	Co	Ni
0,30-0,40	0,30-0,60	0,25-0,50	Max 0,030	Max 0,030	2,50-3,00	2,50-3,00	Max 0,30	0,40-0,60	2,80-3,30	-

MECHANICAL PROPERTIES:

Hardness after	Tempering °C	Symbol	Value
Soft annealing	-	HB	≤241
Quenching	-	HRC	53.5
Quenching and tempering	300	HRC	51.5
	350	HRC	51.5
	400	HRC	52
	450	HRC	52.5
	500	HRC	53
	550	HRC	53.5
	600	HRC	51.5

TECHNOLOGICAL TREATMENT PROCESSES:

Technological treatment processes			Possible application	Temperature, °C
Hot forming	Forging		+	1100-850
	Rolling		+	1100-850
Treatment	Heat treatment	Quenching	+	1020-1040
		Tempering	+	500-600
	Precipitation strengthening	Supersaturation	-	-
		Ageing	-	-
	Annealing	Soft annealing	+	740-770
		Stress relieving	+	600-700
Thermochemical treatment	Nitriding		+	470-550
	Other		-	-

INTERNATIONAL STEEL GRADES:

ISO		EN		Russia	
-	-	-	-	-	-
US		Japan		China	
-	-	-	-	-	-