

# COLD WORK TOOL STEELS

## Application Segments

Cold Work

## Available Product Variants

Long Products\*

Plates

\* Presented data refer exclusively to long products. Please observe the detailed explanations at the end of the data sheet (pdf).

## Product Description

BÖHLER K340 ISODUR belongs to the group of 8% chromium steels. This tool steel is produced using the electro-slag remelting (ESR) process developed by BÖHLER. This re-melting technology ensures the lowest micro and macro segregation as well as excellent purity and uniformity of the material. Compared to conventional 12% chromium steels, BÖHLER K340 ISODUR offers significantly better toughness, hardening response and higher resistance to adhesive wear. This material is therefore used in virtually all cold work applications in situations where tool steels like 1.2379 are insufficient in terms of adhesive wear resistance and toughness. K340 ISODUR also features better machinability and reduces the risk of stress cracking during electrical discharge machining.

## Process Melting

Airmelted + Remelted

## Properties

- > Toughness & Ductility : good
- > Wear Resistance : high
- > Compressive strength : good
- > Dimensional stability : good
- > Grindability : very high

## Applications

- > Machine knife (for producers)
- > Coining
- > Screws and Barrels
- > Rolls
- > Thread rolling
- > Rolling
- > Fine Blanking, Stamping, Blanking
- > Components for the recycling industry
- > Wear parts
- > Pill punching dies
- > Cold Forming
- > Powder Pressing
- > Components for underground construction (drilling, shafts, etc.)
- > General Components for Mechanical Engineering
- > Glasfibre reinforced plastics

## Chemical composition (wt. %)

C	Si	Mn	Cr	Mo	V	Al	Nb
1.10	0.90	0.40	8.30	2.10	0.50	+	+

**Material characteristics**

	Compressive strength	Dimensional stability during heat treatment	Toughness	Wear resistance abrasive	Wear resistance adhesive
<b>BÖHLER K340 ISODUR</b>	★★★	★★★★	★★★	★★★	★★★★
<b>BÖHLER K100</b>	★★	★★	★	★★★	★★
<b>BÖHLER K105</b>	★★	★★	★	★★	★★
<b>BÖHLER K107</b>	★★	★★	★	★★★	★★
<b>BÖHLER K110</b>	★★	★★★	★	★★★	★★
<b>BÖHLER K190 MICROCLEAN</b>	★★★★	★★★★★	★★★★	★★★★	★★★★
<b>BÖHLER K294 MICROCLEAN</b>	★★★★★	★★★★★	★★★	★★★★★	★★★★★
<b>BÖHLER K340 ECOSTAR</b>	★★★	★★★	★★	★★	★★
<b>BÖHLER K346</b>	★★★	★★★	★★★	★★★★	★★
<b>BÖHLER K353</b>	★★	★★★	★★	★★	★★
<b>BÖHLER K360 ISODUR</b>	★★★	★★★★	★★★	★★★★	★★★★
<b>BÖHLER K390 MICROCLEAN</b>	★★★★★	★★★★★	★★★★	★★★★★	★★★★★
<b>BÖHLER K490 MICROCLEAN</b>	★★★★	★★★★★	★★★★	★★★★	★★★★
<b>BÖHLER K497 MICROCLEAN</b>	★★★★★	★★★★★	★★★	★★★★★	★★★★★
<b>BÖHLER K888 MATRIX</b>	★★★★	★★★★★	★★★★★	★★	★★
<b>BÖHLER K890 MICROCLEAN</b>	★★★★	★★★★★	★★★★★	★★★	★★★

**Delivery condition**

**Annealed**

Hardness (HB)	max. 235
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**Heat treatment**

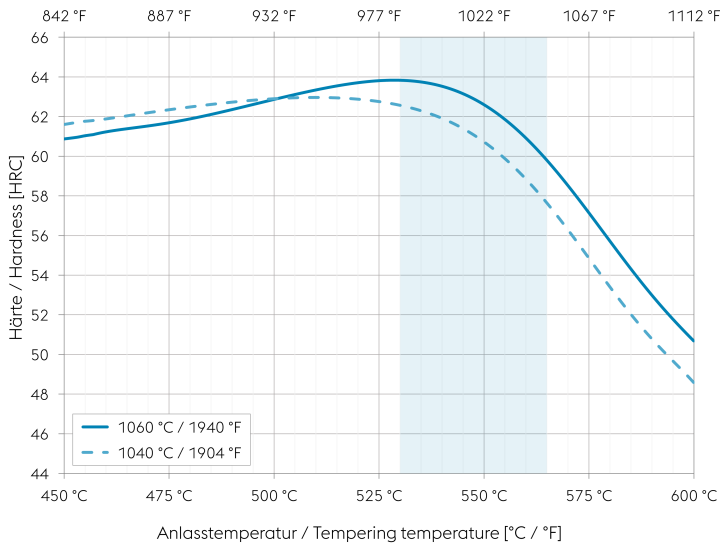
**Stress relieving**

Temperature	650 °C	After through heating, hold in neutral atmosphere for 1-2 hours.    Slow cooling in furnace    Intended to relieve stresses caused by extensive machining or in complex shapes.
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**Hardening and Tempering**

Temperature	1,040 to 1,060 °C	Quenching: Oil, salt bath, compressed air, air, gas.    Holding time after temperature equalization: 15 to 30 minutes.    After hardening, tempering to the desired working hardness according to the tempering chart.
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**Tempering chart**



Specimen size: square 20 mm (0,787 inch)

Slow heating to tempering temperature immediately after hardening.

Time in furnace 1 hour for each 20 mm (0,787 inch) of workpiece thickness but at least 2 hours.

Please refer to the tempering chart for guide values for the achievable hardness after tempering.

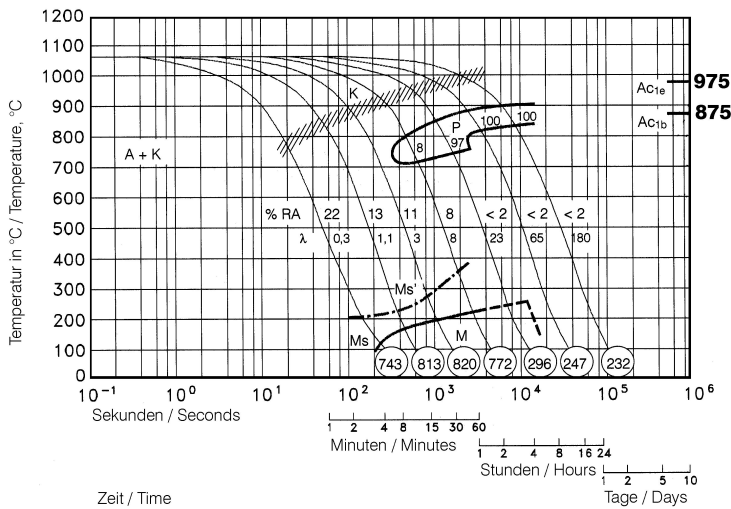
It is recommended to temper at least three times above the secondary hardness maximum.

Cooling in air to room temperature after each tempering step is recommended.

Tempering for stress relieving 30 to 50 °C (86 to 122 °F) below the highest tempering temperature.

Recommended tempering temperature range is indicated by the blue area in the chart.

**CCT chart for continuous cooling**



Austenitising temperature: 1060 °C (1940 °F)  
Holding time: 30 minutes

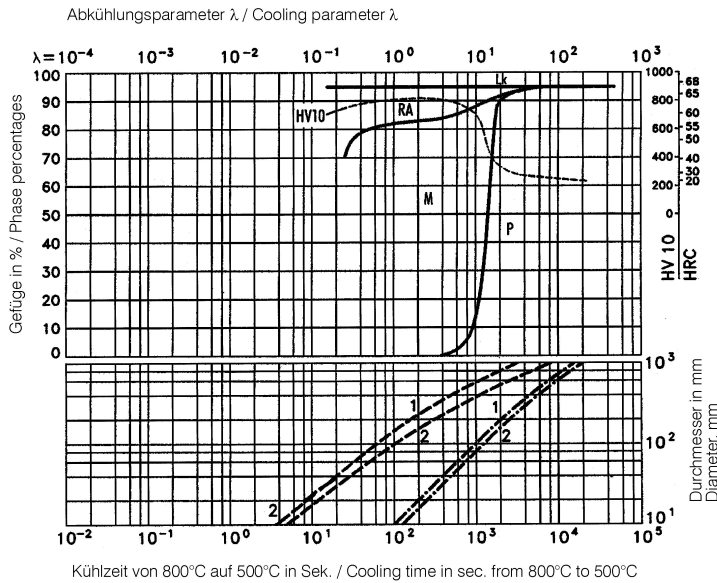
O Vickers hardness

8...100 phase percentages

0.3...180 cooling parameter  $\lambda$ , i.e. duration of cooling from 800 to 500 °C (1472 to 932 °F) in  $s \times 10^{-2}$

- A... Austenite
- K... Carbide
- P... Pearlite
- RA... Residual austenite
- M... Martensite
- Ms... Martensite starting temperature

Quantitative phase diagram



HV10... Vickers Hardness  
LK... Ledeburitic carbides  
RA... Retained austenite  
M... Martensite  
P... Pearlite

--- Oil cooling  
- · - Air cooling

1... Edge or face  
2... Core

Physical Properties

Temperature (°C)	20
Density (kg/dm <sup>3</sup> )	7.68
Thermal conductivity (W/(m.K))	17.8
Specific heat (kJ/kg K)	0.49
Spec. electrical resistance (Ohm.mm <sup>2</sup> /m)	0.64
Modulus of elasticity (10 <sup>3</sup> N/mm <sup>2</sup> )	206

Thermal Expansions between 20°C | 68°F and ...

Temperature (°C)	100	200	300	400	500	600	700
Thermal expansion (10 <sup>-6</sup> m/(m.K))	11.2	11.8	12.3	12.7	12.9	13.1	13.1

If other available product variants are listed in addition to long products, please note that these may differ in terms of melting process, technical data, delivery and surface condition as well as available product dimensions. For mandatory technical specifications, other requirements and dimensions, please contact our regional voestalpine BÖHLER sales companies. The data contained in this brochure is merely for general information and therefore shall not be binding on the company. We may be bound only through a contract explicitly stipulating such data as binding. Measurement data are laboratory values and can deviate from practical analyses. The manufacture of our products does not involve the use of substances detrimental to health or to the ozone layer.

voestalpine BÖHLER Edelstahl GmbH & Co KG  
 Mariazeller Straße 25  
 8605 Kapfenberg, AT  
 T. +43/50304/20-0  
 E. info@bohler-edelstahl.at  
<https://www.voestalpine.com/bohler-edelstahl/de/>