BÖHLER

BÖHLER W320
ISODISC®

ACCIAI DA UTENSILE PER LAVORAZIONE A CALDO

Granulometria disponibile

Prodotti lunghi

Descrizione del prodotto

Acciaio per lavorazione a caldo con ottime proprietà di resistenza al calore, elevata proprietà di rinvenimento e migliore tenacità, nonché buona resistenza alle cricche termiche, raffreddabile in acqua.

Percorso di fusione

Airmelted

Proprietà

- Durezza e duttilità : buono
- Resistenza all'usura : alto
- Lavorabilità : molto alto
- Durezza a caldo (durezza rossa) : alto
- Lucidabilità : buono
- Micropulizia : buono
- Conducibilità termica : molto alto

Applicazioni

- Estrusione
- Pressocolata ad alta pressione
- Forgiatura a caldo
- Forgiatura progressiva (Hatebur)
- Colata in gravità

Dati tecnici

Corrispondenze	
1.2365	SEL
~T20810	UNS
32CrMoV12-28	EN
~H10	AISI
SKD7	JIS

Standard	
4957	EN ISO
G4404	JIS

Analisi chimica

C	Si	Mn	Cr	Mo	V
0,31	0,30	0,35	2,90	2,70	0,50

Proprietà del materiale

	Resistenza a caldo	Durezza a caldo	Resistenza all'usura a caldo
BÖHLER W320 ISODISC®	★★★	★★	★★★
BÖHLER W300 ISODISC®	★★	★★★	★★
BÖHLER W300 ISOBLOC®	★★	★★★★	★★
BÖHLER W302 ISODISC®	★★★	★★★	★★★
BÖHLER W302 ISOBLOC®	★★★	★★★★	★★★
BÖHLER W303 ISODISC®	★★★★	★★★	★★★★
BÖHLER W350 ISOBLOC®	★★★	★★★★★	★★★
BÖHLER W360 ISOBLOC®	★★★★★	★★★★	★★★★★
BÖHLER W400 VMR®	★★	★★★★★	★★
BÖHLER W403 VMR®	★★★★	★★★★	★★★★

Condizioni di consegna

Ricotto

Durezza (HB)	max. 229

Trattamento termico

Annealing

Temperatura	750 a 800 °C	Holding time 6 to 8 hours. Slow, controlled furnace cooling at 10 to 20°C/h (50 to 68 °F/hr) to approx. 600°C (1112°F), further cooling in air.

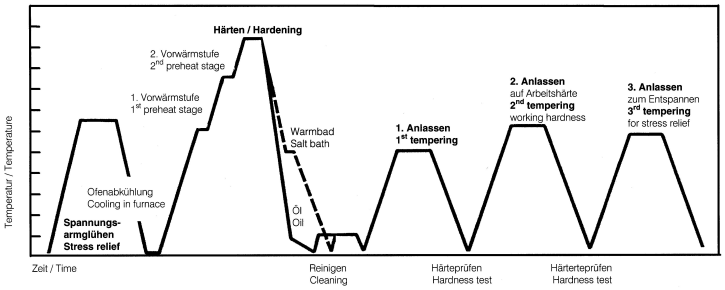
Alleviare lo stress

Temperatura	600 a 670 °C	For stress relief after extensive machining or for complicated tools. Holding time depending on tool size after complete heating 2 - 6 hours in neutral atmosphere. Slow furnace cooling.

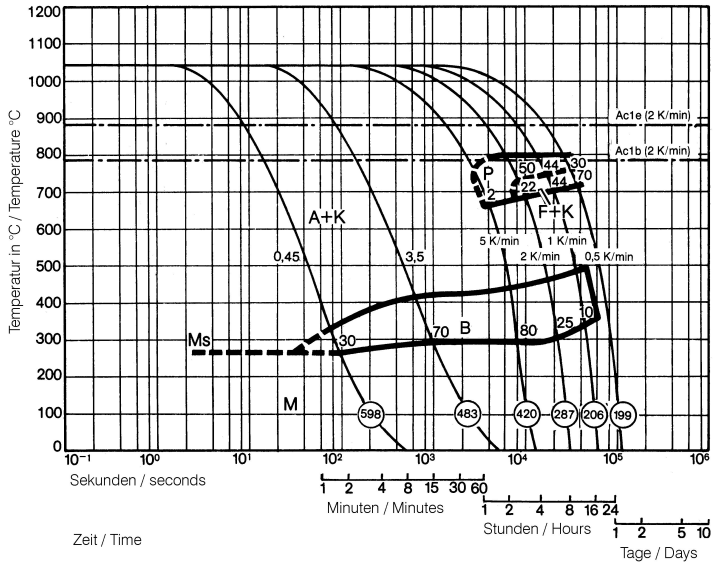
Tempra e rinvenimento

Temperatura	1.010 a 1.050 °C	Holding time after temperature equalization: 15 to 30 minutes; Quenching: Oil, salt bath (500 - 550°C [932-1022°F]), air, vacuum; After hardening, tempering to the desired working hardness (see tempering chart).

Heat treatment sequence



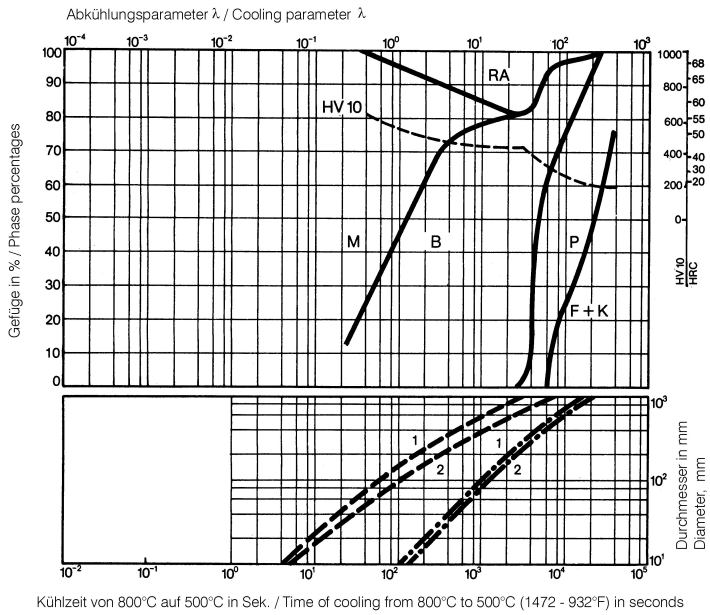
Continuous cooling CCT curves



Austenitising temperature: 1886°F (1030°C)
Holding time: 15 minutes

O Vickers hardness
2...80 phase percentages
0.45...3.5 cooling parameter, i.e. duration of cooling from 1472-932°F (800 - 500°C) in s x 10^{-2}
41...32,9°F/min (5...0.5 K/min) cooling rate in °F/min (K/min) in the 1472-932°F (800 - 500°C) range

Quantitative phase diagram

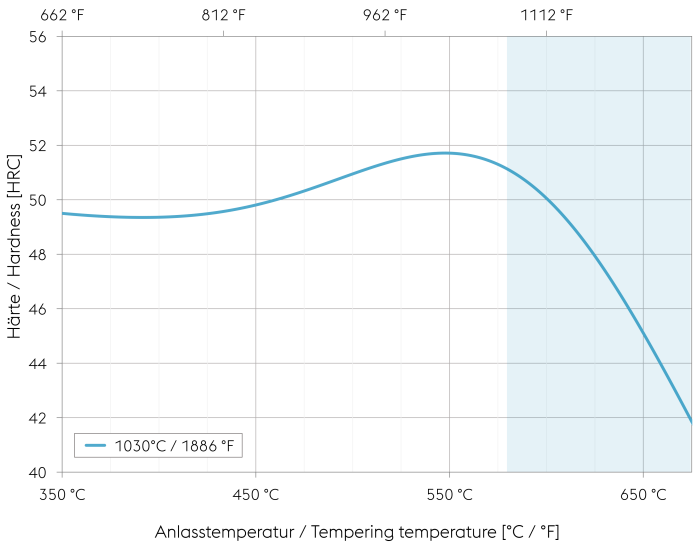


A... Austenite
B... Bainite
F... Ferrite
K... Carbide
M... Martensite
P... Perlite
RA... Retained austenite

- - - - - - Oil cooling
- • - Air cooling

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

Tempering chart



Tempering:

Slow heating to tempering temperature immediately after hardening / time in furnace 1 hour for each 0,787 inch (20 mm) of work piece thickness but at least 2 hours / cooling in air. It is recommended to temper at least twice.

A third tempering cycle for the purpose of stress relieving may be advantageous.

1st tempering approx. 30°C (86°F) above maximum secondary hardness.

2nd tempering to desired working hardness.

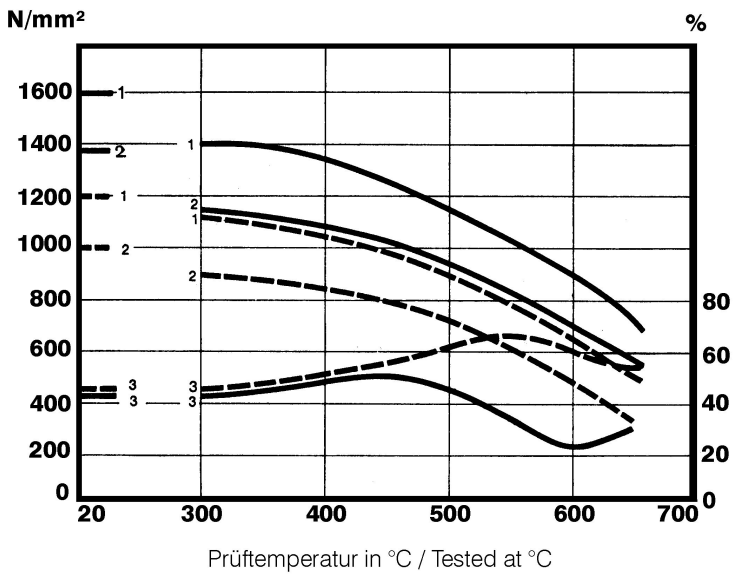
The tempering chart shows average tempered hardness values.

3rd for stress relieving at a temperature 86 to 122°F (30 - 50°C) below highest tempering temperature.

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

Hardening temperature: 1030°C (1886°F)
Specimen size: square 50 mm

Hot strength chart



——— heat treated 1600 N/mm²
- - - - - - heat treated 1200 N/mm²
1... Tensile strength N/mm²
2... 0.2% proof stress N/mm²
3... Reduction of area %

Proprietà fisiche

Temperatura (°C)	20
Densità (kg/dm³)	7,9
Conducibilità termica (W/(m.K))	30
Capacità termica specifica (kJ/kg K)	0,46
Resistenza elettrica specifica (Ohm.mm²/m)	0,37
Modulo di elasticità (10^3N/mm²)	215

Espansioni termiche

Temperatura (°C)	100	200	300	400	500	600	700
Espansione termica (10^{-6} m/(m.K))	12	12,5	12,7	13	13,2	13,4	13,7

For additional specifications and technical requirements, please contact our regional voestalpine BÖHLER sales companies.

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ONE STEP AHEAD.