

# COLD WORK TOOL STEELS

Available Product Variants  Long Products* Plates  * Presented data refer exclusivly to long products. Please observe the detailed explanations at the end of the data sheet (pdf).  Product Description  BÖHLER K353 belongs to the group of conventionally produced 8% chromium steels. It is used in situations where chipper steels like 1.23 are insufficient in terms of wear resistance and tool steels like 1.2379 (D2) do not have sufficient toughness. BÖHLER K353 is especially suitable for industrial knives for the woodworking industry. It is also used for stamping and cutting tools.  Process Melting  Airmelted  Properties  > Dimensional stability: good  Applications  > Machine knife (for producers)	Application S	Segments					
Long Products* Plates  * Presented data refer exclusivly to long products. Please observe the detailed explanations at the end of the data sheet (pdf).  Product Description  BÖHLER K353 belongs to the group of conventionally produced 8% chromium steels. It is used in situations where chipper steels like 1.23 are insufficient in terms of wear resistance and tool steels like 1.2379 (D2) do not have sufficient toughness. BOHLER K353 is especially suitable for industrial knives for the woodworking industry. It is also used for stamping and cutting tools.  Process Melting  Airmelted  Properties  > Dimensional stability: good  Applications  > Machine knife (for producers) > Cold Forming > Fine Blanking, Stamping, Blanking > Press Hardening / Hot Stamping > Hotrunner systems  Chemical composition (wt. %)  C Si Mn Cr Mo V Al	Cold Wo	rk					
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C Si Mn Cr Mo V Al	> Press Harder	ning / Hot Stamping	y > Hotro	ŭ	> Fine Blan	king, Stamping, Blan	king
	Chemical co	mposition (wt.	%)				
0.00	С	Si	Mn	Cr	Мо	V	Al
0.82 0.70 0.40 8.00 1.60 0.60 +	0.82	0.70	0.40	8.00	1.60	0.60	+



#### Material characteristics

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

## **Delivery condition**

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Hardness (HB)	max. 240

#### Heat treatment

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Temperature	800 to 850 °C	Slow controlled cooling in furnace at a rate of 10 to 20 °C/hr (18 to 36 °F/hr) down to approximately 600 °C (1112 °F)    Further cooling in air.

#### 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.

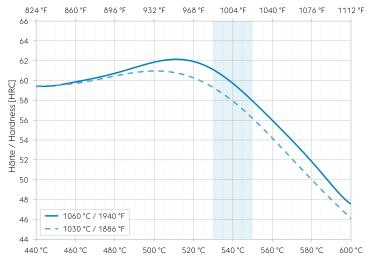
#### Hardening and Tempering

Temperature 1,0°C		nching: Oil, salt bath, gas.    Holding time after temperature equalization: 15 to 30 minutes.    hardening, tempering to the desired working hardness according to the tempering chart.
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### Tempering chart



Anlasstemperatur / Tempering temperature [°C / °F]

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.

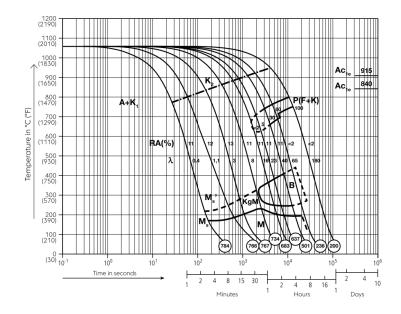
It is recommended to temper at least three times above the secondary hardness maximum.

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

Tempering for stress relieving 30 to 50  $^{\circ}$ C (86 to 122  $^{\circ}$ F) below the highest tempering temperature.

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

# Continuous cooling CCT curves



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

O Vickers hardness

2...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 x 10  $^{-2}$ 

A... Austenite

K... Carbide

RA... Retained austenite

P... Perlite

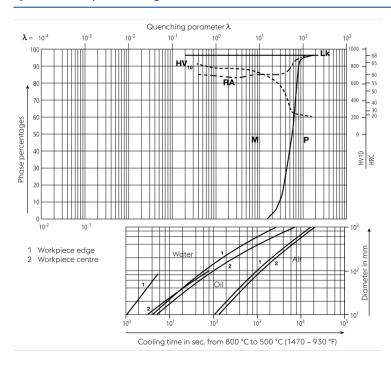
B...Bainite

M... Martensite

Ms... Martensite starting temperature



## Quantitative phase diagram

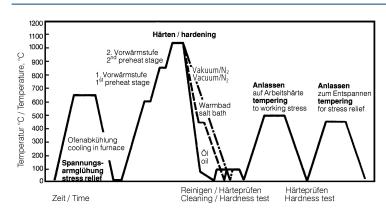


○ Vickers hardnessLK... Ledeburitic carbides RA... Retained austenite

M... Martensite P... Perlite

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

## Heat treatment sequence



## **Physical Properties**

Temperature (°C)	20
Density (kg/dm³)	7.7
Thermal conductivity (W/(m.K))	21.9
Specific heat (kJ/kg K)	0.47
Spec. electrical resistance (Ohm.mm²/m)	-
Modulus of elasticity (10 <sup>3</sup> N/mm <sup>2</sup> )	212



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

Temperature (°C)	100	200	300	400	500
Thermal expansion (10 <sup>-6</sup> m/(m.K))	11	11.3	11.6	12	12.4

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.

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