

durostat 400/450/500/B2

Wear-resistant steels with best workability

The steel grades durostat 400, durostat 450 and durostat 500 are wear-resistant special steels with hardness of approx. 400 HB, 450 HB resp. 500 HB. These steels provide high levels of resistance to mechanical wear and are specially suitable for components exposed to heavy abrasion, e.g. loading devices, shovels of wheel loaders, bodies of trough tipping wagons, conveyors, excavator components, road machines, screens and crushers. The high hardness is reached by accelerated cooling directly after hot rolling (direct quenching) or by conventional quenching in a water quench. Direct quenching is mainly applied due to improved toughness and reduced scale. State-of-the-art alloying concepts with low carbon content provide good weldability.

durostat B2 steels are delivered in as-rolled condition (non-quenched). The highest achievable hardness is approximately 500 HB. These steel grades are used in components of agricultural machinery, cutting edges for front-end loaders and brick-molding boxes.

Convincing advantages

- » Longer service life with much higher resistance to wear
- » Weight savings due to reduced plate thickness as a result of high hardness
- » Good surface quality due to thinner, more easily removable rolling scale
- » Good weldability with elimination of preheating for small plate thicknesses
- » Guaranteed toughness for low temperature applications

Chemical composition

Heat analysis in mass %

| durostat® | C max. | Si max. | Mn max. | P max. | S max. | Al min. | Cr max. | Mo max. | B max. | Ti max. |
|-----------|--------|---------|---------|--------|--------|---------|---------|---------|--------|---------|
| 400 | 0.18 | 0.60 | 2.10 | 0.025 | 0.010 | 0.020 | 1.00 | 0.50 | 0.005 | 0.050 |
| 450 | 0.23 | 0.60 | 2.10 | 0.025 | 0.010 | 0.020 | 1.00 | 0.50 | 0.005 | 0.050 |
| 500 | 0.30 | 0.60 | 2.10 | 0.025 | 0.010 | 0.020 | 1.00 | 0.50 | 0.005 | 0.050 |
| B2 | 0.30 | 0.60 | 2.10 | 0.025 | 0.010 | 0.020 | 1.00 | 0.50 | 0.005 | 0.050 |

The steel is fine grain melted and may contain microalloying elements such as Nb and V.

Carbon equivalent

| durostat® | Plate thickness [mm] | Mass percentages [%] | |
|-----------|----------------------|------------------------|------------------------|
| | | CEV ¹⁾ max. | CET ²⁾ max. |
| 400 | 5 ≤ 35 | 0.52 | 0.35 |
| | > 35 - 120 | 0.57 | 0.37 |
| 450 | 5 ≤ 15 | 0.57 | 0.37 |
| | > 15 - 70 | 0.59 | 0.39 |
| 500 | 8 ≤ 30 | 0.59 | 0.44 |
| | > 30 - 50 | 0.67 | 0.47 |

¹⁾ CEV = C + Mn/6 + (Cr + Mo + V)/5 + (Ni + Cu)/15, according to IIW

²⁾ CET = C + (Mn + Mo)/10 + (Cr + Cu)/20 + Ni/40, according to SEW 088

Mechanical properties: Hardness/Tensile strength

| durostat® | Hardness [HB] | Standard values ¹⁾ | | | |
|-----------|-----------------------|-------------------------------|--|---------------------------------------|--|
| | | Hardness [HB] | Yield strength R _{0.2H} [MPa] | Tensile strength R _m [MPa] | Fracture elongation A ₅ [%] |
| 400 | 360 - 440 | 400 | 1,000 | 1,250 | 10 |
| 450 | 410 - 490 | 450 | 1,100 | 1,400 | 9 |
| 500 | 460 - 540 | 500 | 1,200 | 1,550 | 8 |
| B2 | ca. 500 ²⁾ | 200 | 400 | 650 | 20 |

¹⁾ Typical values for plate thickness of 20 mm

²⁾ As-delivered condition is non-quenched; achievable hardness after water quenching

Mechanical properties: Notch impact energy/Edging radii

| durostat® | Plate thickness [mm] | Notch impact energy ¹⁾ Av [Joule] min. -40 °C | Edging radii Ri min. at 90° edging (s = plate thickness) Position of the bending edge to the rolling direction | |
|--------------------------------------|----------------------|--|--|------------|
| | | | Longitudinal | Transverse |
| Guaranteed values | | | | |
| 400 | 5 - 50 | 27 | - | - |
| | > 50 ≤ 120 | upon request | - | - |
| 450 | 5 - 50 | 20 | - | - |
| 500 | 8 - 50 | upon request | - | - |
| Standard values ²⁾ | | | | |
| 400 | - | 50 | 4 s | 3 s |
| 450 | - | 30 | 5 s | 4 s |
| 500 | - | 20 | 5 s | 4 s |

¹⁾Notch impact bending test in accordance with EN ISO 148-1 on Charpy-V longitudinal samples at -40 °C. The mean value from 3 individual samples must reach the specified requirements. No individual value may be below 70% of the guaranteed mean value. For thicknesses < 12 mm, subsize-specimen with dimensions of 10 x 7.5 mm or 10 x 5 mm are tested. The guaranteed value is reduced in proportion to the sample cross-section.

²⁾Typical values of notch impact energy for plate thickness of 20 mm

Available dimensions

Maximum width per thickness; minimum width 1,500 mm; for thickness of 5 mm the minimum width is 2,000 mm

| durostat® | Plate thickness [mm] | Max. width [mm] | Max. length [mm] | As-delivered condition ⁵⁾ |
|-----------|----------------------|-----------------|--|--------------------------------------|
| 400 | 5 ≤ 12 | 2,500 | 12,000 (8,000 for thickness 5 mm and a width ≥ 2,000 mm) | direct quenched |
| | > 12 ≤ 120 | 3,000 | | |
| 450 | 5 ≤ 12 | 2,500 | | |
| | > 12 ≤ 70 | 3,000 | | quenched or direct quenched |
| 500 | 8 ≤ 50 | 2,500 | 18,700 | non-quenched |
| B2 | 8 ≤ 50 | 2,500 | | |

Weight per plate is max. 16 t.
Additional dimensions upon request.

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