UDDEHOLM SLEIPNER®

UDDEHOLM

Classified according to EU Directive 1999/45/EC
For further information see our "Material Safety Data Sheets".

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The latest revised edition of this brochure is the English version, which is always published on our web site www.uddeholm.com

SS-EN ISO 9001
SS-EN ISO 14001

UDDEHOLM SLEIPNER

THE CHANGING TOOLING ENVIRONMENT

The tooling environment is changing to suit the changing market environment. Lead times are one aspect of this change and they are getting shorter and shorter. This ultimately means that more emphasis has to be placed on tool reliability in service and on time to manufacture the tooling.

The production materials used nowadays are placing more demands on the tools and the tool steels used to manufacture them. For example, advanced high strength steel sheet materials now being used for automotive parts place extra demands on resistance to chipping and cracking, compressive strength and wear resistance.

THE MODERN GENERAL COLD WORK TOOL STEEL

The classical 12 % Cr-steels such as AISI D2 or W.-Nr. 1.2379 are still the backbone of cold work tooling but their limitations are becoming more and more apparent in the changing production environment.

Uddeholm Sleipner is a new 8 % Cr-steel from Uddeholm Tooling. Its properties profile has been carefully balanced and the result is a very versatile tool steel which overcomes the limitations of the 12% Cr-steels.

A VERSATILE TOOL STEEL

The properties profile of Uddeholm Sleipner is more versatile and superior to that of 12 % Cr-steels. The machinability, grindability and hardenability are much better and it is easier to make small repair welds. This means that Uddeholm Sleipner is the right choice for faster toolmaking, better tool performance and easier maintenance.

General

Uddeholm Sleipner is a chromium-molybdenum-vanadium alloyed tool steel which is characterised by:

- Good wear resistance
- Good chipping resistance
- High compressive strength
- High hardness (>60 HRC) after high temperature tempering
- Good through-hardening properties
- Good stability in hardening
- Good resistance to tempering back
- Good WEDM properties
- Good machinability and grindability
- Good surface treatment properties.

Typical analysis %	C 0,9	Si 0,9	Mn 0,5	Cr 7,8	Mo 2,5	V 0,5
Standard spec.	None					
Delivery condition	Soft annealed to approx. 235 HB					
Colour code	Blue/brown					

Applications

Uddeholm Sleipner is a general purpose steel for cold work tooling. It has a mixed-abrasive wear profile and a good resistance to chipping. Furthermore a high hardness (>60 HRC) can be obtained after high temperature tempering. This means that surface treatments such as nitriding or PVD can be made on a high strength substrate. Also, it means that complicated shapes with hardness levels >60 HRC can be wire EDM'd from blocks with relatively thick cross-sections with a much reduced risk of cracking.

Uddeholm Sleipner is recommended for medium run tooling applications where a resistance to mixed or abrasive wear and a good resistance to chipping are required.

Examples:

- Blanking and fine blanking
- Shearing
- Forming
- Coining
- Cold forging
- Cold extrusion
- Thread rolling
- Drawing and deep drawing
- Powder pressing

Properties

Physical data

Hardened and tempered to 62 HRC. Data at room and elevated temperatures.

Density kg/m³ lbs/in³	7 730 0,279	7 680 0,277	7 620 0,275
Modulus of elasticity MPa ksi	205 000 297 000	190 000 276 000	180 000 261 000
Coefficient of thermal expansion –after low temperature tempering (60 HRC) per °C from 20°C per °F from 68°F	– –	$12,7 \times 10^{-6}$ $7,1 \times 10^{-6}$	– –
–after high temperature tempering per °C from 20°C per °F from 68°F	– –	$11,6 \times 10^{-6}$ $6,4 \times 10^{-6}$	$12,4 \times 10^{-6}$ $6,9 \times 10^{-6}$
Thermal conductivity W/m ·°C Btu in/(ft² h °F)	– –	20 140	25 170
Specific heat J/kg C Btu/lb. °F	460 0,11	– –	– –

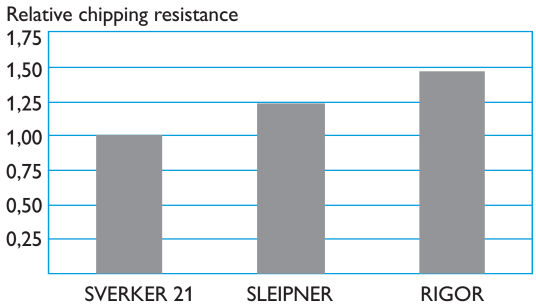
Compressive strength

The figures should be considered as approximate.

Hardness HRC	Compressive yield strength Rc0,2 MPa	ksi
50	1 700	250
55	2 050	300
60	2 350	340
62	2 500	360
64	2 650	380

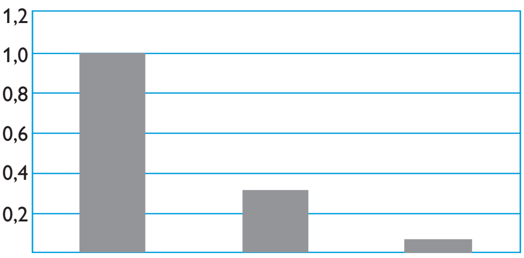
Chipping resistance

Relative chipping resistance for Uddeholm Sverker 21, Uddeholm Sleipner and Uddeholm Rigor at the same hardness level.



Abrasive wear resistance

Relative abrasive wear resistance for Uddeholm Sverker 21 Uddeholm Sleipner and Uddeholm Rigor at the same hardness level (low value means better wear resistance).



Heat treatment

Sift annealing

Protect the steel and heat through to 850°C (1560°F). Then cool in the furnace at 10°C (20°F) per hour to 650°C (1200°F), then freely in air.

Stress relieving

After rough machining the tool should be heated through to 650°C (1200°F) and held for 2 hours. Cool slowly to 500°C (930°F) then freely in air.

Hardening

Preheating temperature: 650–750°C (1200–1380°F).
Austenitizing temperature: 950–1080°C (1740–1980°F) but usually 1030–1050°C (1890–1920°F).
Holding time: 30 minutes

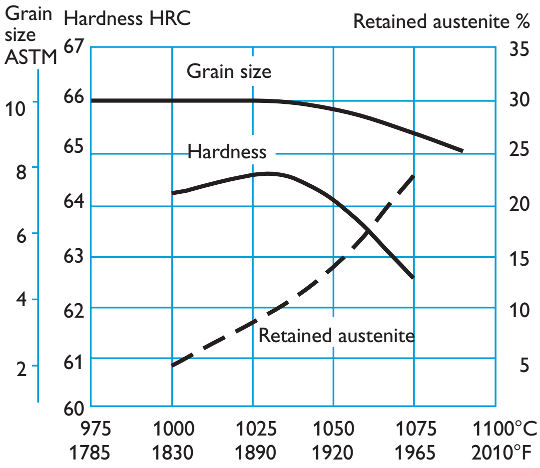
Protect the part against decarburization and oxidation during hardening.

Quenching media

- Forced gas/circulating atmosphere
- Vacuum (high speed gas with sufficient overpressure)
- Martempering bath or fluidized bed at 500–550°C (930–1020°F)
- Martempering bath or fluidized bed at approx. 200–350°C (390–660°F)
- Oil (only very simple geometries)

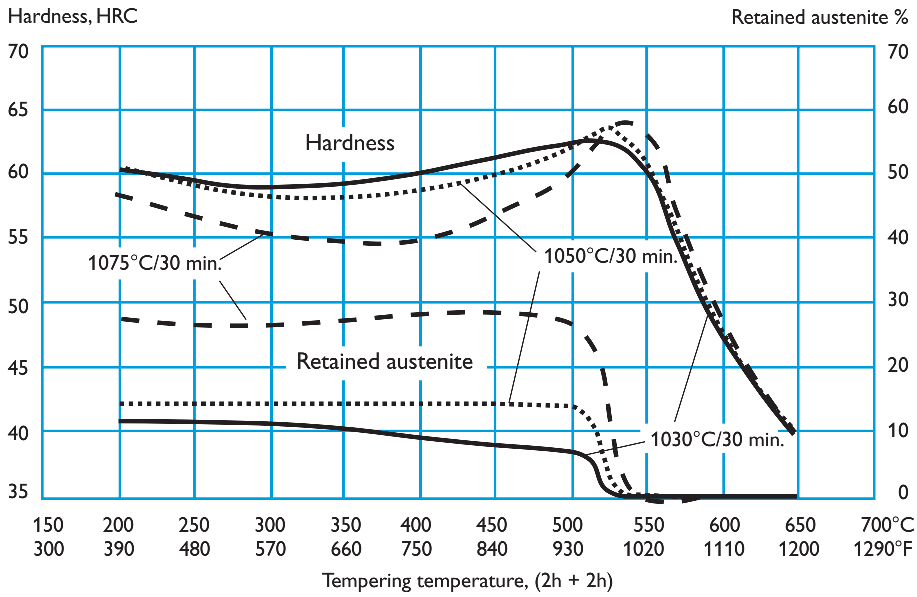
Note: Temper the tool as soon as its temperature reaches 50–70°C (120–160°F)

HARDNESS, RETAINED AUSTENITE AND GRAIN SIZE AS FUNCTION OF AUSTENITIZING TEMPERATURE



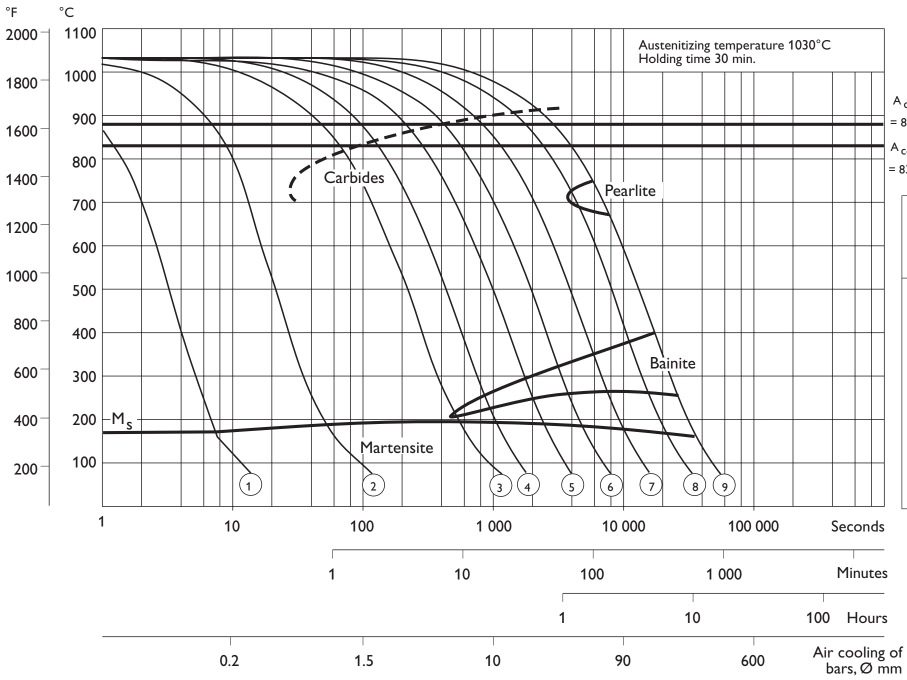
Tempering

Choose the tempering temperature according to the hardness required by reference to the tempering graph. Temper at least twice with intermediate cooling to room temperature. The lowest tempering temperature which should be used is 180°C (360°F). The minimum holding time at temperature is 2 hours.



CCT-GRAPH

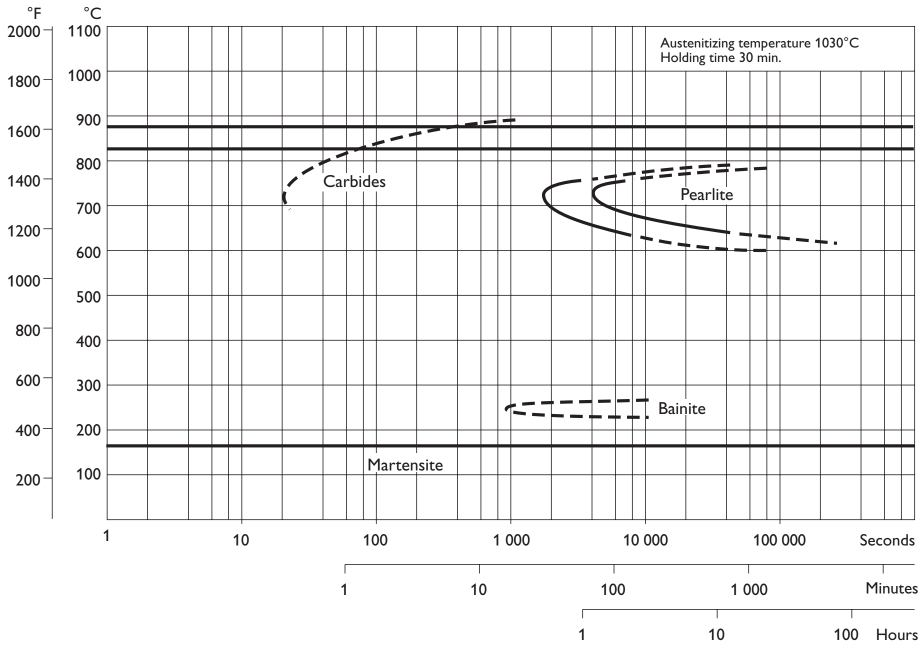
Austenitizing temperature 1030°C (1890°F). Holding time 30 min.



Cooling curve no.	Hardness HV 10	$T_{800-500}$ (sec.)
1	824	2
2	824	11
3	813	140
4	813	280
5	813	630
6	813	1241
7	724	2482
8	649	5215
9	572	8360

TTT-GRAPH

Austenitizing temperature 1030°C (1890°F). Holding time 30 min.



Temp. °C.	Time h	Hardness HV10
800	31,0	498
750	3,1	266
725	1,6	309
700	3,0	304
650	19,6	239
600	23,3	724
300	7,0	813
250	16,3	803
200	23,4	813

Dimensional changes

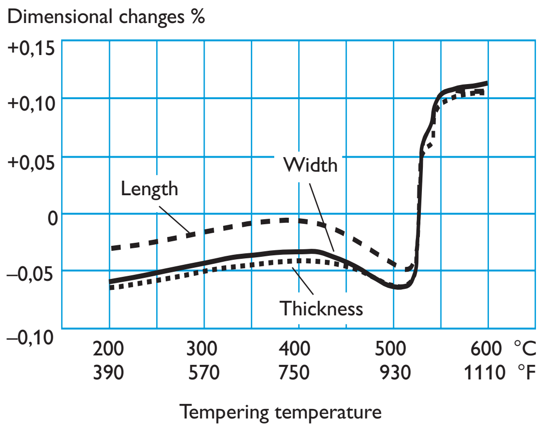
The dimensional changes have been measured after austenitizing and tempering.

Austenitizing: 1030°C (1890°F)/30 min, cooling in vacuum furnace at 0,75°C/s (1,35°F/s) between 800°C (1470°F) and 500°C (930°F)

Tempering: 2 x 2 h at various temperatures

Specimen size: 100 x 100 x 100 mm

DIMENSIONAL CHANGES
AS FUNCTION OF TEMPERING TEMPERATURE



Sub-zero treatment

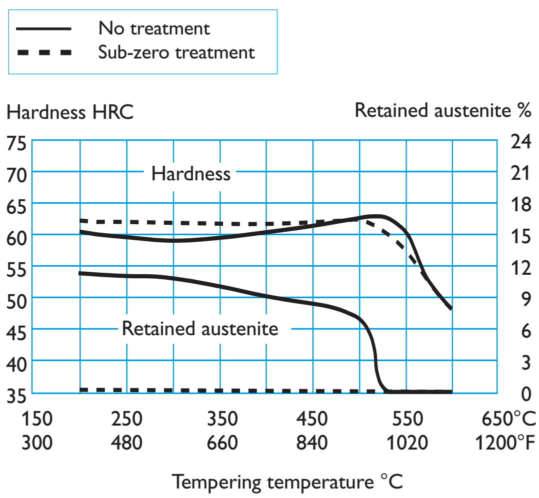
Pieces requiring maximum dimensional stability in service should be sub-zero treated.

Sub-zero treatment reduces the amount of retained austenite and changes the hardness as shown in the diagram below.

Austenitizing: 1030°C (1890°F)/30 min

Tempering: 2 x 2 h at various temperatures

HARDNESS AND RETAINED AUSTENITE AS FUNCTION OF TEMPERING TEMPERATURE AND SUB-ZERO TREATMENT



Surface treatments

Some cold work tool steels are given a surface treatment in order to reduce friction and increase wear resistance. The most commonly used treatments are nitriding and surface coating with wear resistant layers produced via PVD or CVD.

The high hardness and good resistance to chipping together with a good dimensional stability make Uddeholm Sleipner suitable as a substrate steel for various surface coatings.

Nitriding and nitrocarburizing

Nitriding and nitrocarburizing result in a hard surface layer which is very resistant to wear and galling. The surface hardness after nitriding is approximately 1100 $HV_{0,2kg}$. The thickness of the layer should be chosen to suit the application in question.

PVD

Physical vapour deposition, PVD, is a method of applying a wear-resistant coating at temperatures between 200–500°C (390–930°F).

CVD

Chemical vapour deposition, CVD, is used for applying wear-resistant surface coatings at a temperature of around 1000°C (1830°F). It is recommended that the tools are separately hardened and tempered in a vacuum furnace after surface treatment.

Machining recommendations

The cutting data below are to be considered as guide values which must be adapted to existing local conditions.

More information can be found in the Uddeholm publication "Cutting data recommendations".

The recommendations in following tables are valid for Uddeholm Sleipner in soft annealed condition to approx. 235 HB.

Turning

Cutting data parameters	Turning with carbide		Turning with high speed steel
	Rough turning	Fine turning	Fine turning
Cutting speed (v_c), m/min. f.p.m.	100–150 328–492	150–200 492–656	17–22 56–72
Feed, (f) mm/rev i.p.r.	0,2–0,4 0,008–0,016	0,05–0,2 0,002–0,008	0,05–0,3 0,002–0,01
Depth of cut, (a_p) mm inch	2–4 0,08–0,16	0,5–2 0,02–0,08	0,5–3 0,02–0,12
Carbide designation ISO US	K20, P20 C2–C6 Coated carbide	K10, P15 C3, C7 Coated carbide	–

Drilling

HIGH SPEED STEEL TWIST DRILL

Drill diameter mm	inch	Cutting speed (v_c) m/min	f.p.m.	Feed (f) mm/rev	i.p.r.
– 5	–3/16	13–18*	43–59*	0,05–0,10	0,002–0,004
5–10	3/16–3/8	13–18*	43–59*	0,10–0,20	0,004–0,008
10–15	3/8–5/8	13–18*	43–59*	0,20–0,25	0,008–0,010
15–20	5/8–3/4	13–18*	43–59*	0,25–0,30	0,010–0,012

* For coated HSS drill v_c 25–35 m/min. (82–115 f.p.m./min.)

CARBIDE DRILL

Cutting data parameters	Type of drill		
	Indexable insert	Solid carbide	Brazed carbide[1)]
Cutting speed (v_c) m/min f.p.m.	140–160 460–525	80–100 262–328	45–55 148–180
Feed (f) mm/r i.p.r	0,05–0,15[2)] 0,002–0,006[2)]	0,10–0,25[2)] 0,004–0,01[2)]	0,15–0,25[2)] 0,006–0,01[2)]

1) Drill with internal cooling channels and brazed tip
2) Depending on drill diameter

Milling

FACE AND SQUARE SHOULDER MILLING

Cutting data parameters	Milling with carbide	
	Rough milling	Fine milling
Cutting speed (v_c) m/min f.p.m.	110–180 360–590	180–220 590–722
Feed (f_z) mm/tooth inch/tooth	0,2–0,4 0,008–0,016	0,1–0,2 0,004–0,008
Depth of cut (a_p) mm inch	2–5 0,08–0,2	–2 –0,08
Carbide designation ISO US	K20, P20 C2, C6 Coated carbide	P10–P20 C3–C7 Coated carbide

END MILLING

Cutting data parameters	Type of milling		
	Solid carbide	Carbide indexable insert	High speed steel
Cutting speed (v_c) m/min f.p.m.	80–120 262–394	100–140 328–460	13–18[1)] 43–59[1)]
Feed (f_z) mm/tooth inch/tooth	0,03–0,20[2)] 0,001–0,008[2)]	0,08–0,20[2)] 0,003–0,008[2)]	0,05–0,35[2)] 0,002–0,014[2)]
Carbide designation ISO US	–	P15–P40 C6–C5	–

[1)] For coated HSS end mill v_c 30–35 m/min. (98–115 f.p.m./min.)
[2)] Depending on radial depth of cut and cutter diameter

Grinding

A general grinding wheel recommendation is given below. More information can be found in the Uddeholm publication ”Grinding of tool steel”.

Type of grinding	Soft annealed condition	Hardened condition
Face grinding straight wheel	A 46 HV	A 46 HV
Face grinding segments	A 24 GV	A 36 GV
Cylindrical grinding	A 46 LV	A 60 KV
Internal grinding	A 46 JV	A 60 JV
Profile grinding	A 100 KV	A 120 JV

Welding

Good results when welding tool steel can be achieved if proper precautions are taken during the welding operation.

- The joints should be prepared properly.
- Repair welds should be made at elevated temperature. Make the two first layers with the same electrode diameter and/or current.
- Always keep the arc length as short as possible. The electrode should be angled at 90° to the joint sides to minimize undercut. In addition, the electrode should be held at an angle of 75–80° to the direction of forward travel.
- For large repairs, weld the initial layers with a soft filler material (buffering layer)

Filler material

TIG WELDING CONSUMABLES

Filler Material	Hardness after welding
Type AWS ER312	300 HB (for buffering layers)
UTP A67S	55–58 HRC
UTP A696	60–64 HRC
CastoTig 5*	60–64 HRC
Caldie TIG-Weld	58–62 HRC

* Should not be used for more then 4 layers because of the increased risk of cracking

MMA (SMAW) WELDING CONSUMABLES

Filler Material	Hardness after welding
Type AWS E312	300 HB (for buffering layers)
CASTOLIN 2	54–60 HRC
UTP 67S	55–58 HRC
UTP 69	60–64 HRC
CASTOLIN 6	60–64 HRC
Caldie TIG-Weld	58–62 HRC

Preheating temperature

The temperature of the tool during the entire welding process should be maintained at an even level.

	Soft annealed	Hardened
Hardness	230 HB	60–62 HRC
Preheating temperature	250°C (480°F)	250°C (480°F)
Max. interpass-temperature	400°C (750°F)	400°C (750°F)

Heat treatment after welding

	Soft annealed	Hardened
Hardness	230 HB	60–62 HRC
Cooling rate	20–40°C/h (40–80°F/h) for the first 2 hours then freely in air	
Heat treatment	Soft anneal Harden Temper	Temper 10–20°C (20–40°F) below the latest tempering temperature

More information on welding of tool steel can be found in the Uddeholm publication "Welding of Tool Steel".

Flame hardening

Use oxy-acetylene equipment with a capacity of 800–1250 l/h. Oxygen pressure 2,5 bar, acetylene pressure 1,5 bar. Adjust to give neutral flame.

Temperature: 980–1020°C (1795–1870°F). Cool freely in air.

The hardness at sthe surface will be 58–62 HRC and 41 HRC (400 HB) at a depth of 3–3,5 mm (0,12–0,14").

Electrical-discharge machining–EDM

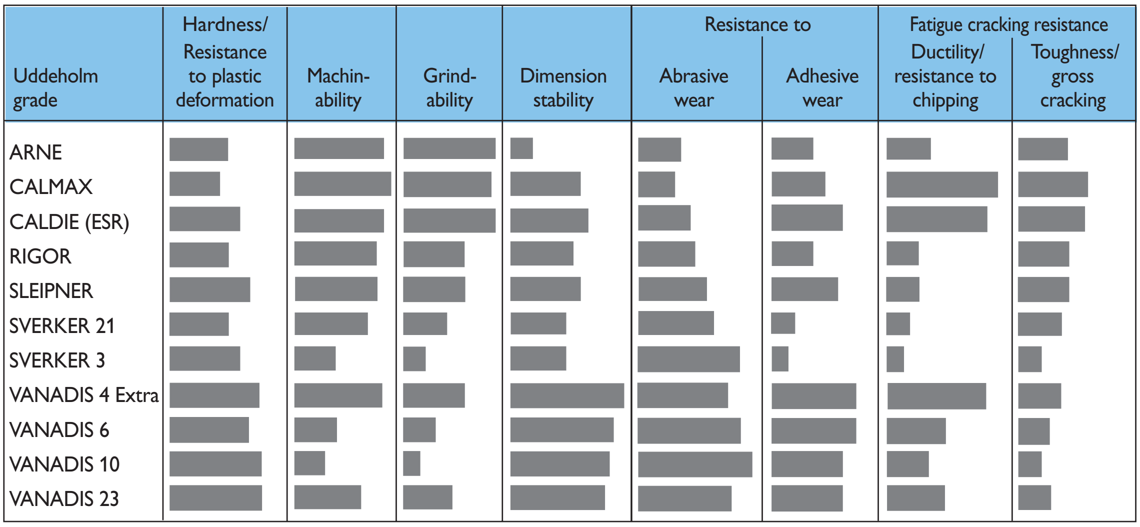
If EDM is performed in the hardened and tempered condition, finish with a fine-sparking, i.e. low current, high frequency.

For optimal performance the EDM'd surface should be ground/polished and the tool re-tempered at approx. 25°C (80°F) lower than the original tempering temperature.

When EDM' ing larger sizes or complicated shapes Uddeholm Sleipner should be tempered at high temperature, above 500°C (930°F).

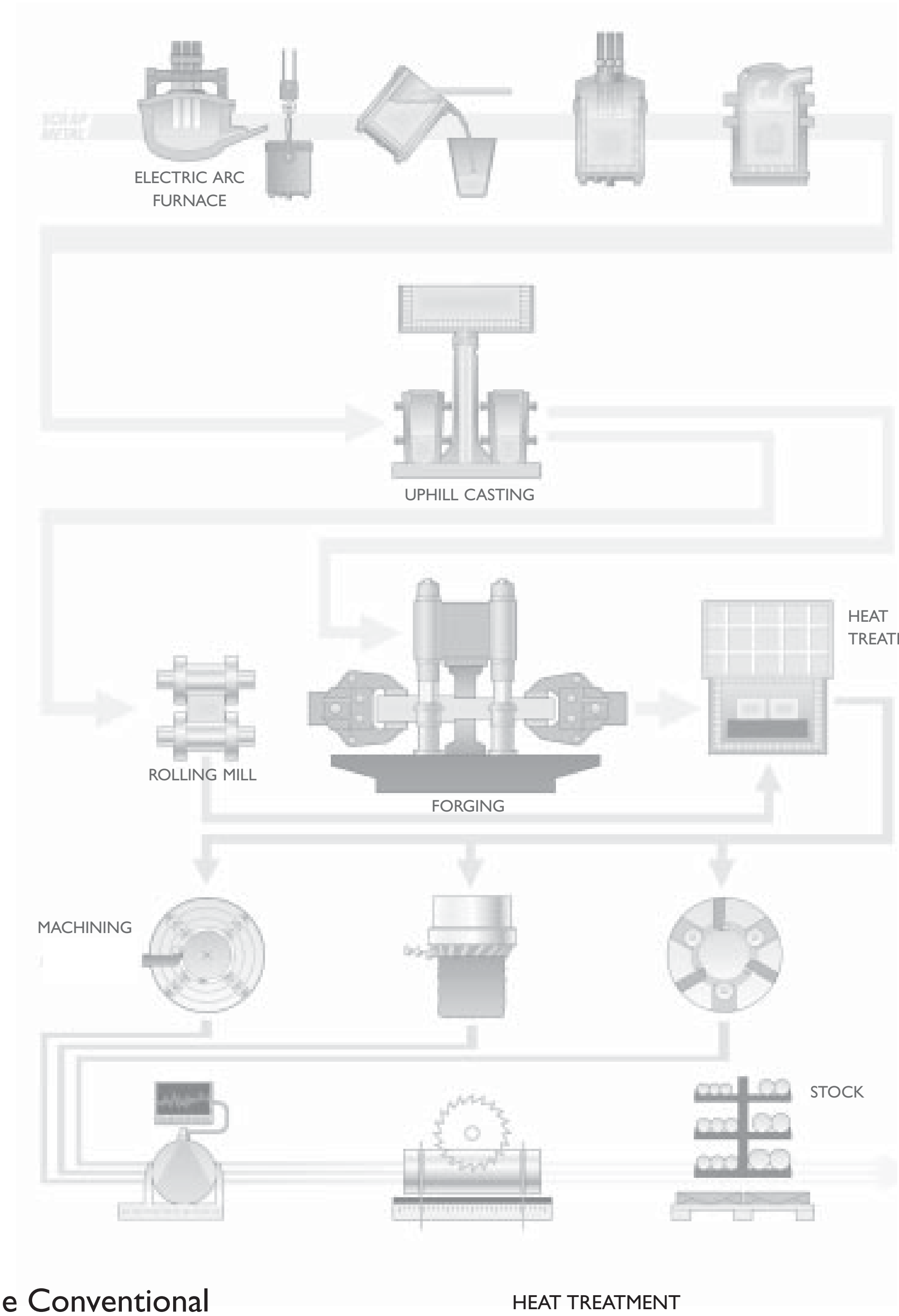
Relative comparison of Uddeholm cold work tool steel

Material properties and resistance to failure mechanisms



Further information

Please contact your local Uddeholm office for further information on the selection, heat treatment, application and availability of Uddeholm tool steel.



The Conventional Tool Steel Process

The starting material for our tool steel is carefully selected from high quality recyclable steel. Together with ferroalloys and slag formers, the recyclable steel is melted in an electric arc furnace. The molten steel is then tapped into a ladle.

The de-slagging unit removes oxygen-rich slag and after the de-oxidation, alloying and heating of the steel bath are carried out in the ladle furnace. Vacuum degassing removes elements such as hydrogen, nitrogen and sulphur.

In uphill casting the prepared moulds are filled with a controlled flow of molten steel from the ladle. From this, the steel goes directly to our rolling mill or to the forging press to be formed into round or flat bars.

HEAT TREATMENT

Prior to delivery all of the different bar materials are subjected to a heat treatment operation, either as soft annealing or hardening and tempering. These operations provide the steel with the right balance between hardness and toughness.

MACHINING

Before the material is finished and put into stock, we also rough machine the bar profiles to required size and exact tolerances.

In the lathe machining of large dimensions, the steel bar rotates against a stationary cutting tool. In peeling of smaller dimensions, the cutting tools revolve around the bar.

To safeguard our quality and guarantee the integrity of the tool steel we perform both surface- and ultrasonic inspections on all bars. We then remove the bar ends and any defects found during the inspection.

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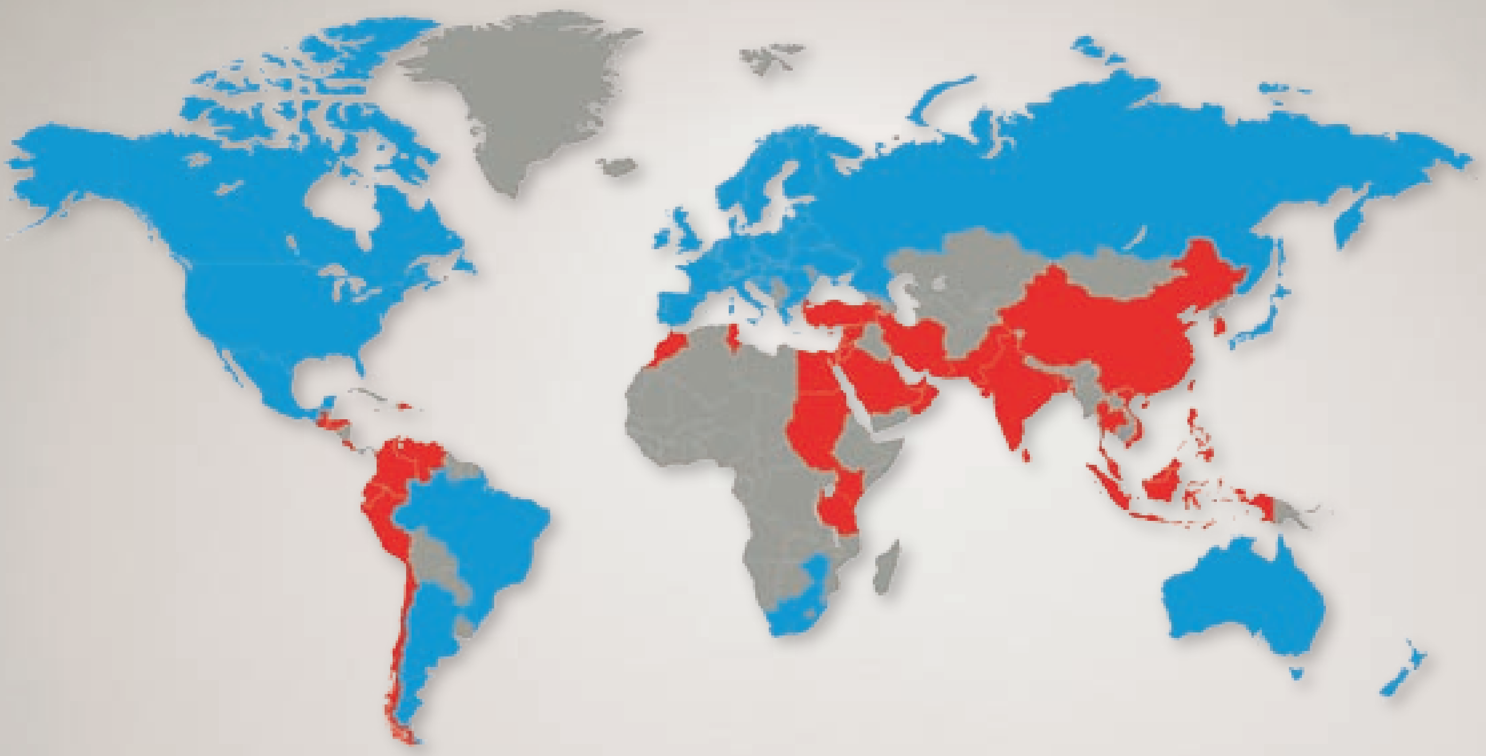

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