

# PLASTIC MOULD STEELS

## PREHARDENED CORROSION RESISTANT STEEL

### Application Segments

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Plastic Mould

### Available Product Variants

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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

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BÖHLER M300 is a prehardened corrosion-resistant martensitic chromium steel that can be tempered to a higher strength due to its carbon content. Due to the alloying with chromium and molybdenum, BÖHLER M300 has very good corrosion resistance and good wear resistance and is therefore suitable for molds for processing chemically aggressive molding compounds (e.g. PVC).

### Process Melting

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Airmelted

### Properties

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- > Toughness & Ductility : high
- > Wear Resistance : high
- > Machinability : very high
- > Dimensional stability : good
- > Polishability : good
- > Corrosion resistance : very high
- > No heat treatment necessary
- > Prehardened

### Applications

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- > Plastic Extrusion
- > General Components for Mechanical Engineering
- > Packaging industry
- > Mechanical Engineering
- > Electronic industry
- > Hotrunner systems
- > Blow Molding
- > Food processing industry
- > Injection Moulding
- > Screws and Barrels

### Technical data

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Material designation	
1.2316	SEL
X36CrMo17 ~X38CrMo16	EN

### Chemical composition (wt. %)

C	Si	Mn	Cr	Mo	Ni
0.38	0.4	0.65	16	1	0.8

### Delivery condition

Hardened and Tempered	
Hardness (HB)	280 to 330

### Heat treatment

Stress relieving		
Temperature	max. 570 °C	Prehardened material: When stress-relieving the material after processing, keep the material at temperature in a neutral atmosphere for at least 2 hours after complete heating, then slowly cool the oven at 20°C [68 °F]/hour to 200°C [392 °F], then cool in air.
Temperature		Newly hardened and tempered material: Carry out the stress relief heat treatment at approx. 50°C [122 °F] below the tempering temperature. After complete heating, hold at temperature for 1 to 2 hours in a neutral atmosphere, then slowly cool down the furnace.

### Physical Properties

Temperature (°C)	20
Density (kg/dm <sup>3</sup> )	7.71
Thermal conductivity (W/(m.K))	20.3
Specific heat (kJ/kg K)	0.442
Spec. electrical resistance (Ohm.mm <sup>2</sup> /m)	0.8
Modulus of elasticity (10 <sup>3</sup> N/mm <sup>2</sup> )	219

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

Temperature (°C)	100	200	300	400	500
Thermal expansion (10 <sup>-6</sup> m/(m.K))	10.4	10.8	11.1	11.5	11.8

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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