

# ENGINEERING STEELS

## CASE HARDENING STEELS

### Application Segments

Automotive

### Available Product Variants

Long Products

### Product Description

BÖHLER M121 ISOPLAST is a remelted nickel-chromium-molybdenum case-hardening steel for components with increased requirements for toughness and core strength.

### Process Melting

Airmelted + Remelted

### Properties

- > Toughness & Ductility : very high
- > Wear Resistance : high
- > Machinability : very high
- > Polishability : high
- > Micro-cleanliness : high

### Applications

> Mechanical Engineering

> Gears

### Technical data

Material designation		
~1.6657	SEL	
~14NiCrMo13-4	EN	
~EN36C	BS	

### Chemical composition (wt. %)

C	Si	Mn	Cr	Mo	Ni
0.14	0.28	0.55	0.9	0.13	3.15

### Delivery condition

Normalized, Tempered	
Hardness (HB)	max. 255

### Heat treatment

Case hardening		
Temperature	880 to 980 °C	For case hardening in the given temperature range, carburise (usually below 950°C [1.742°F]) and quench / oil, (water), hot bath (160 - 250°C [320 - 482°F]), air. Quenching in water generally only for large parts of simple mould. Achievable surface hardness after case hardening: min. 59 HRC

### Hardening and Tempering

Temperature	840 to 880 °C	For core hardening, heat and quench the material / oil, (water), hot bath (160 - 250°C [320 - 482°F]).
Temperature	150 to 200 °C	Tempering treatment: Single tempering.

### Physical Properties

<b>Temperature (°C)</b>	<b>20</b>
Density (kg/dm <sup>3</sup> )	7.85
Thermal conductivity (W/(m.K))	34
Specific heat (kJ/kg K)	0.46
Spec. electrical resistance (Ohm.mm <sup>2</sup> /m)	0.2
Modulus of elasticity (10 <sup>3</sup> N/mm <sup>2</sup> )	210

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

<b>Temperature (°C)</b>	<b>100</b>	<b>200</b>	<b>300</b>	<b>400</b>	<b>500</b>	<b>600</b>	<b>700</b>
Thermal expansion (10 <sup>-6</sup> m/(m.K))	11.1	12.1	12.9	13.5	13.9	14.1	14.2

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.

### voestalpine BÖHLER Edelstahl GmbH & Co KG

Mariazeller Straße 25  
8605 Kapfenberg, AT  
T. +43/50304/20-0  
E. [info@bohler-edelstahl.at](mailto:info@bohler-edelstahl.at)  
<https://www.voestalpine.com/bohler-edelstahl/de/>