

HOT WORK TOOL STEELS

Application Segments

Hot Work

Available Product Variants

Long Products*

Open Die Forgings

* Presented data refer exclusively to long products. Please observe the detailed explanations at the end of the data sheet (pdf).

Product Description

BÖHLER W303 ISODISC is a 5% chromium steel and corresponds to material number 1.2367 (X38CrMoV5-3). This tool steel has good hot toughness as well as a very high hot hardness and resistance against heat-checkings. Compared to an X37CrMoV5-1 (material number 1.2343), the steel has an increased molybdenum content, which significantly increases its thermal resistance and thus makes it the ideal material in die closed-die forging, open-die forging and extrusion.

Process Melting

Airmelted

Properties

- > Toughness & Ductility : good
- > Wear Resistance : high
- > Machinability : very high
- > Hot Hardness (red hardness) : high
- > Polishability : good
- > Thermal conductivity : good
- > Micro-cleanliness : good

Applications

- > Hot Extrusion
- > High Pressure Die-Casting
- > Mechanical Engineering
- > Forging (Hot / Semi-hot)
- > Press Hardening / Hot Stamping
- > Gravity / Low Pressure Die-Casting
- > Progressive Forging (Hatebur)

Technical data

| Material designation | | Standards | |
|----------------------|-----|-----------|--------|
| 1.2367 | SEL | 4957 | EN ISO |
| X38CrMoV5-3 | EN | | |

Chemical composition (wt. %)

| C | Si | Mn | Cr | Mo | V |
|------|------|------|------|------|------|
| 0.38 | 0.40 | 0.40 | 5.00 | 2.80 | 0.55 |

Material characteristics

| | High temperature strength | High temperature toughness | High temperature wear resistance | Machinability in as supplied condition | Polishability |
|----------------------------|---------------------------|----------------------------|----------------------------------|--|---------------|
| BÖHLER W303 ISODISC | ★★★★★ | ★★★ | ★★★★★ | ★★★★★ | ★★★ |
| BÖHLER W300 ISODISC | ★★ | ★★★ | ★★ | ★★★★★ | ★★★ |
| BÖHLER W300 ISOBLOC | ★★ | ★★★★★ | ★★ | ★★★★★ | ★★★★★ |
| BÖHLER W302 ISODISC | ★★★ | ★★★ | ★★★ | ★★★★★ | ★★★ |
| BÖHLER W302 ISOBLOC | ★★★ | ★★★★★ | ★★★ | ★★★★★ | ★★★★★ |
| BÖHLER W320 ISODISC | ★★★ | ★★ | ★★★ | ★★★★★ | ★★★ |
| BÖHLER W350 ISOBLOC | ★★★ | ★★★★★ | ★★★ | ★★★★★ | ★★★★★ |
| BÖHLER W360 ISOBLOC | ★★★★★ | ★★★★★ | ★★★★★ | ★★★★★ | ★★★★★ |
| BÖHLER W400 VMR | ★★ | ★★★★★ | ★★ | ★★★★★ | ★★★★★ |
| BÖHLER W403 VMR | ★★★★★ | ★★★★★ | ★★★★★ | ★★★★★ | ★★★★★ |

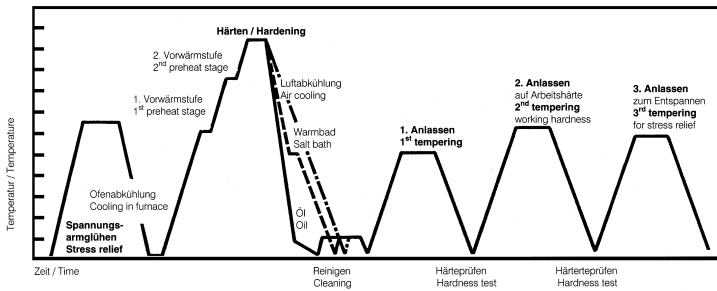
Delivery condition

| Annealed | |
|-----------------------|----------|
| Hardness (HB) | max. 229 |
| Hardened and Tempered | |
| Hardness (HRC) | 30 to 44 |

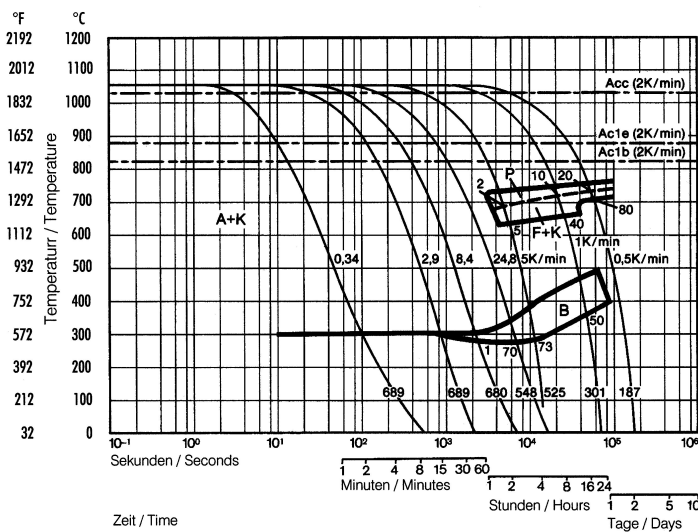
Heat treatment

| Annealing | | |
|-------------------------|-------------------|---|
| Temperature | 750 to 800 °C | Holding time 6 to 8 hours. Slow, controlled furnace cooling at 10 to 20°C/h (50 to 68 °F/hr) to approx. 600°C (1112°F), further cooling in air. |
| Stress relieving | | |
| Temperature | 600 to 670 °C | For stress relief after extensive machining or for complicated tools. Holding time depending on tool size after complete heating 2 - 6 hours in neutral atmosphere. Slow furnace cooling. |
| Hardening and Tempering | | |
| Temperature | 1,030 to 1,080 °C | Holding time after temperature equalization: 15 to 30 minutes; Quenching: Oil, salt bath (500 - 550°C [932-1022°F]), air, vacuum; After hardening, tempering to the desired working hardness (see tempering chart). |

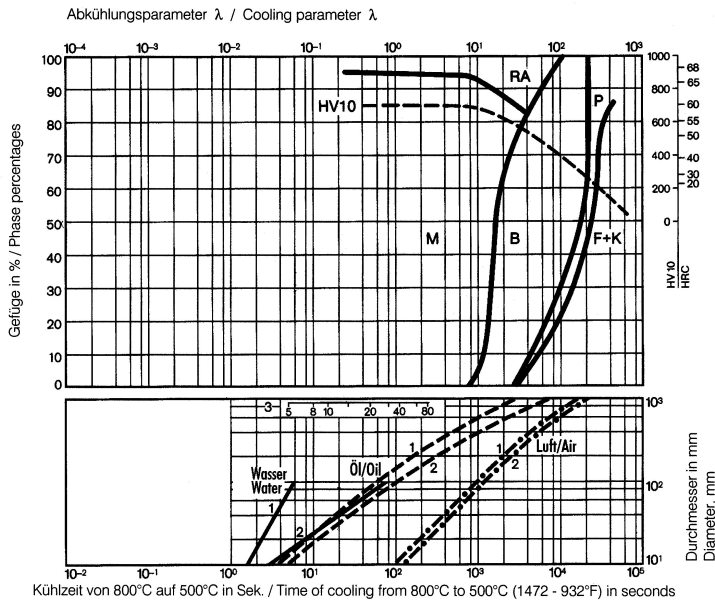
Heat treatment sequence



Continuous cooling CCT curves



Quantitative phase diagram

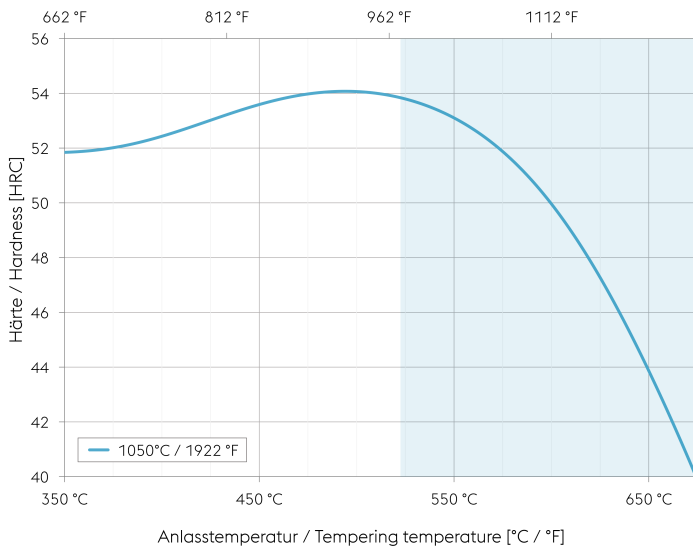


- A... Austenite
- B... Bainite
- F... Ferrite
- K... Carbide
- M... Martensite
- P... Perlite
- RA... Retained austenite

- - - - Oil cooling
- · - Air cooling

- 1... Edge or face
- 2... Core
- 3... Jominy test: distance from end

Tempering chart



Tempering:

Slow heating to tempering temperature immediately after hardening / time in furnace 1 hour for each 0,787 inch (20 mm) of work piece thickness but at least 2 hours / cooling in air. It is recommended to temper at least twice.

A third tempering cycle for the purpose of stress relieving may be advantageous.

1st tempering approx. 30°C (86°F) above maximum secondary hardness.

2nd tempering to desired working hardness.

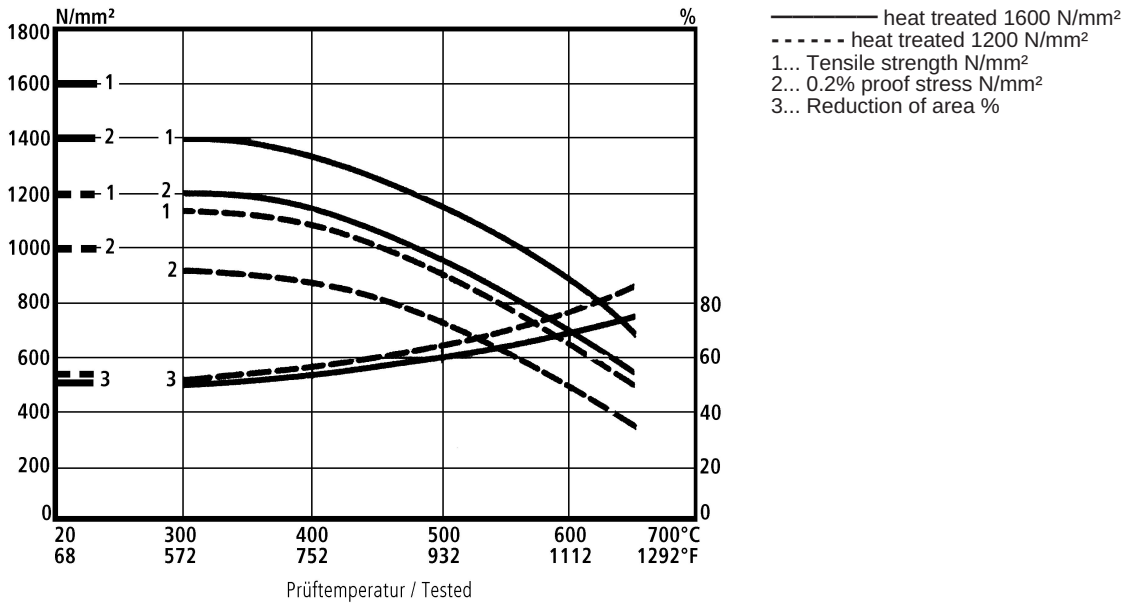
The tempering chart shows average tempered hardness values.

3rd for stress relieving at a temperature 86 to 122°F (30 - 50°C) below highest tempering temperature.

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

Hardening temperature: 1050°C (1922°F)
Specimen size: square 50 mm

Hot strength chart



Physical Properties

| | |
|--|-----------|
| Temperature (°C) | 20 |
| Density (kg/dm ³) | 7.9 |
| Thermal conductivity (W/(m.K)) | - |
| Specific heat (kJ/kg K) | 0.46 |
| Spec. electrical resistance (Ohm.mm ² /m) | 0.5 |
| Modulus of elasticity (10 ³ N/mm ²) | 215 |

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

| Temperature (°C) | 100 | 200 | 300 | 400 | 500 | 600 | 700 |
|--|------|-----|------|------|------|-----|------|
| Thermal expansion (10 ⁻⁶ m/(m.K)) | 11.5 | 12 | 12.2 | 12.5 | 12.9 | 13 | 13.2 |

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.

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