

OȚELURI PENTRU LUCRU LA RECE

Application Segments

Muncă la rece

Available Product Variants

Long Products*

Plates

* Datele prezentate se referă exclusiv la produsele lungi. Vă rugăm să respectați explicațiile detaliate de la sfârșitul fișei tehnice (pdf).

Product Description

BÖHLER K100 is a 12% ledeburitic chromium steel and corresponds to material number 1.2080 (X210Cr12). This commonly used tool steel is highly resistant to abrasive wear. Compared to modern cold work tool steels, BÖHLER K100 has the advantage of simple heat treatment with lower hardening temperatures and single tempering. However, this characteristic tempering behaviour limits the use of advanced coatings.

Process Melting

Aer topit

Properties

> Rezistență la uzură : good

Applications

- > Cuțit de mașină (pentru producători)
- > Blanking fin, ștanțare, blanking
- > Rulouri
- > Drilling
- > Pumping
- > Roll Forming
- > Laminare
- > Piese standard (matrițe, plăci, pini, perforatoare)
- > Piese de uzură
- > Clamping
- > Wear Applications
- > Cold Rolling incl. Sendzimir Rolls
- > Formare la rece
- > Componente pentru industria reciclării
- > Cuțite industriale
- > Mineral Processing
- > Inginerie mecanică
- > Industria ambalajelor

Technical data

Material designation		Standards	
1.2080	SEL	4957	EN ISO
X210Cr12	EN		
~T30403	UNS		
~D3	AISI		
~SKD1	JIS		

Chemical composition (wt. %)

C	Si	Mn	Cr
2.00	0.25	0.35	11.50

Material characteristics

	Compressive strength	Dimensional stability during heat treatment	Toughness	Wear resistance abrasive	Wear resistance adhesive
BÖHLER K100	★★	★★	★	★★★	★★
BÖHLER K105	★★	★★	★	★★	★★
BÖHLER K107	★★	★★	★	★★★	★★
BÖHLER K110	★★	★★★	★	★★★	★★
BÖHLER K190 MICROCLEAN	★★★★	★★★★★	★★★★★	★★★★★	★★★★★
BÖHLER K294 MICROCLEAN	★★★★★	★★★★★	★★★	★★★★★	★★★★★
BÖHLER K340 ISODUR	★★★	★★★★	★★★	★★★	★★★★
BÖHLER K340 ECOSTAR	★★★	★★★	★★	★★	★★
BÖHLER K346	★★★	★★★	★★★	★★★★	★★
BÖHLER K353	★★	★★★	★★	★★	★★
BÖHLER K360 ISODUR	★★★	★★★★	★★★	★★★★	★★★★
BÖHLER K390 MICROCLEAN	★★★★★	★★★★★	★★★★★	★★★★★	★★★★★
BÖHLER K490 MICROCLEAN	★★★★	★★★★★	★★★★	★★★★	★★★★
BÖHLER K497 MICROCLEAN	★★★★★	★★★★★	★★★	★★★★★	★★★★★
BÖHLER K888 MATRIX	★★★★	★★★★★	★★★★★	★★	★★
BÖHLER K890 MICROCLEAN	★★★★	★★★★★	★★★★★	★★★	★★★

Delivery condition

Recoaptă	
Hardness (HB)	max. 248

Heat treatment

Recoacere

Temperature	800 to 850 °C	Slow controlled cooling in furnace at a rate of 10 to 20 °C/hr (18 to 36 °F/hr) down to approximately 600 °C (1112 °F) Further cooling in air.
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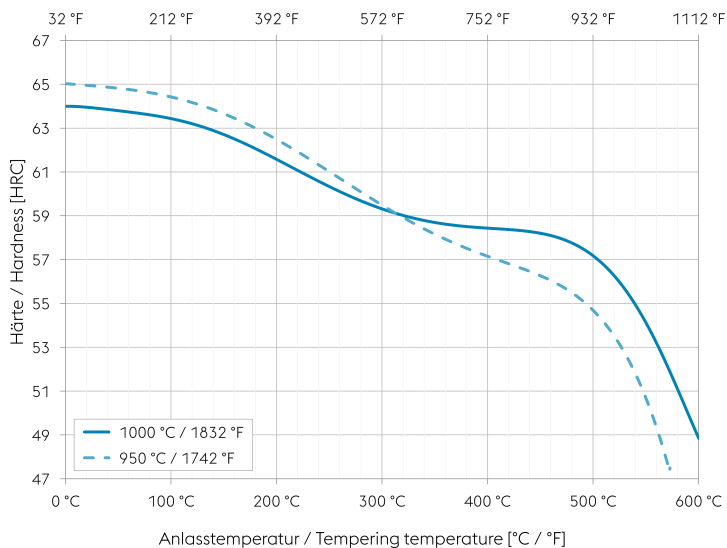
Eliminarea stresului

Temperature	650 °C	After through heating, hold in neutral atmosphere for 1-2 hours. Slow cooling in furnace Intended to relieve stresses caused by extensive machining or in complex shapes.
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Călire și revenire

Temperature	940 to 970 °C	Quenching: Oil, salt bath (220 to 250 °C or 500 to 550 °C 428 to 482 °F or 932 to 1022 °F), gas, compressed or still air if thickness does not exceed 25 mm (0,98 inch) and if hardening temperature is on the upper side of the range. Holding time after temperature equalization: 15 to 30 minutes. After hardening, tempering to the desired working hardness according to the tempering chart.
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Tempering chart



Specimen size: square 20 mm (0,787 inch)

Slow heating to tempering temperature immediately after hardening.

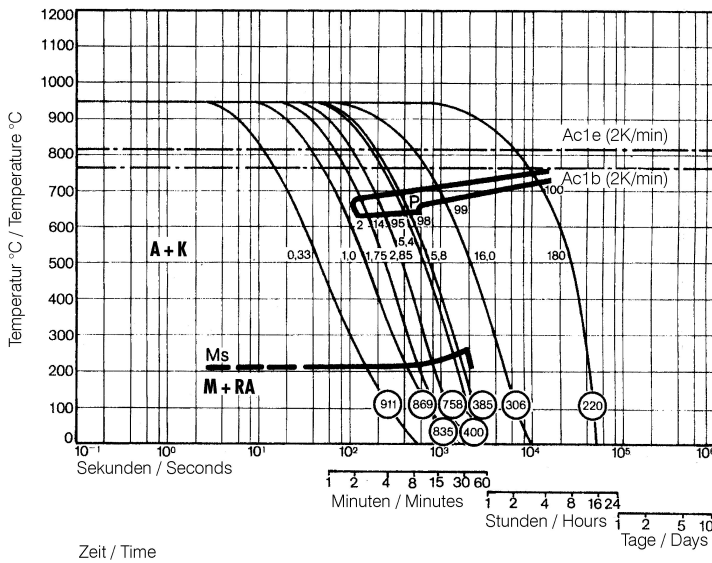
Time in furnace 1 hour for each 20 mm (0,787 inch) of workpiece thickness but at least 2 hours.

Please refer to the tempering chart for guide values for the achievable hardness after tempering.

Tempering for stress relieving 30 to 50 °C (86 to 122 °F) below the highest tempering temperature.

Cooling in air after each tempering step is recommended.

Continuous cooling CCT curves



Austenitising temperature: 950 °C (1742 °F)

Holding time: 30 minutes

○ Vickers hardness

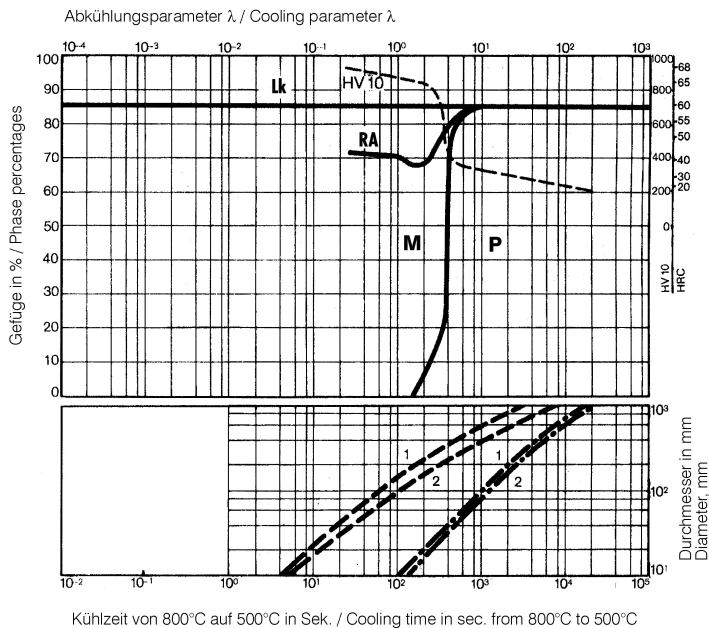
2...100 phase percentages

0.33...180 cooling parameter λ , i.e. duration of cooling from 800 to 500 °C (1472 to 932 °F) in $s \times 10^{-2}$

2 K/min... cooling rate in the range of 800 to 500 °C (1472 to 932 °F)

- A... Austenite
- K... Carbide
- P... Pearlite
- M... Martensite
- RA... Retained austenite
- Ms... Martensite starting temperature

Quantitative phase diagram



HV10... Vickers Hardness

Lk... Ledeburite carbide

RA... Residual austenite

M... Martensite

P... Pearlite

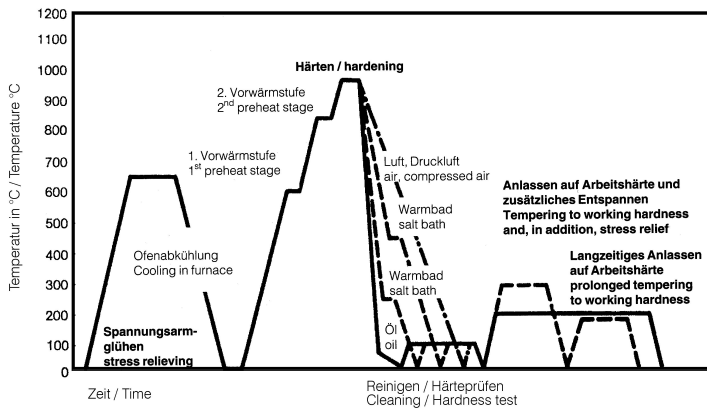
--- Oil cooling

-.- Air cooling

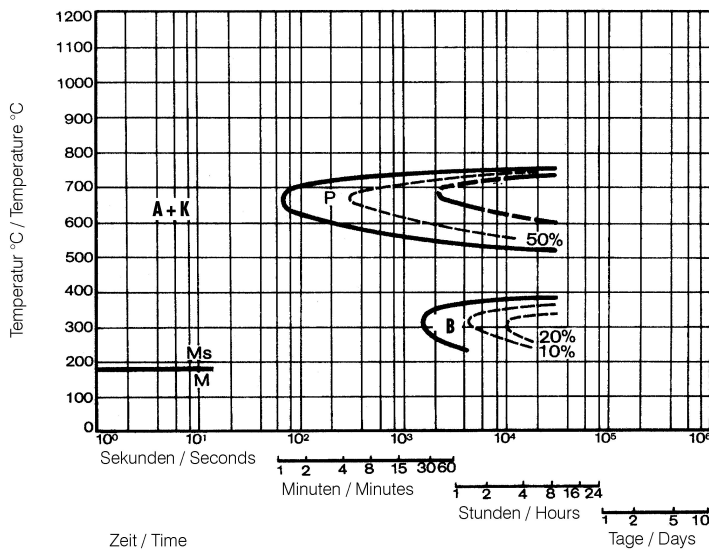
1... Edge or face

2... Core

Heat treatment sequence



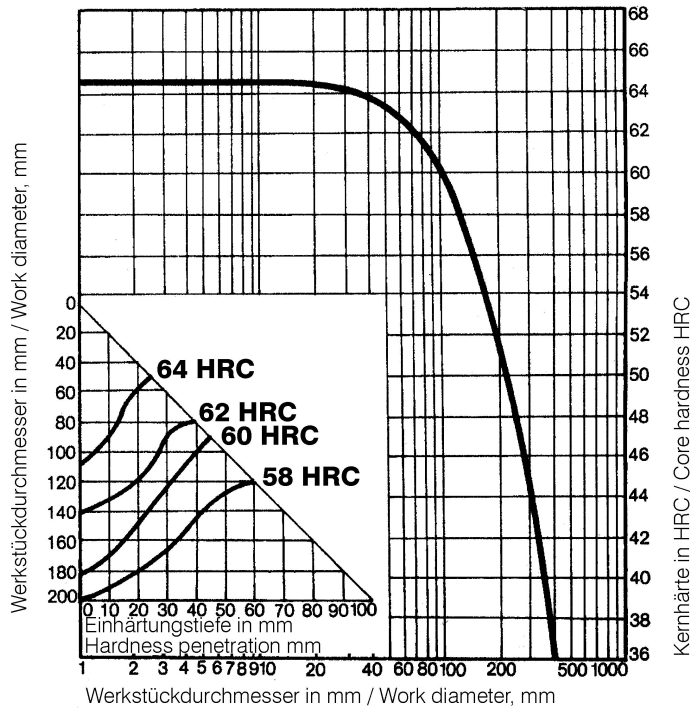
Isothermal TTT curves



Austenitising temperature: 950 °C (1742 °F)
 Holding time: 30 minutes

- A... Austenite
- K... Carbide
- P... Pearlite
- B... Bainite
- M... Martensite
- Ms... Martensite starting temperature

Influence of work diameter on core hardness and hardness penetration



Hardening temperature: 950 °C (1742 °F)
Quenchant: Oil

Physical Properties

Temperature (°C)	20
Density (kg/dm ³)	7.7
Thermal conductivity (W/(m.K))	20
Specific heat (kJ/kg K)	0.46
Spec. electrical resistance (Ohm.mm ² /m)	0.65
Modulus of elasticity (10 ⁹ N/mm ²)	210

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

Temperature (°C)	100	200	300	400	500	600
Thermal expansion (10 ⁻⁶ m/(m.K))	10.5	11	11	11.5	12	12

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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