

# HOT WORK TOOL STEELS

## Application Segments

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Hot Work

## Available Product Variants

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Long Products\*

Plates

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

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BÖHLER W360 ISOBLOC is a material produced by the electroslag remelting process (ESR), which has been specially adapted for use at high tool hardnesses in the range of 51-57 HRC. Although the steel can be classified as a 5% chromium steel, the increased carbon and molybdenum content coupled with state-of-the-art manufacturing technology ensures that BÖHLER W360 ISOBLOC still shows a very good toughness and an exceptionally good thermal resistance, even at high hardness levels. These properties make the steel the perfect choice for smaller components in the die casting sector (e.g., mold inserts, cores, core pins, ejector pins, etc.). The material also is frequently the preferred choice for closed-die and open-die forging tools due to its high wear resistance. Because of this excellent wear resistance and the high toughness, BÖHLER W360 ISOBLOC is also frequently used for cold work applications and as a molding material for plastic injection molds. The Steel also is available as powder material for metal-3D-printing under the brand name BÖHLER W360 AMPO.

## Process Melting

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Airmelted + Remelted

## Properties

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

## Applications

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- > High Pressure Die-Casting
- > Hot Extrusion
- > Gravity / Low Pressure Die-Casting
- > Rolling
- > Cold Forming
- > Machine knife (for producers)
- > Screws and Barrels
- > Glasfibre reinforced plastics
- > Extrusion
- > Drilling
- > Gears
- > Packaging industry
- > Forging (Hot / Semi-hot)
- > Fine Blanking, Stamping, Blanking
- > Injection Moulding
- > Industrial Knives
- > Fasteners, Bolts, Nuts
- > Powder Pressing
- > Standard Parts (Moulds, Plates, Pins, Punches)
- > Cutting
- > Wear Applications
- > Camshafts
- > Roll Forming
- > Progressive Forging (Hatebur)
- > Coining
- > Press Hardening / Hot Stamping
- > Mechanical Engineering
- > Forging Applications
- > Rolls
- > Pill punching dies
- > Grinding
- > Mineral Processing
- > Driveshafts
- > Cold Rolling incl. Sendzimir Rolls

## Technical data

Material designation	
BÖHLER patent	Market grade

## Chemical composition (wt. %)

C	Si	Mn	Cr	Mo	V
0.50	0.20	0.25	4.50	3.00	0.60

## Material characteristics

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

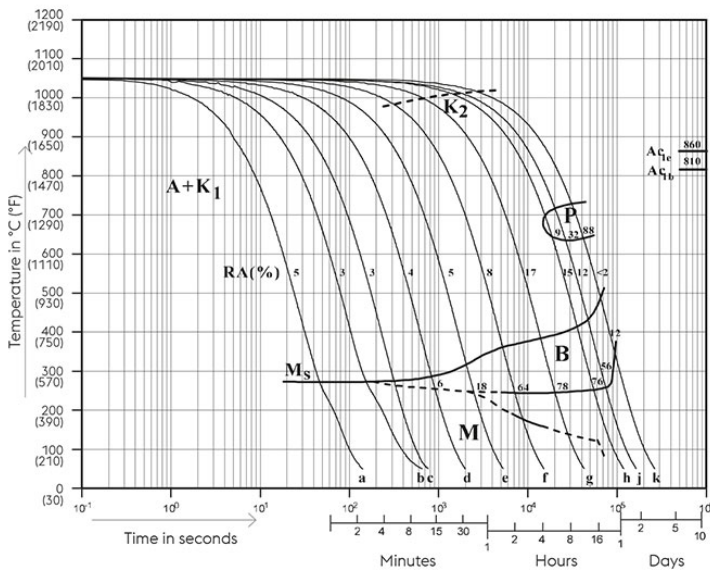
## Delivery condition

Annealed	
Hardness (HB)	max. 205

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	650 to 700 °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	1,050 °C	Holding time after temperature equalization: 15 to 30 minutes; In order to prevent coarsening of the grain, hardening must be carried out at the recommended temperature; Quenching: oil, salt bath (500 - 550°C [930 to 1020 °F]), air, inert gas in vacuum; After hardening, required tempering treatment to achieve desired working hardness (see tempering chart).

Continuous cooling CCT curves

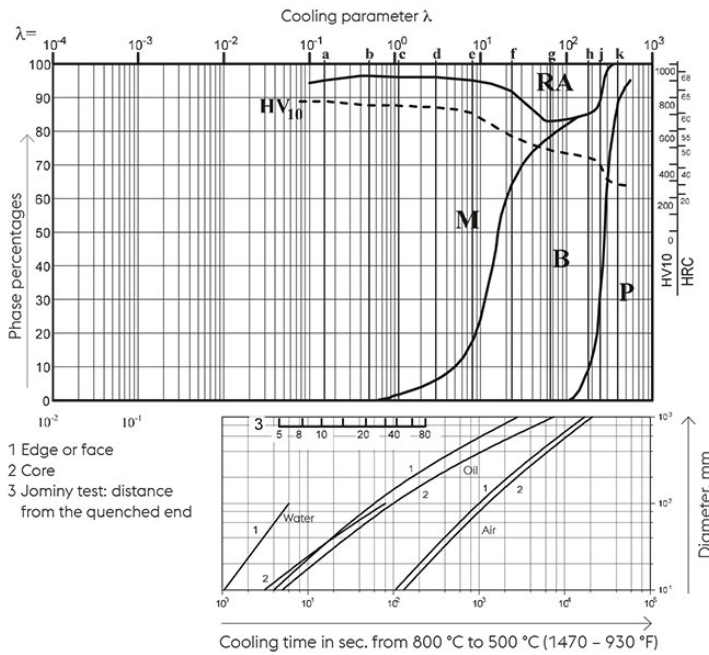


Austenitising temperature: 1050°C (1922°F)  
 Holding time: 30 minutes  
 5...100 phase percentages  
 0.5...400 cooling parameter, i.e. duration of cooling from 800 - 500°C (1472-932°F) in s x 10<sup>-2</sup>

Table:

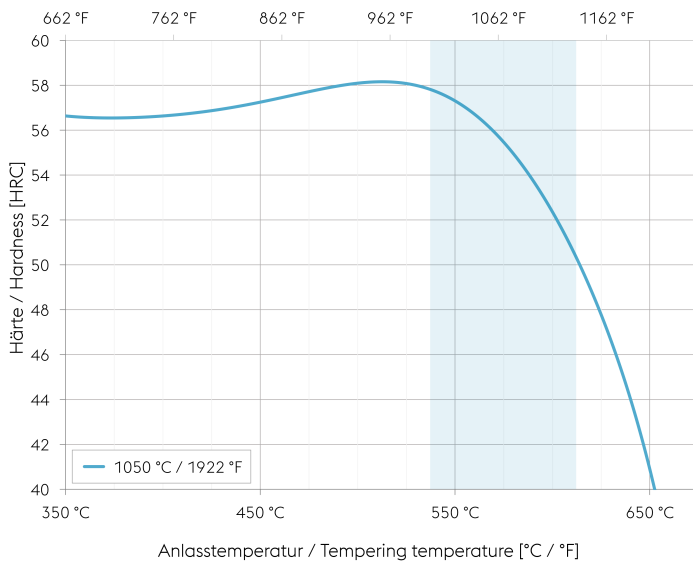
Sample	λ	HV10	Sample	λ	HV10
a	0,15	785	f	23	582
b	0,50	760	g	65	498
c	1,10	762	h	180	453
d	3	754	j	250	415
e	8	724	k	400	294

Quantitative phase diagram



A... Austenite  
 B... Bainite  
 K... Carbide  
 M... Martensite  
 P... Pearlite  
 RA... Retained austenite

Tempering chart



**Tempering:**

Slow heating to tempering temperature immediately after hardening (time in furnace 1 hour for each 0,787 inch (20 mm) of workpiece 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. 86°F (30°C) 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 to 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

## Physical Properties

Temperature (°C)	20
Density (kg/dm <sup>3</sup> )	7.8
Thermal conductivity (W/(m.K))	30.8
Specific heat (kJ/kg K)	0.43
Spec. electrical resistance (Ohm.mm <sup>2</sup> /m)	-
Modulus of elasticity (10 <sup>3</sup> N/mm <sup>2</sup> )	212

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

Temperature (°C)	100	200	300	400	500	600
Thermal expansion (10 <sup>-6</sup> m/(m.K))	10.8	11.6	12.1	12.5	12.8	13.3

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/>



ONE STEP AHEAD.