

# HIGH SPEED STEELS

## Application Segments

- Cutting Tools
- Automotive

## Available Product Variants

- 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

### BÖHLER S600 – "The high-speed steel"

Ideal for mills, twist drills, and taps, broaches, cold-work tools. BÖHLER S600 is the most commonly used high-speed steel and is the starting material for our customers who deal with high-speed steel.

## Process Melting

- Airmelted or Airmelted + ESR (ISORAPID)

## Properties

- > Toughness & Ductility : high
- > Wear Resistance : high
- > Compressive strength : high
- > Edge Stability : high
- > Grindability : high
- > Hot Hardness (red hardness) : high

## Applications

- > Broaches and Reamers
- > Cold Forming / Coining
- > Fine Blanking, Stamping, Blanking
- > Gear Cutting, Shaving and Shaping Tools
- > Injection Components
- > Other Automotive Components (Turbochargers, Piston Rings, Sensors, etc.)
- > Powder Pressing
- > Rolling
- > Shearing / Machine Knives
- > Special Cutting Tools
- > Standard Parts (Molds, Plates, Pins, Punches)
- > Twist Drills and Taps
- > Wear parts
- > Thread rolling
- > Blades for Sawing Machines

## Technical data

Material designation		Standards	
1.3343	SEL	4957	EN ISO
HS6-5-2C	EN		

Chemical composition (wt. %)

C	Cr	Mo	V	W
0.9	4.1	5	1.8	6.2

Material characteristics

	Compressive strength	Grindability	Red hardness	Toughness	Wear resistance	Edge Stability
BÖHLER S600	★★★	★★★	★★★	★★	★★	★★★
BÖHLER S200	★★★	★★	★★★	★★	★★★	★★
BÖHLER S400	★★★	★★★	★★★	★★★	★★	★★
BÖHLER S401	★★	★★★	★★	★★★	★★	★★★
BÖHLER S404	★★	★★★	★★	★★★	★★	★★
BÖHLER S405	★★★	★★★	★★	★★★	★★	★★
BÖHLER S430	★★	★★★	★★	★★★	★★	★★
BÖHLER S500	★★★★	★★★	★★★★	★★	★★★	★★★
BÖHLER S601	★★★	★★★	★★★	★★	★★	★★★
BÖHLER S607	★★★	★★★	★★★	★★	★★★	★★★
BÖHLER S630	★★★	★★★	★★★	★★	★★	★★★
BÖHLER S705	★★★	★★★	★★★★	★★	★★	★★★★
BÖHLER S730	★★★	★★★	★★★★	★★	★★	★★★★

Delivery condition

Annealed

Hardness (HB)	max. 280
Ultimate tensile strength (UTS) (MPa)	max. 950
Tensile Strength (MPa)	max. 950

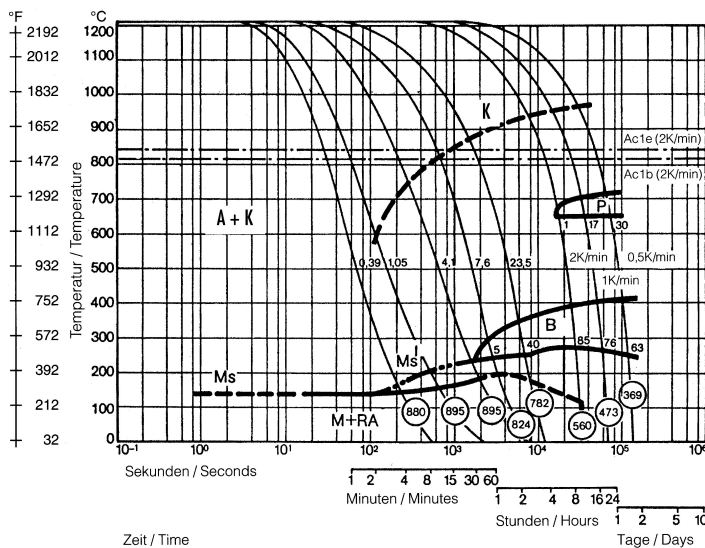
Hardened and Tempered

Hardness (HRC)	min. 62   bars hardened and tempered (BHT)
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## Heat treatment

Annealing		
Temperature	770 to 840 °C	Controlled slow cooling in furnace (10 - 20°C / h (50 - 68°F / h)) to approx. 600°C (1110°F), air cooling.
Stress relieving		
Temperature	600 to 650 °C	Slow cooling furnace.    To relieve stresses set up by extensive machining or in tools of intricate shape.    After through heating, hold in neutral atmosphere for 1 to 2 hours.
Hardening and Tempering		
Temperature	1,100 to 1,210 °C	Salt bath, vacuum    Preheating: 1st stage ~ 500 °C, 2nd stage ~ 850 °C, 3rd stage ~1050 °C    Austenitising: 1100 - 1210 °C, holding time after complete heating 80 seconds, maximum 150 seconds, to avoid material damage due to overheating.   Quenching: oil, warm bath (500 - 550 °C), gas
Temperature	550 to 570 °C	Slow heating to tempering temperature immediately after austenitising.    Dwell time in the furnace 1 hour per 20 mm material thickness (at least 1 hour)    Slow cooling to room temperature    3 tempering cycles recommended    Hardness see tempering chart

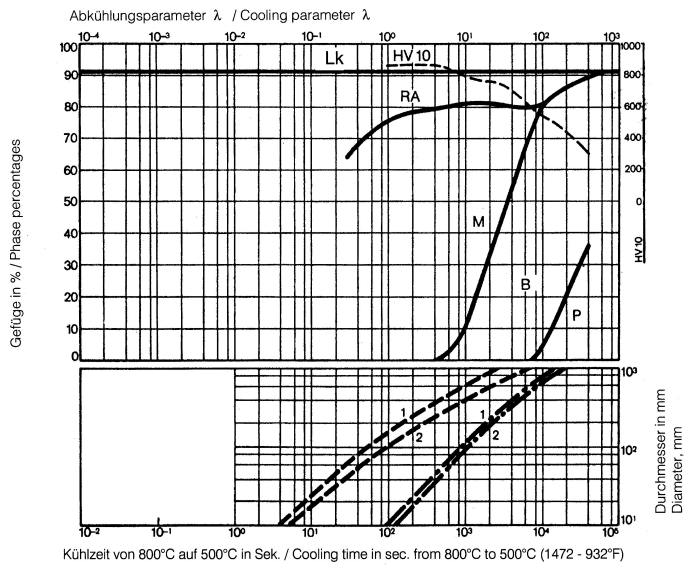
## Continuous cooling CCT curves



Austenitising temperature: 1210°C (2210°F)  
Holding time: 180 seconds

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

**Quantitative phase diagram**

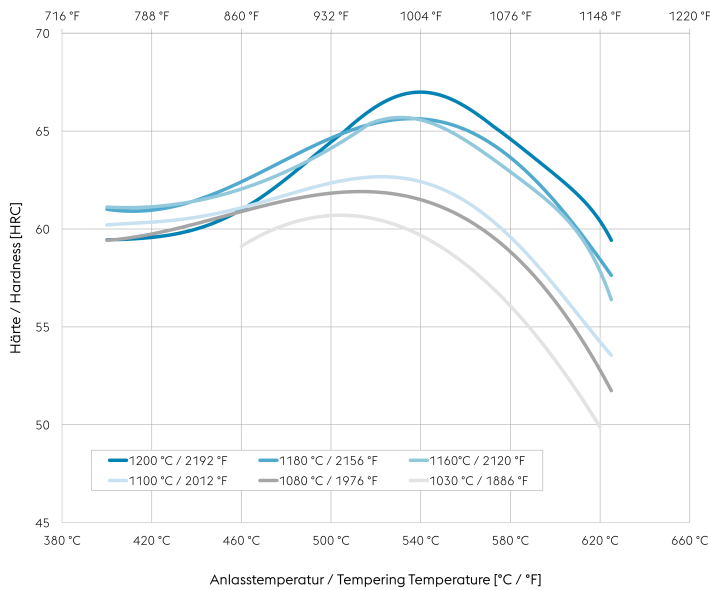


A....Austenite  
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1....Edge or Face  
 2....Core  
 3....Jominy test: distance from quenched end

-- oilcooling  
 - - - aircooling

**Tempering Chart**



Vacuum

Holding time 3 x 2 hours  
 Specimen size: square 25 mm

## Physical Properties

<b>Temperature (°C)</b>	<b>20</b>
Density (kg/dm <sup>3</sup> )	8.07
Thermal conductivity (W/(m.K))	21.8
Specific heat (kJ/kg K)	0.433
Spec. electrical resistance (Ohm.mm <sup>2</sup> /m)	0.47
Modulus of elasticity (10 <sup>3</sup> N/mm <sup>2</sup> )	219

## 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))	11.5	11.7	12.2	12.4	12.7	13	12.9

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.