

NÁSTROJOVÉ OCELI PRO PRÁCI ZA STUDENA

Rozměrový sortiment k dispozici

Tyčová ocel*

Plech

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

Popis produktu

BÖHLER K107 is a 12% ledeburitic chromium steel and corresponds to material number 1.2436 (X210CrW12). Due to the higher tungsten content, BÖHLER K107 achieves a higher resistance to abrasive wear compared to the conventional tool steel 1.2080. Compared to modern cold work tool steels, BÖHLER K107 has the advantage of simple heat treatment with lower hardening temperatures and single tempering. However, this characteristic tempering behaviour limits the use of modern coatings.

Trasa tavení

Airmelted

Vlastnosti

- > Odolnost proti opotřebení : dobré

Použití

- > Průmyslové nože
- > Přesné stříhání, lisování, ražení plechu
- > Díly odolné proti opotřebení
- > Válcování
- > Normálie (formy, plechy, kolíky, střížníky)
- > Všeobecné díly pro strojírenství
- > Tváření za studena
- > Komponenty pro recyklační průmysl

Technické údaje

Označení materiálu		Normy	
1.2436	SEL	4957	EN ISO
X210CrW12	EN		
~ D6	AISI		

Chemické složení

C	Si	Mn	Cr	W
2,10	0,25	0,40	11,50	0,70

Materiálové vlastnosti

	Tlaková zatížitelnost	Rozměrová stabilita při tepelném zpracování	Houževnatost	Odolnost proti opotřebení abrazivní	Odolnost proti opotřebení adhezivní
BÖHLER K107	★★	★★	★	★★★	★★
BÖHLER K100	★★	★★	★	★★★	★★
BÖHLER K105	★★	★★	★	★★	★★
BÖHLER K110	★★	★★★	★	★★★	★★
BÖHLER K190 MICROCLEAN®	★★★★★	★★★★★	★★★★★	★★★★★	★★★★★
BÖHLER K294 MICROCLEAN®	★★★★★	★★★★★	★★★	★★★★★	★★★★★
BÖHLER K340 ECOSTAR®	★★★	★★★	★★	★★	★★
BÖHLER K340 ISODUR®	★★★	★★★★★	★★★	★★★	★★★★★
BÖHLER K346	★★★	★★★	★★★	★★★★★	★★
BÖHLER K353	★★	★★★	★★	★★	★★
BÖHLER K360 ISODUR®	★★★	★★★★★	★★★	★★★★★	★★★★★
BÖHLER K390 MICROCLEAN®	★★★★★	★★★★★	★★★★★	★★★★★	★★★★★
BÖHLER K490 MICROCLEAN®	★★★★★	★★★★★	★★★★★	★★★★★	★★★★★
BÖHLER K497 MICROCLEAN®	★★★★★	★★★★★	★★★	★★★★★	★★★★★
BÖHLER K888 MATRIX	★★★★★	★★★★★	★★★★★	★★	★★
BÖHLER K890 MICROCLEAN®	★★★★★	★★★★★	★★★★★	★★★	★★★

Stav dodání

Žiháno

Tvrdość (HB)	max. 250
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Tepelné zpracování

Annealing

Teplota	800 na 850 °C	Slow controlled cooling in furnace at a rate of 50 - 68°F/hr (10 to 20°C/hr) down to approx. 1112°F (600°C), further cooling in air.
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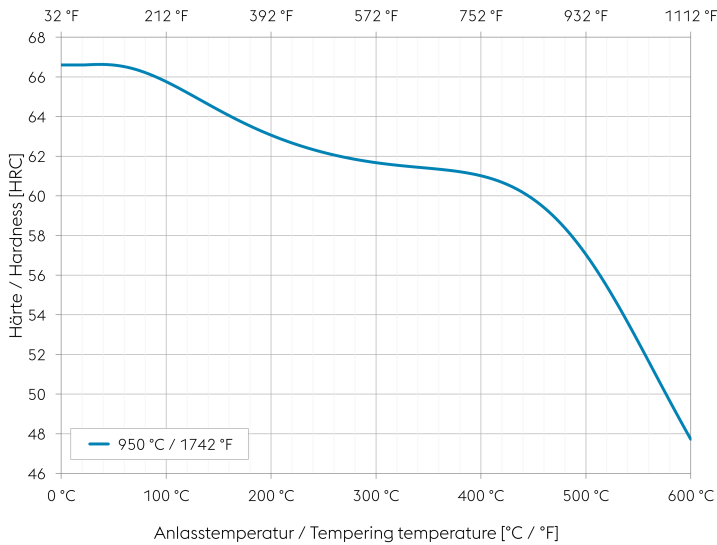
Žihání na odstranění vnitřního pnutí

Teplota	650 na 700 °C	Slow cooling in furnace. Intended to relieve stresses set up by extensive machining, or in complex shapes. After through heating, hold in neutral atmosphere for 1 - 2 hours
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Kalení a popouštění

Teplota	950 na 980 °C	Oil, salt bath 428 to 482°F or 932 to 1022°F (220 to 250°C or 500 to 550°C), air, oil, still air, gas; Holding time after temperature equalization: 15 to 30 minutes. Special treatment: Hardening 1868°F (1020°C) and tempering at 932°F (500°C). After hardening, tempering to the desired working hardness, see tempering chart.
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Tempering chart



Tempering:

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

Slow heating to tempering temperature immediately after hardening.

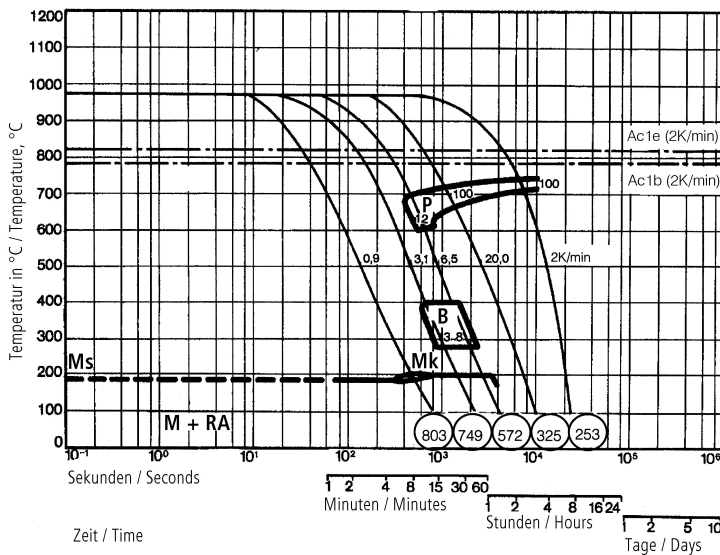
Time in furnace 1 hour for each 0,787 inch (20 mm) of workpiece thickness but at least 2 hours/cooling in air.

Slow cooling to room temperature after each tempering step is recommended.

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

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

Continuous cooling CCT curves



Austenitising temperature: 1796°F (980°C)
Holding time: 30 minutes

O Vickers hardness

3...100 phase percentages

0.9...20.0 cooling parameter, i.e. duration of cooling

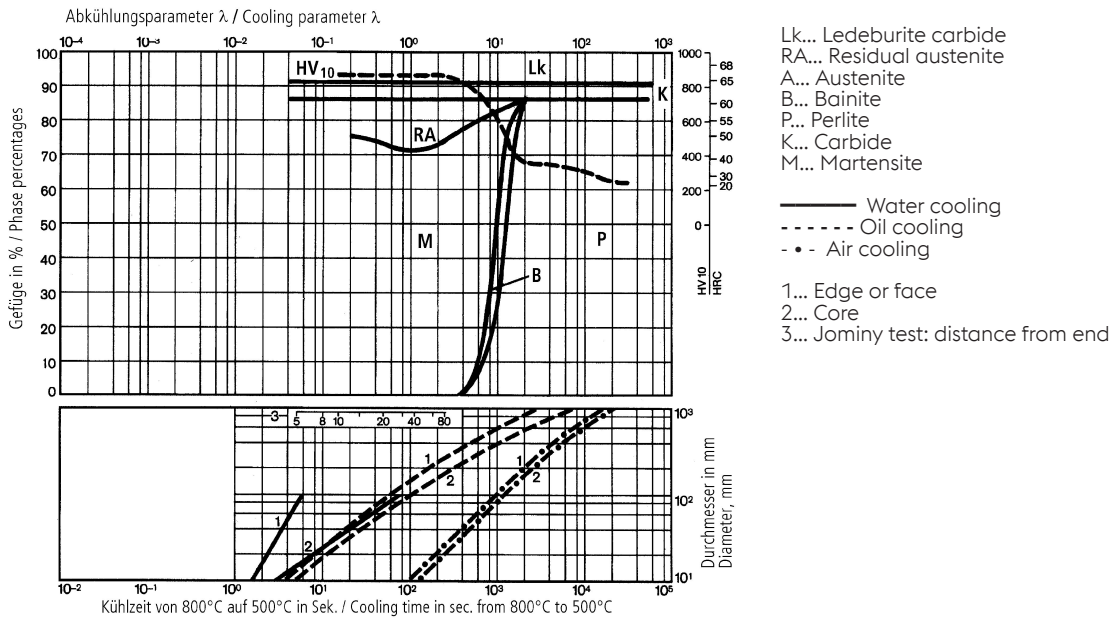
from 1472 to 932°F (800 to 500°C) in $s \times 10^{-2}$

35,6°F/min (2 K/min) cooling rate in °F/min (K/min) in

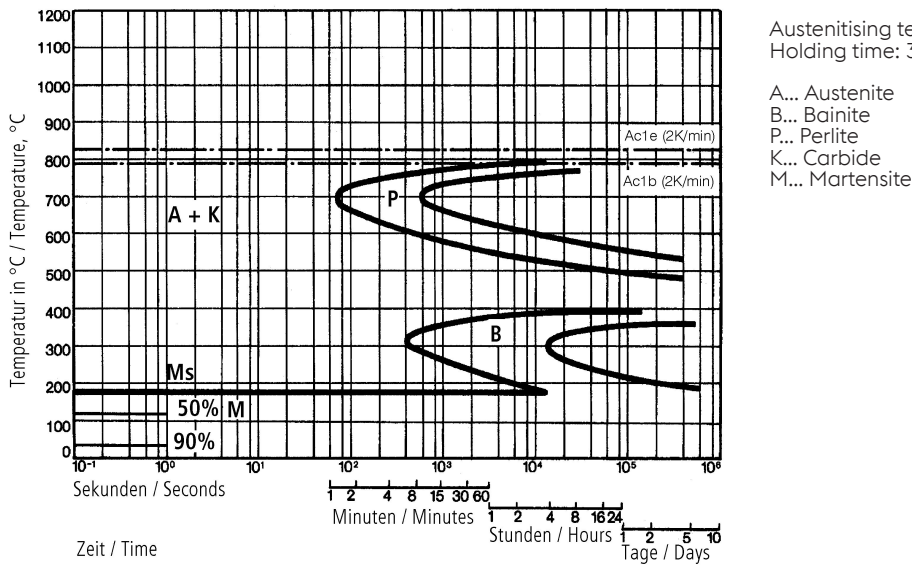
the 1472 to 932°F (800 to 500°C) range

Mk... Grain boundary martensite

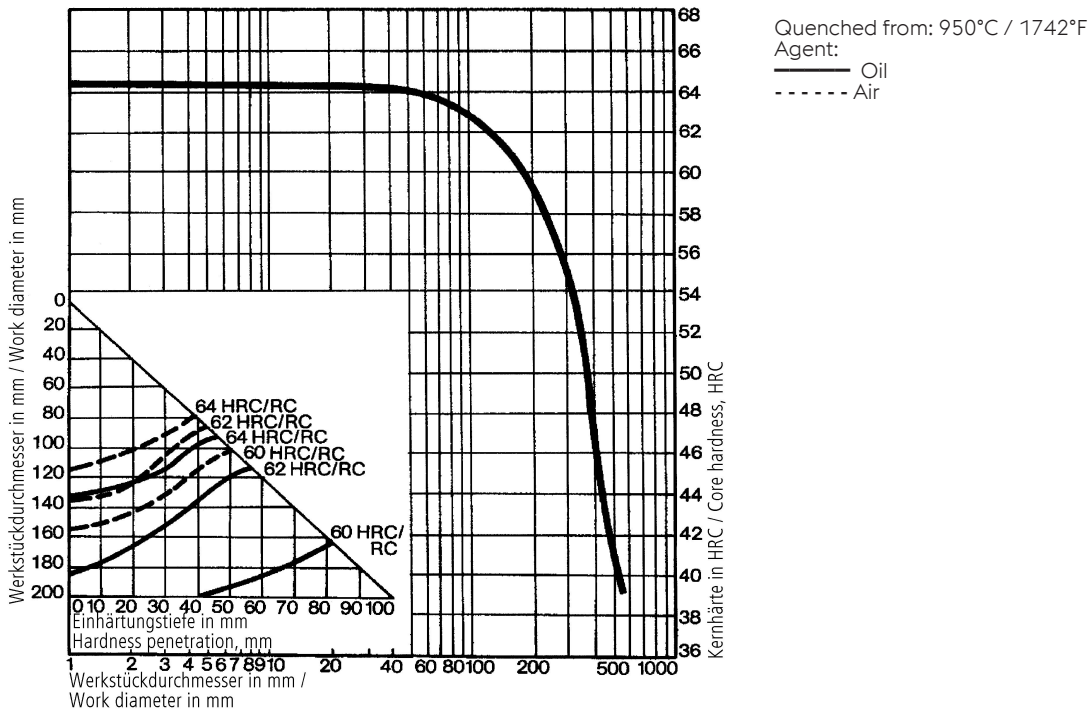
Quantitative phase diagram



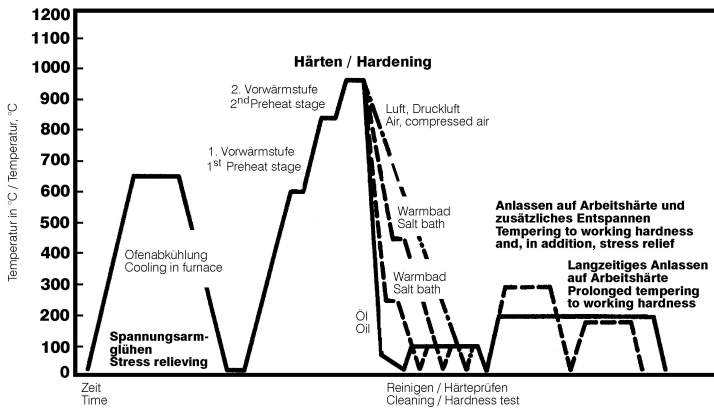
Isothermal TTT curves



Influence of work diameter on core hardness and hardness penetration



Heat treatment sequence



Fyzikální vlastnosti

Teplota (°C)	20
Hustota (kg/dm ³)	7,7
Tepelná vodivost (W/(m.K))	20
Měrná tepelná kapacita (kJ/kg K)	0,46
Měrný elektrický odpor (Ohm.mm ² /m)	0,65
Modul pružnosti (10 ³ N/mm ²)	210

Tepelná roztažnost

Teplota (°C)	100	200	300	400	500	600
Tepelná roztažnost (10 ⁻⁶ m/(m.K))	10,5	11	11	11,5	12	12

Long Products: For additional specifications and technical requirements, please contact our regional voestalpine BÖHLER sales companies.

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