

COLD WORK TOOL STEELS

Application Segments

Cold Work

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 K110 is a 12% ledeburitic chromium steel and corresponds to material number 1.2379 (X153CrMoV12, D2). This tool steel combines the advantages of conventional 12% ledeburitic chromium steels with those of advanced tool steels. In the group of 12% ledeburitic chromium steels, BÖHLER K110 offers the best combination of wear resistance, compressive strength and toughness, for which reason it is used in virtually all cold work applications. Its advantageous tempering behavior with a pronounced secondary hardness maximum also enables the use of advanced coatings. This also makes BÖHLER K110 suitable for complex tools requiring a high degree of dimensional stability and shape stability.

Process Melting

Airmelted

Properties

- > Wear Resistance : good
- > Dimensional stability : good

Applications

- > Machine knife (for producers)
- > Coining
- > Standard Parts (Molds, Plates, Pins, Punches)
- > Components for underground construction (drilling, shafts, etc.)
- > General Components for Mechanical Engineering
- > Rolling
- > Fine Blanking, Stamping, Blanking
- > Screws and Barrels
- > Rolls
- > Thread rolling
- > Cold Forming
- > Powder Pressing
- > Components for the recycling industry
- > Wear parts

Technical data

Material designation		Standards	
1.2379	SEL	4957	EN ISO
X153CrMoV12	EN		
~T30402	UNS		
D2	AISI		

Chemical composition (wt. %)

C	Si	Mn	Cr	Mo	V
1.55	0.30	0.30	11.30	0.75	0.75

Material characteristics

	Compressive strength	Dimensional stability during heat treatment	Toughness	Wear resistance abrasive	Wear resistance adhesive
BÖHLER K110	★★	★★★	★	★★★	★★
BÖHLER K100	★★	★★	★	★★★	★★
BÖHLER K105	★★	★★	★	★★	★★
BÖHLER K107	★★	★★	★	★★★	★★
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	★★★★	★★★★★	★★★★★	★★★	★★★

Delivery condition

Annealed	
Hardness (HB)	max. 250

Heat treatment

Annealing

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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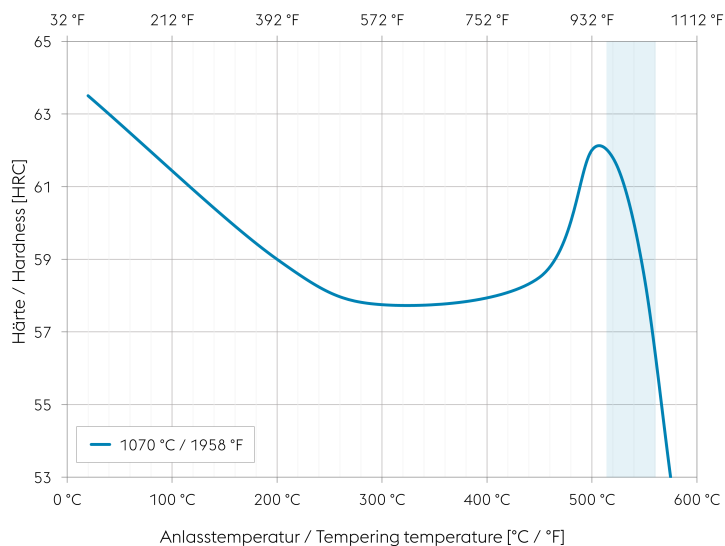
Stress relieving

Temperature	650 to 700 °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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Hardening and Tempering

Temperature	1,030 to 1,070 °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. Tools of intricate shape or with sharp edges should preferably be hardened in air. 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.

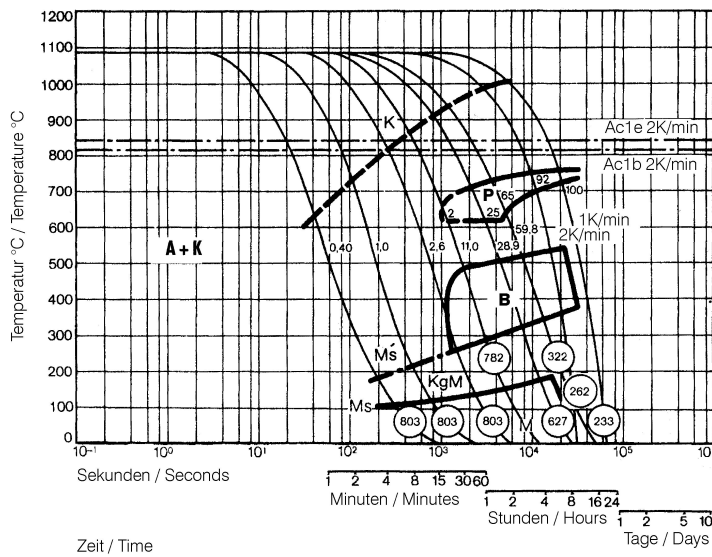
It is recommended to temper at least three times above the secondary hardness maximum.

Cooling in air to room temperature after each tempering step is recommended.

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

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

Continuous cooling CCT curves



Austenitising temperature: 1080 °C (1976 °F)
Holding time: 30 minutes

○ Vickers hardness

2...100 phase percentages

0.40...59.8 cooling parameter λ , i.e. duration of cooling from 800 to 500 °C (1472 to 932 °F) in $s \times 10^{-2}$

1...2 K/min... cooling rate in the range of 800 to 500 °C (1472 to 932 °F)

A... Austenite

K... Carbide

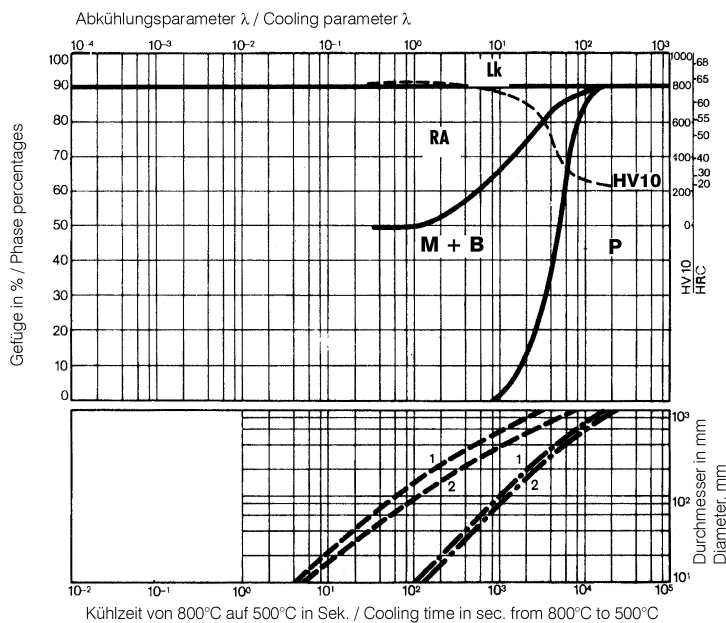
P... Pearlite

B... Bainite

M... Martensite

Ms... Martensite starting temperature

Quantitative phase diagram



HV10... Vickers Hardness

Lk... Ledeburite carbide

RA... Residual austenite

M... Martensite

B... Bainite

P... Pearlite

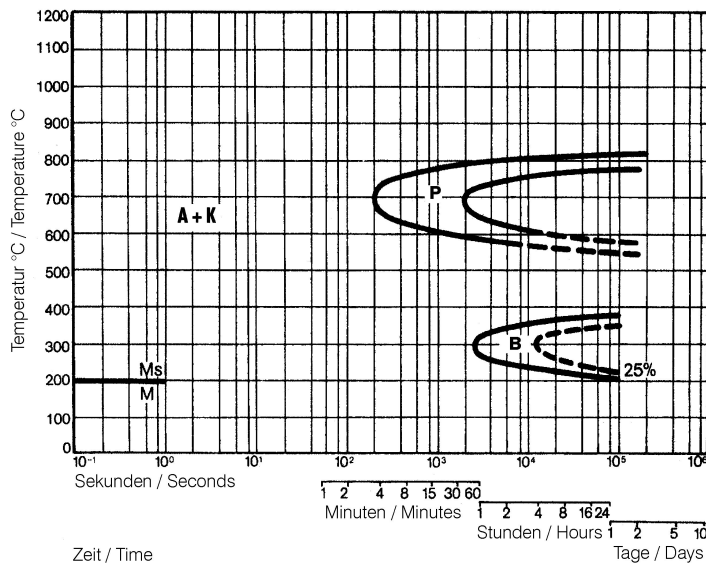
--- Oil cooling

- - - Air cooling

1... Edge or face

2... Core

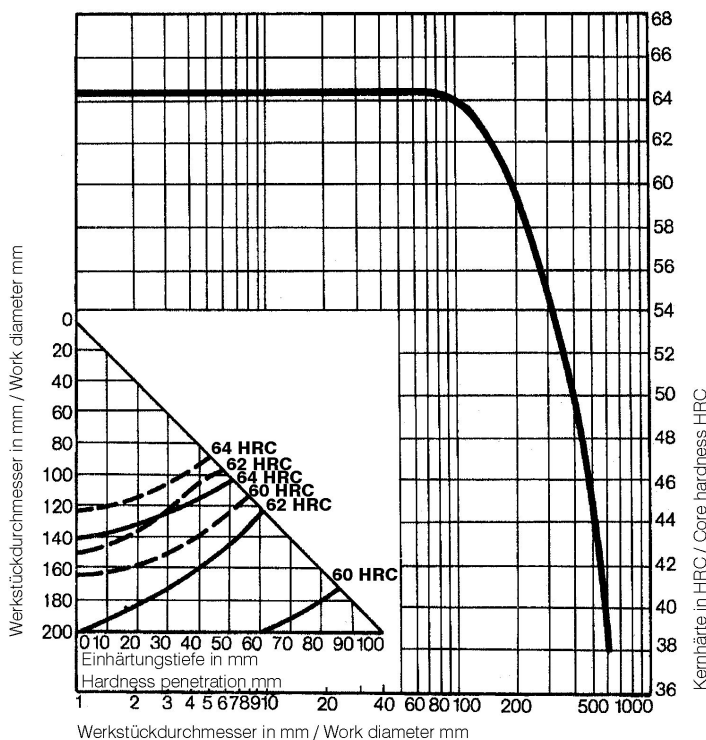
Isothermal TTT curves



Austenitising temperature: 1020 °C / 1868 °F
Holding time: 30 minutes

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

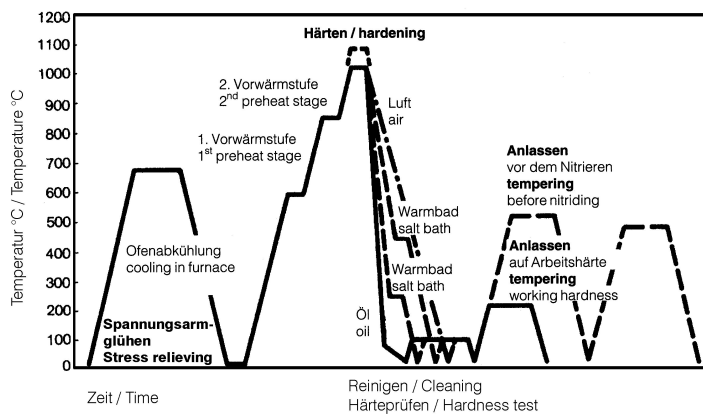
Influence of work diameter on core hardness and hardness penetration



Quenched from: 1030 °C / 1886 °F

Quenchant:
— Oil
- - - Air

Heat treatment sequence



Physical Properties

Temperature (°C)	20
Density (kg/dm ³)	7.67
Thermal conductivity (W/(m.K))	23.9
Specific heat (kJ/kg K)	0.47
Spec. electrical resistance (Ohm.mm ² /m)	0.65
Modulus of elasticity (10 ³ N/mm ²)	200

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	11.4	11.9	12.2	12.7	12.8	12.1

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<https://www.voestalpine.com/bohler-edelstahl/de/>**voestalpine**

ONE STEP AHEAD.