

# 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 K353 belongs to the group of conventionally produced 8% chromium steels. It is used in situations where chipper steels like 1.2360 are insufficient in terms of wear resistance and tool steels like 1.2379 (D2) do not have sufficient toughness. BÖHLER K353 is especially suitable for industrial knives for the woodworking industry. It is also used for stamping and cutting tools.

## Process Melting

Airmelted

## Properties

> Dimensional stability : good

## Applications

- > Machine knife (for producers)
- > Press Hardening / Hot Stamping
- > Cold Forming
- > Hotrunner systems
- > Fine Blanking, Stamping, Blanking

## Chemical composition (wt. %)

C	Si	Mn	Cr	Mo	V	Al
0.82	0.70	0.40	8.00	1.60	0.60	+

## Material characteristics

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

## Delivery condition

### Annealed

Hardness (HB)	max. 240
---------------	----------

## 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.
-------------	---------------	---

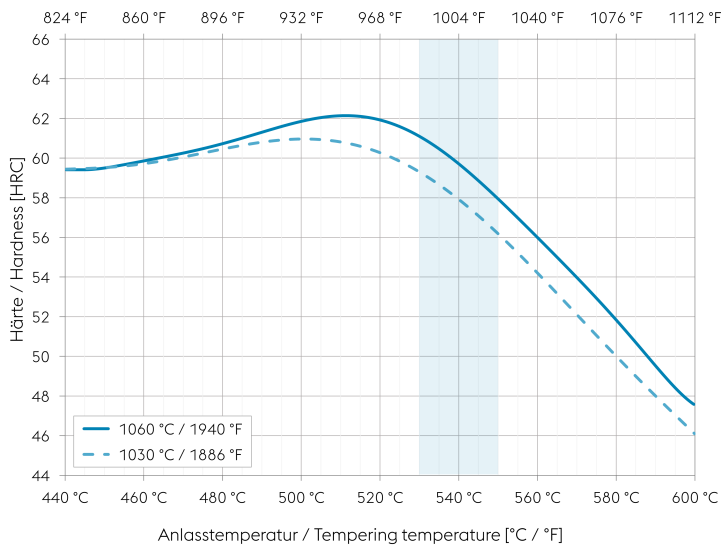
### Stress relieving

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.
-------------	--------	---

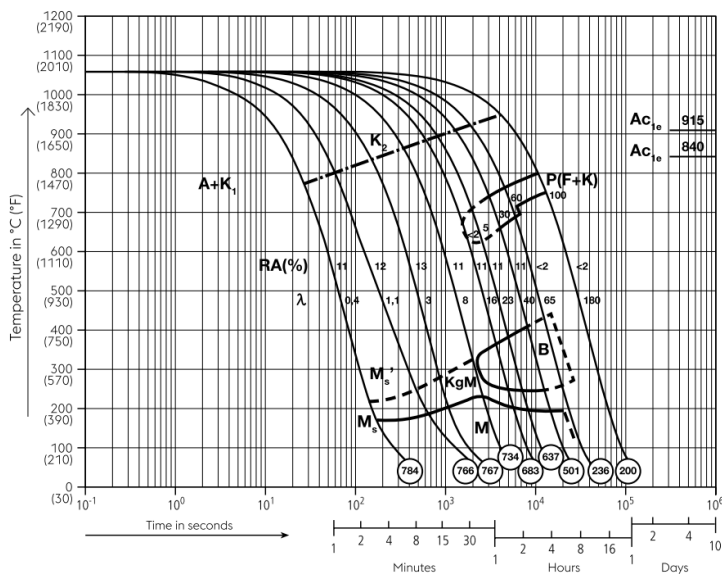
### Hardening and Tempering

Temperature	1,030 to 1,060 °C	Quenching: Oil, salt bath, gas.    Holding time after temperature equalization: 15 to 30 minutes.    After hardening, tempering to the desired working hardness according to the tempering chart.
-------------	-------------------	---

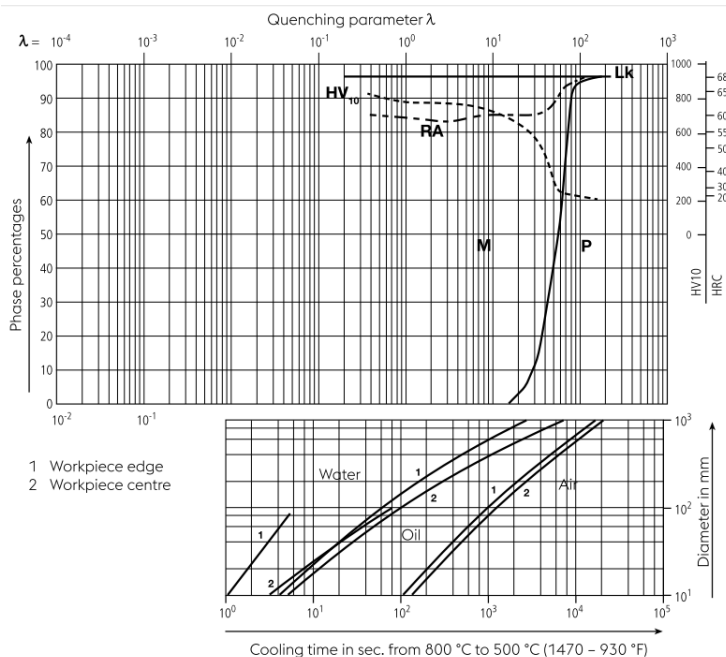
## Tempering chart



## Continuous cooling CCT curves



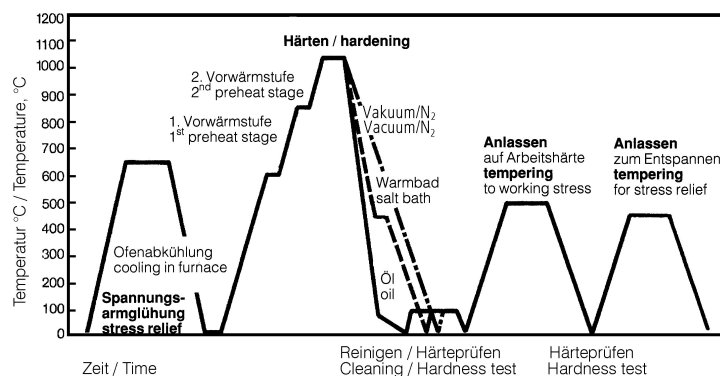
## Quantitative phase diagram



O Vickers hardness  
LK... Ledgeburitic carbides  
RA... Retained austenite  
M... Martensite  
P... Pearlite

1... Edge or face  
2... Core

## Heat treatment sequence



## Physical Properties

Temperature (°C)	20
Density (kg/dm <sup>3</sup> )	7.7
Thermal conductivity (W/(m.K))	21.9
Specific heat (kJ/kg K)	0.47
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
Thermal expansion ( $10^{-6}$ m/(m.K))	11	11.3	11.6	12	12.4

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.