BÖHLER

BÖHLER K105

COLD WORK STEELS

Available Product Shapes

Long Products | Open Die Forgings | Plates

Product Description

High-duty cutting tools (dies and punches), blanking and punching tools, woodworking tools, shear blades for cutting light-gauge material, thread rolling tools, tools for drawing, deep drawing and cold extrusion, pressing tools for the ceramics and pharmaceutical industries, cold rools (working rolls) for multiple-roll stands, measuring instruments and gauges, small moulds for the plastics industry where excellent wear resistance is required.

Properties

- Dimensionally stable, high carbon, high-chromium (12%) steel.
- Particularly suitable for air hardening.
- Good toughness.

Applications

- Machine knife (for producers)
- Fine Blanking, Stamping, Blanking
- Rolls
- Rolling
- Standard Parts (Molds, Plates, Pins, Punches)
- Wear parts
- Cold Forming
- Components for Recycling Industry
- General Components for Mechanical Engineering

Technical data

Material designation	
1.2601	SEL
~T30402	UNS
X165CrMoV12	EN
~D2	AISI
~Ch12MF	GOST

Chemical composition (wt. %)

C	Si	Mn	Cr	Mo	V	W
1.6	0.35	0.3	11.5	0.6	0.3	0.5

Material characteristics

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

Delivery condition

Annealed

Hardness	max. 250 HB

Heat treatment

Annealing

Temperature (°C | °F)	800 | 1472 to 850 | 1562	Slow controlled cooling in furnace at a rate of 50 to 68°F/hr (10 to 20°C/hr) down to approx. 600°C, further cooling in air.

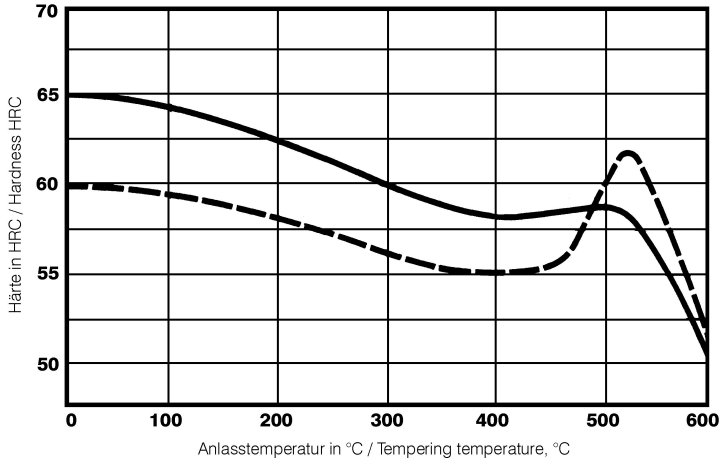
Stress relieving

Temperature (°C | °F)	650 | 1202 to 700 | 1292	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 to 2 hours..

Hardening and Tempering

Temperature (°C | °F)	980 | 1796 to 1010 | 1850	Oil, salt bath from 428 to 482°F or 932 to 1022°F (220 to 250°C or 500 to 550°C), air, gas. Tools of intricate shape or with sharp edges should preferably be hardened in air or salt bath. Holding time after temperature equalization: 15 to 30 minutes. After hardening, tempering to the desired working hardness, see tempering chart.

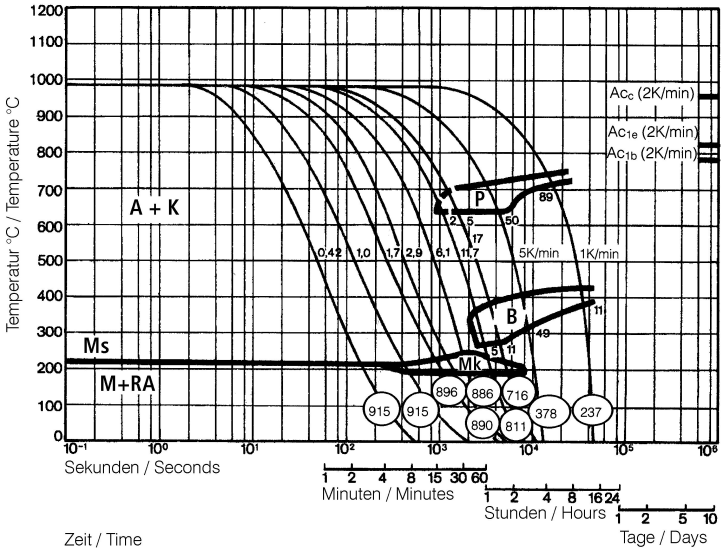
Tempering chart



Tempering:

Hardening temperature:
——— 980°C / 1796°F
- - - - - - 1080°C / 1976°F
Specimen size: square 20 mm

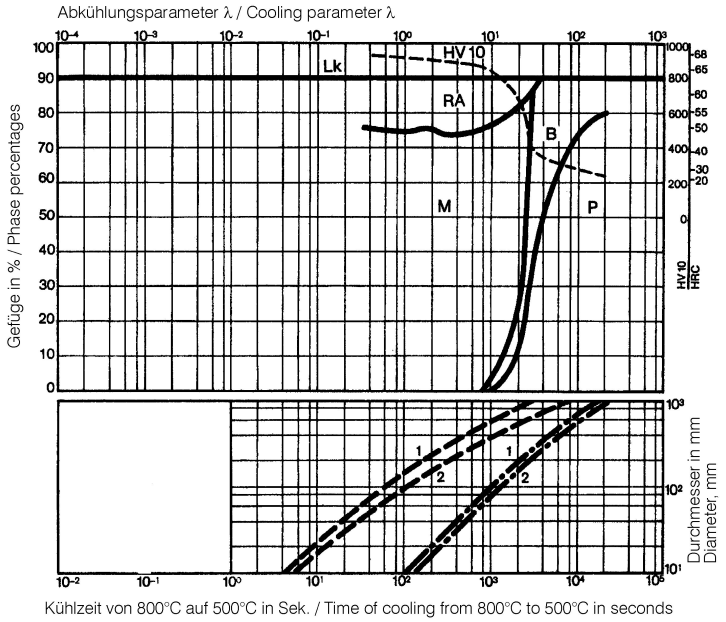
Continuous cooling CCT curves



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

O Vickers hardness
2...50 phase percentages
0.42...17 cooling parameter (λ), i.e. duration of cooling from 1472 to 932°F (800 to 500°C) in s x 10^{-2}
41...33,8°F/min (5...1K/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

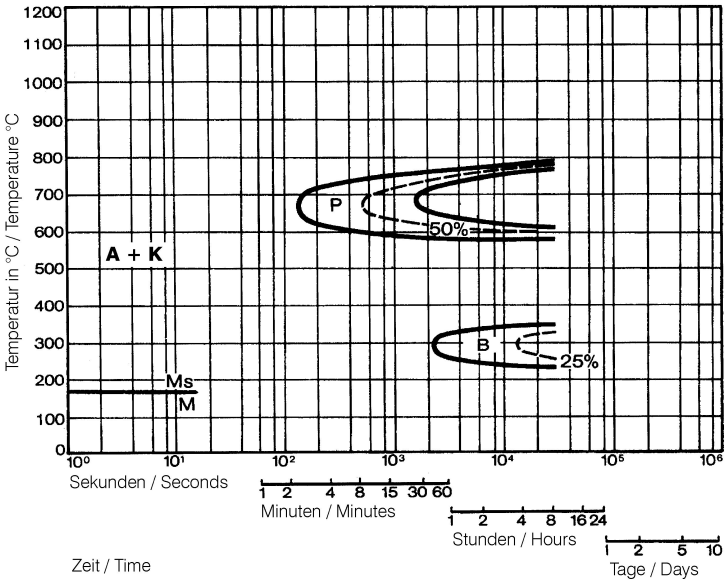


Lk... Ledeburite carbide
RA... Residual austenite
A... Austenite
B... Bainite
P... Perlite
K... Carbide
M... Martensite

- - - - - - Oil cooling
- • - Air cooling

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

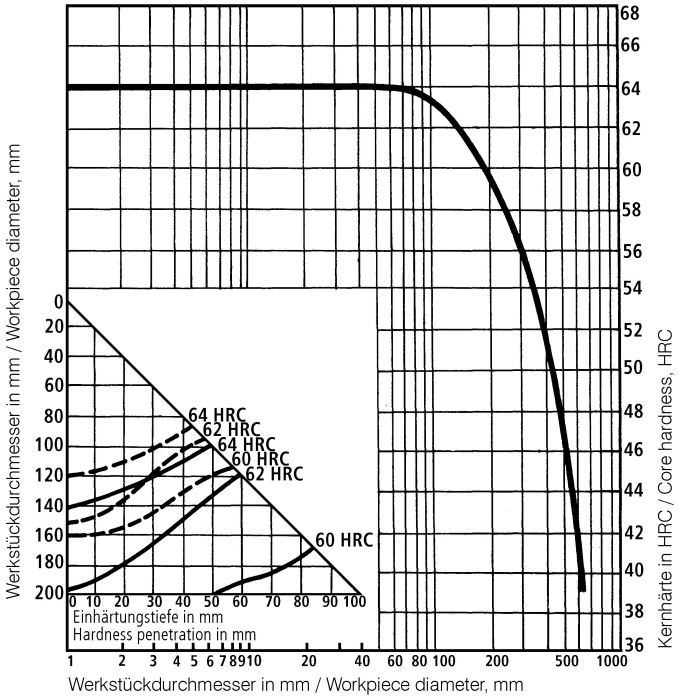
Isothermal TTT curves



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

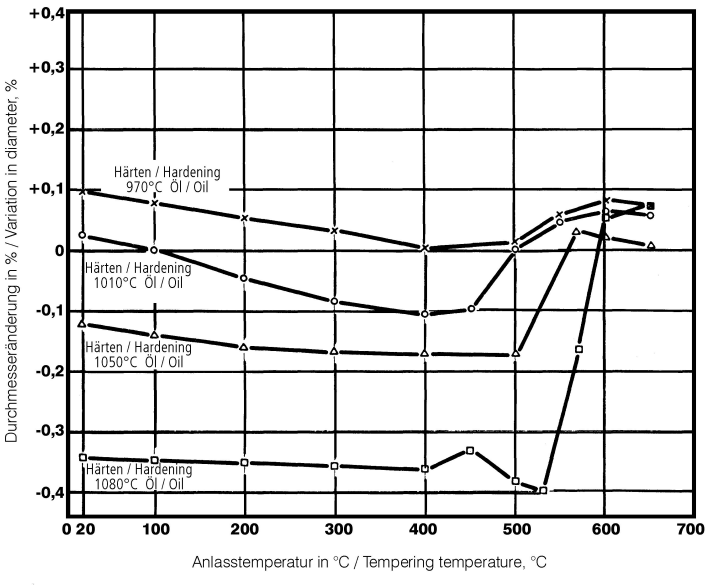
A... Austenite
B... Bainite
P... Perlite
K... Carbide
M... Martensite

Influence of work diameter on core hardness and hardness penetration



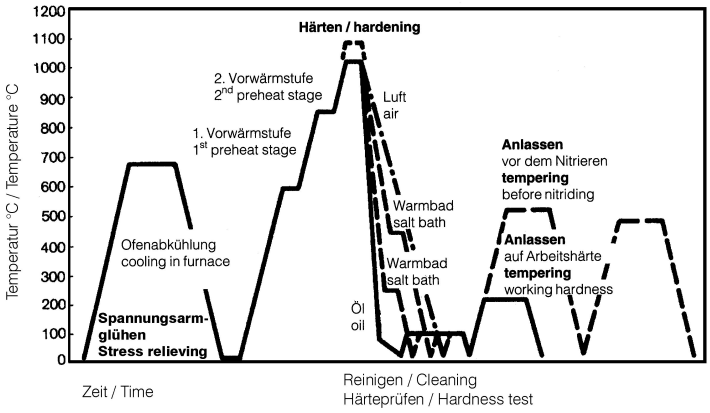
Quenched from: 980°C / 1796°F
Quenchant:
——— Oil
- - - - - - Air

Variation in size as a function of tempering temperature after hardening



Specimen size: Ø 22 x 5 mm

Heat treatment sequence



Physical Properties

Temperature (°C | °F)	20 | 68
Density (kg/dm^3 | lb/in^3)	7.7 | 0.28
Thermal conductivity (W/(m.K) | BTU (IT) ft/hr/ft^2/F)	20 | 11.56
Specific heat (J/(kg.K) | BTU (IT) lb/F)	460 | 109.87
Spec. electrical resistance (Ohm.mm^2/m | 10^{-4} Ohm.inch^2/ft)	0.65 | 3.07
Modulus of elasticity (10^{3}N/mm^2 | 10^{3}ksi)	210 | 30.46

Thermal Expansions

Temperature (°C | °F)	100 | 212	200 | 392	300 | 572	400 | 752	500 | 932	600 | 1112
Thermal expansion (10^{-6} m/(m.K) | 10^{-6} inch/(inch.F))	10.5 | 5.833	11 | 6.111	11 | 6.111	11.5 | 6.389	12 | 6.667	12 | 6.667

For more information see www.voestalpine.com/bohler-edelstahl

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.

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ONE STEP AHEAD.