

HIGH SPEED STEELS

Available Product Variants

Long Products

Product Description

BÖHLER S401 – "The conventional"

This grade is part of the family of molybdenum-alloyed high-speed steels and its winning performance is matched by its good cost effectiveness.

Process Melting

Airmelted

Properties

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

Applications

- > Twist Drills and Taps
- > Thread rolling
- > Broaches and Reamers

Technical data

Material designation		Standards	
1.3346	SEL	A600	ASTM
M1	AISI		
HS2-9-1	EN		

Chemical composition (wt. %)

C	Si	Mn	Cr	Mo	V	W
0.84	0.4	0.3	3.8	8.6	1.2	1.8

Material characteristics

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

Delivery condition

Annealed

Hardness (HB)	max. 280
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Heat treatment

Annealing

Temperature	770 to 840 °C 1,418 to 1,544 °F	Controlled slow cooling in furnace (10 - 20°C / h (50 - 68°F / h) to approx. 600°C (1110°F), air cooling.
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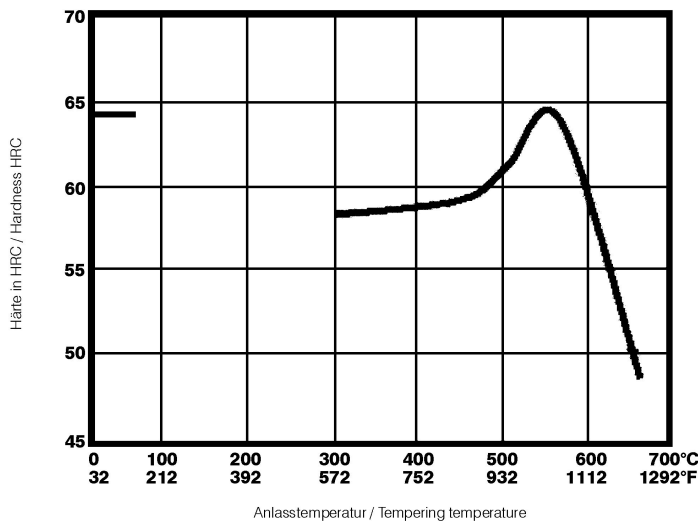
Stress relieving

Temperature	600 to 650 °C 1,112 to 1,202 °F	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.
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Hardening and Tempering

Temperature	1,170 to 1,210 °C 2,138 to 2,210 °F	Salt bath, vacuum Preheating: 1st stage ~ 500 °C, 2nd stage ~ 850 °C, 3rd stage ~1050 °C Austenitising: 1170 - 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 1,022 to 1,058 °F	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

Tempering Chart



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

Physical Properties

Temperature (°C °F)	20 68
Density (kg/dm ³ lb/in ³)	8 0.29
Thermal conductivity (W/(m.K) BTU/ft h °F)	19 10.98
Specific heat (kJ/kg K BTU/lb °F)	0.46 0.1099
Spec. electrical resistance (Ohm.mm ² /m 10 ⁻⁴ Ohm.inch ² /ft)	0.6 2.84
Modulus of elasticity (10 ³ N/mm ² 10 ³ ksi)	217 31.47

Thermal Expansions between 20°C | 68°F and ...

Temperature (°C °F)	100 212	200 392	300 572	400 752	500 932	600 1,112	700 1,292
Thermal expansion (10 ⁻⁶ m/(m.K) 10 ⁻⁶ inch/inch.°F)	11 6.1	11.5 6.4	11.9 6.6	12.3 6.8	12.4 6.9	12.5 6.9	12.5 6.9

For additional specifications and technical requirements, 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.

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