

HIPERDIE Hot Work Tool Steel

■ Typical analysis	C	Si	Mn	P	S	Cr	Mo	V	Otros/ Others
	0,35	≤5	0,50	≤0,025	≤0,003	2,70	1,00	0,20	+

Figures in % by mass.

■ Characteristics

Special CrMoV-alloyed hot work tool steel with excellent high-temperature strength and better toughness properties than grade 2344 as well as higher thermal conductivity than the classic hot work tool steels 2343, 2344 and 2367. In comparison to the NiCrMoV - tool steels 2711/2714 High PERFORMANCE DIE is characterized by higher wear resistance, comparable to grade 2343.

■ Applications

- Close-die forging: Small and medium-sized dies and die inserts for a large number of forgings.
- Highly stressed plastic moulds: Small and medium moulds as well as mould inserts subject to abrasive stress caused by processing of thermosetting plastics, thermoplastics and composite materials also in combination with surface treatments.

Where there is a requirement for

- Polishability < 400 paper grit
- Sensitive etch designs (e.g. HNO₃)
- Higher thermal conductivity we recommend grade Thruhard Supreme®

- Light alloy processing: Gravity - as well as low pressure die- casting moulds and tools up to 45 HRC.

■ Delivered condition

Annealed to max. 250 HB

Quenched and tempered to customer specification on request to max. 430 HB (Δ approx. 1450 MPa)*

Sizes upon request.

■ Physical properties (reference values)		
Thermal expansion coefficient (10-6/K)	20–250 °C	20–500 °C
	12,8	13,8
Thermal conductivity (W/mK)	250 °C	500 °C
	37,1	35,3
Young's modulus (GPa)	250 °C	500 °C
	204	198

* Surface hardness in Brinell, converted to DIN EN ISO 18265, Table A.1.

SERMETAL BARCELONA, S.L.U.

Viladecans • Andorra, 59-61 • Pol. Ind. Can Calderón • 08840 Viladecans (Barcelona) • Tel. 936 357 380 • Fax 936 585 465 | sermetalbcn@sermetalbcn.com

SERMETAL UNIPESSOAL, Lda.

Estarreja • Eco parque Empresarial de Estarreja • Rua de Freguesia de Beduido, Lote 7 nº 10 • 3860-356 Estarreja
Tel. +351 234 840 060 • Fax +351 234 840 069 | geral.estarreja@sermetal.pt

Coucineira • Rua Central da Coucinheria • 2400-768 Amor • Tel. +351 234 840 060 • Fax +351 234 840 069 |

geral.estarreja@sermetal.pt

Moita (machining division) • Rua 23 de Outubro nº 2 • 2445-573 Moita • Tel. +351 244 502 092 | general.moita@sermetal.pt

www.sermetal.es

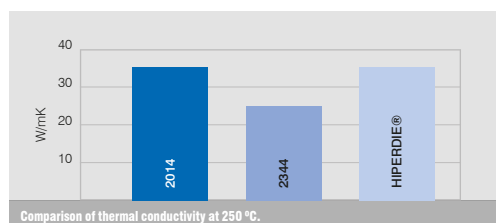
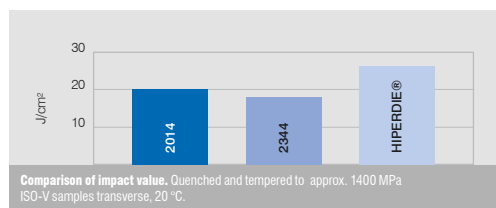
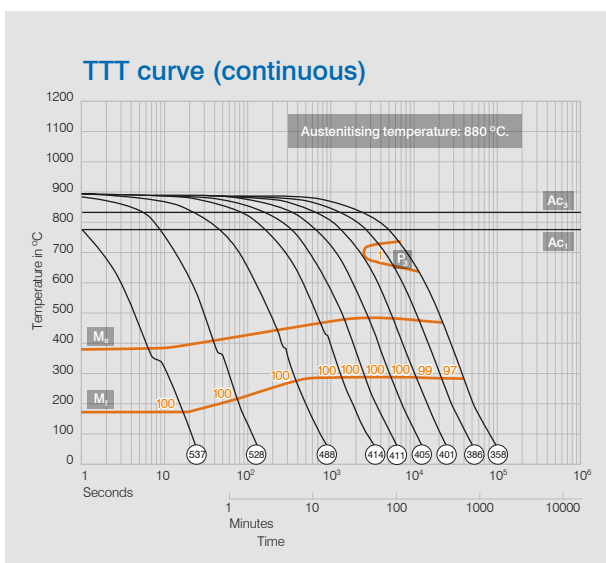
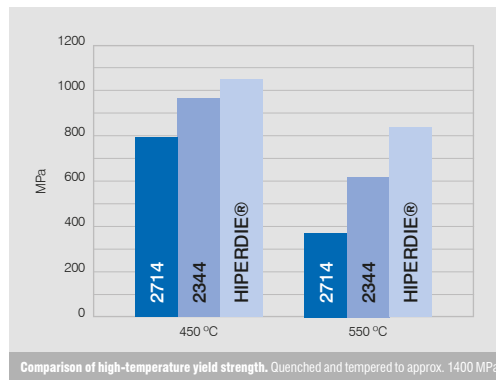
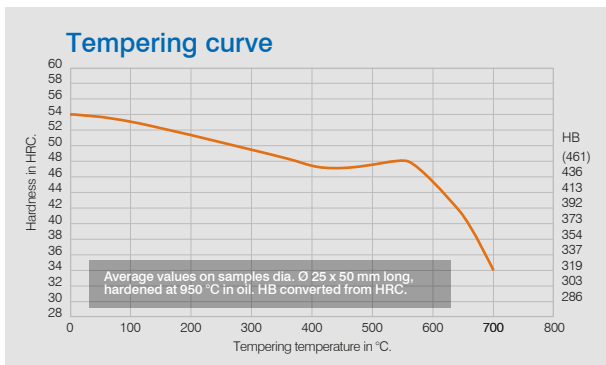
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■ Heat Treatment		
Stress relieving	Temperature:	Approx. 650 °C in the annealed state 40° below tempering temperature in the quenched state
	Duration:	1 hour per 50 mm wall thickness.
	Cooling:	Furnace.
Soft annealing	Temperature:	750 °C
	Duration:	1 hour per 25 mm wall thickness.
	Cooling:	Furnace.
Hardening	Hardening:	950 °C
	Duration:	1 minute per mm wall thickness.
	Quenching hardness	Max. 54 HRC
Tempering	Temperature:	See tempering curve
	Duration:	1 hour per 25 mm wall thickness.
	Cooling:	Air
Working Hardness	Max. 430 HB	



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