

DIN 1.2631 is a medium alloyed cold work steel. It has good thorough hardenability, high wear resistance and very good toughness.

STANDARDS •

- » DIN 1.2631
- » X50CrMoW9-1-1
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CHEMICAL COMPOSITION •

	C	Cr	Si	Mn	Mo	W	P	S	Ni	Cu
Min	0.45	8.00	0.80	0.40	1.10	1.10	--	--	--	--
Typical	0.50	8.50	0.90	0.50	1.20	1.20				
Max	0.55	9.00	1.00	0.60	1.30	1.30	0.035	0.035	0.25	0.25

APPLICATIONS •

- » Wood working knives
- » Straight and round cutting blades
- » Blades used in paper industry

FORM SUPPLIED •

- » Round Bar
- » Square Block
- » Plates
- » Flat Bars

Available surface conditions : drawn, ground, hot rolled, cold rolled, peeled, turned.

HEAT TREATMENT •

● Annealing:

Annealing temperature/ °C: 750~800; After the annealing, degree of hardness ≤HBS: 230

● Quenching:

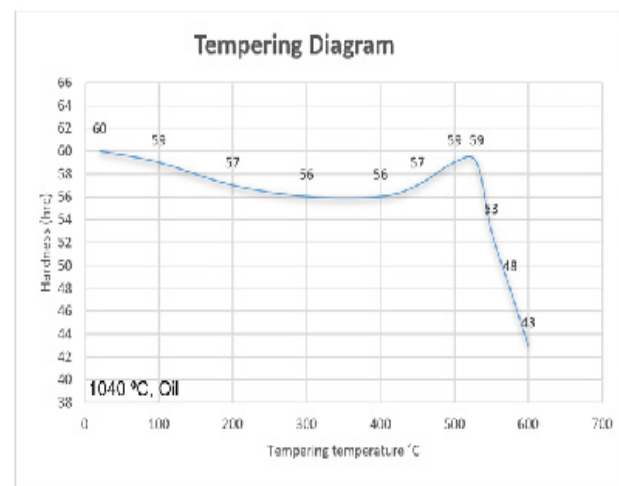
Hardening temperature/ °C: 1020~1050, Quenching in oil

● Tempering:

Commonly used drawing temperature/ °C: 180~250; After tempering hardness HRC | 100 °C: 58; After tempering hardness HRC | 200 °C : 57; After tempering hardness HRC | 300 °C: 56 ;After tempering hardness HRC | 400 °C: 55

● Normalizing:

at Normalizing temperature, then cool in furnace



Tool	Hardening	Tempering
single edge cutting tools	1220 °C	560 °C
multi edge cutting tools	1180-1220 °C	560 °C
cold work tools	1050-1150 °C	560 °C

DELIVERY HARDNESS . _____

» Typical soft annealed hardness is 230 HB

PROCESSING . _____

DIN 1.2631 can be worked as follows :

- » Machining(grinding,turning,milling)
- » Polishing
- » Hot forming
- » Electrical discharge machining
- » Welding(special procedure incl. pre-heating & filler materials of base material composition)

GRINDING . _____

During Grinding, local heating of the surface, which can alter the temper, must be avoided. Grinding wheel manufacturers can provide advise on the choice of grinding wheels.

SURFACE TREATMENT . _____

The Steel Grade is a perfect substrate material for PVD coating. If nitriding is requested, a small diffusion zone is recommended but avoid compound and oxidized layers.

SIZES AVAILABLE . _____



ROUND	Starting From	Upto
DIAMETER	8 mm	500 mm
LENGTH	2000 mm	6000 mm




SQUARE BAR	Starting From	Upto
SIZE	8x8 mm	250x250 mm
LENGTH	2000 mm	6000 mm



FLAT	Starting From	Upto
THICKNESS	4 mm	205 mm
WIDTH	20 mm	400 mm
LENGTH	2000 mm	6000 mm

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