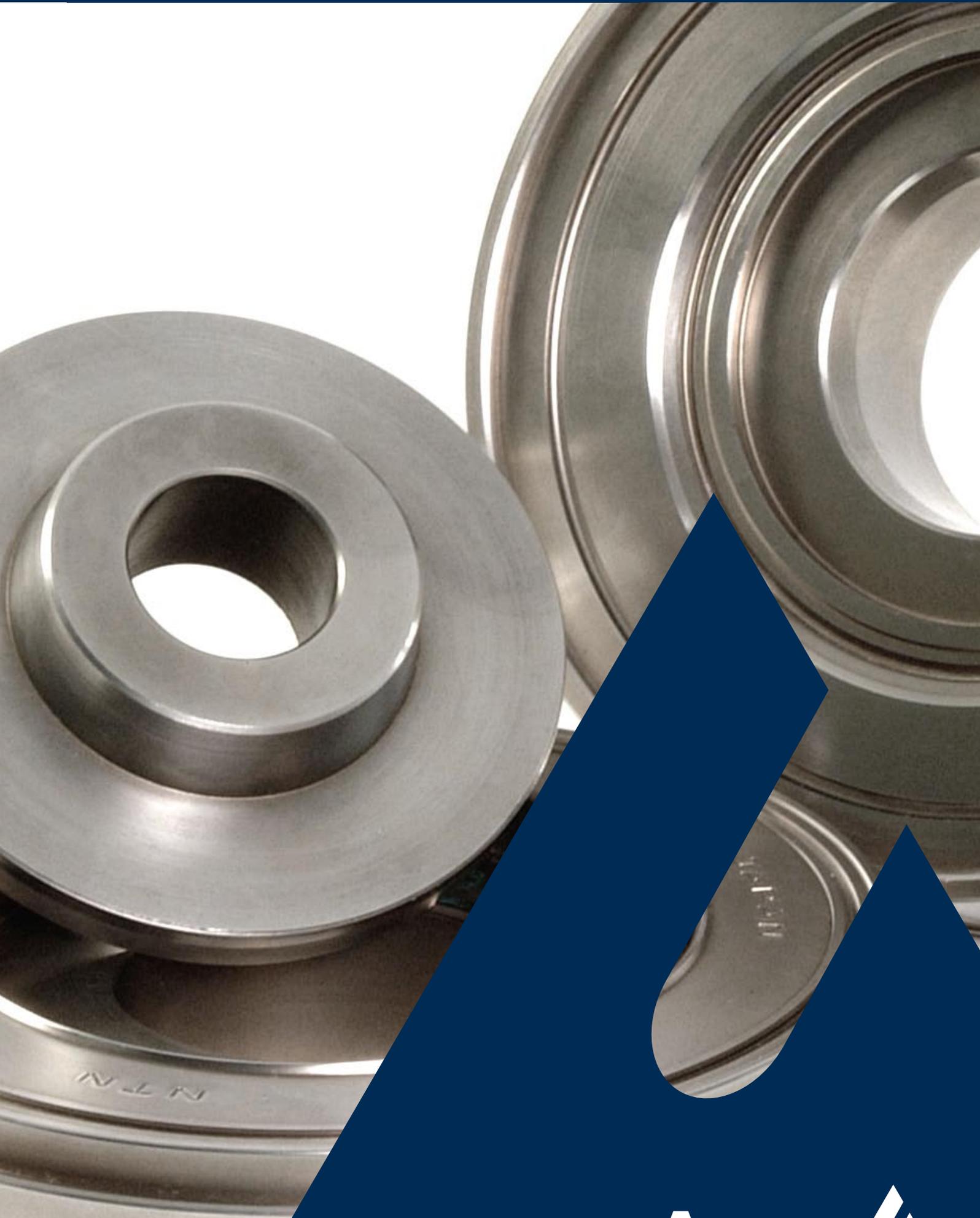


VANADIS 10

UDDEHOLM
VANADIS 10



ASSAB 

		REFERENCE STANDARD		
		AISI	DIN	JIS
DF-2	ARNE	O1	1.2510	SKS 3
DF-3		O1	1.2510	SKS 3
XW-5	SVERKER 3	D6 (D3)	(1.2436)	(SKD 2)
XW-10	RIGOR	A2	1.2363	SKD 12
XW-41	SVERKER 21	D2	1.2379	SKD 11
XW-42		D2	1.2379	SKD 11
CARMO	CARMO			
CALMAX	CALMAX			
CALDIE	CALDIE			
ASSAB 88	SLEIPNER			
ASP 23		(M3:2)	1.3344	SKH 53
ASP 30		(M3:2 + Co)	1.3244	SKH 40
ASP 60			1.3241	
VANADIS 4 EXTRA	VANADIS 4 EXTRA			
VANADIS 6	VANADIS 6			
VANADIS 10	VANADIS 10			
VACRON 40	VANACRON 40			
618		P20 Mod.	1.2738	
618 HH		P20 Mod.	1.2738	
618 T		P20 Mod.	1.2738 Mod.	
718 SUPREME	IMPAX SUPREME	P20 Mod.	1.2738	
718 HH	IMPAX HH	P20 Mod.	1.2738	
NIMAX	NIMAX			
UNIMAX	UNIMAX			
CORRAX	CORRAX			
STAVAX ESR	STAVAX ESR	420 Mod.	1.2083 ESR	SUS 420J2
MIRRAX ESR	MIRRAX ESR	420 Mod.		
POLMAX	POLMAX			
ELMAX	ELMAX			
RAMAX LH	RAMAX LH	420 F Mod.		
RAMAX HH	RAMAX HH	420 F Mod.		
ROYALLOY				
PRODAX				
ASSAB PT18				
ASSAB MMXL				
ASSAB MM40				
ALVAR 14	ALVAR 14		1.2714	SKT 4
8407 2M	ORVAR 2M	H13	1.2344	SKD 61
8407 SUPREME	ORVAR SUPREME	H13 Premium	1.2344 ESR	SKD 61
DIEVAR	DIEVAR			
HOTVAR	HOTVAR			
QRO 90 SUPREME	QRO 90 SUPREME			
705		4340	1.6582	SNCM8
709		4140	1.7225	SCM4
760		1050	1.1730	S50C

This information is based on our present state of knowledge and is intended to provide general notes on our products and their uses. It should not therefore be construed as a warranty of specific properties of the products described or a warranty for fitness for a particular purpose.

General

Vanadis 10 is a high vanadium alloyed powder metallurgical (PM) tool steel offering a unique combination of an excellent abrasive wear resistance in combination with a good chipping resistance.

Vanadis 10 is characterised by:

- Extremely high abrasive wear resistance
- High compressive strength
- Very good through-hardening properties
- Good toughness
- Very good stability during hardening
- Good resistance to tempering back
- Good surface treatment properties

Typical analysis %	C 2.9	Si 0.5	Mn 0.5	Cr 8.0	Mo 1.5	V 9.8
Standard specification	None					
Delivery condition	Soft annealed to approx. 280 - 310 HB					
Colour code	Green / Violet					

Due to the very carefully balanced alloying and the powder metallurgical manufacturing route, Vanadis 10 has a similar heat treatment procedure to the steel D2. One very big advantage with Vanadis 10 is that the dimensional stability after hardening and tempering is much better than for the conventionally produced high performance cold work steels. This also means that Vanadis 10 is a tool steel which is very suitable for CVD coating.

Applications

Vanadis 10 is especially suitable for very long run tooling where abrasive wear is the dominating problem. Its very good combination of extremely high wear resistance and good toughness also makes Vanadis 10 an interesting alternative in applications where tooling made of carbide tends to chip or crack.

TYPICAL APPLICATIONS

- Blanking and forming
- Fine blanking
- Blanking of electrical sheet
- Gasket stamping
- Deep drawing
- Cold forging
- Slitting knives (paper and foil)
- Powder pressing
- Granulator knives
- Extruder screws etc.

Properties

PHYSICAL PROPERTIES

Hardened and tempered to 62 HRC.

Temperature	20°C	200°C	400°C
Density kg/m ³	7 400	–	–
Modulus of elasticity MPa	220 000	210 000	200 000
Coefficient of thermal expansion per °C from 20°C	–	10.7 x 10 ⁻⁶	11.4 x 10 ⁻⁶
Thermal conductivity W/m °C	–	20	22
Specific heat J/kg °C	460	–	–

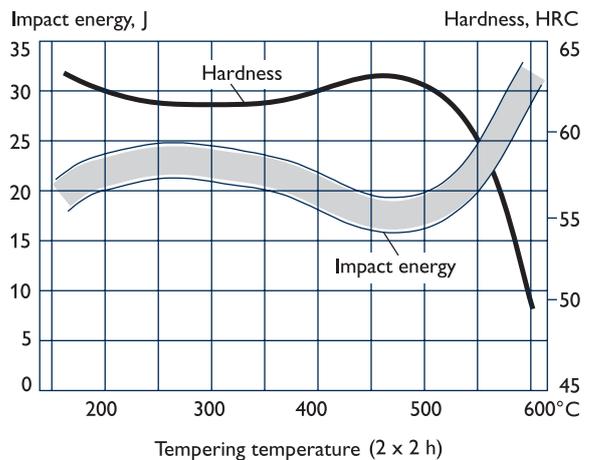
IMPACT STRENGTH

The effect of tempering temperature on unnotched impact strength at room temperature.

Specimen size: 7 x 10 x 55 mm

Specimen type: Unnotched

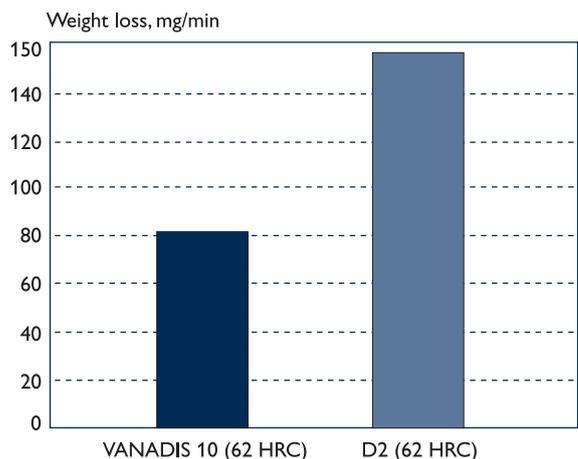
Heat treatment: Hardened at 1020°C. Quenched in air. Tempered twice.



WEAR RESISTANCE

Test method: Pin-on-disc test

Disc material: SiC



Heat treatment

SOFT ANNEALING

Protect the steel and heat through to 900°C. Cool in the furnace at 10°C per hour to 750°C, then freely in air.

STRESS RELIEVING

After rough machining, the tool should be heated through to 650°C, holding time 2 hours. Cool slowly to 500°C, then freely in air.

HARDENING

Preheating temperature: 600 - 700°C

Austenitising temperature: 1020 - 1100°C

Holding time: 30 minutes

Holding time = Time at hardening temperature after the tool is fully heated through. A holding time of less than 30 minutes will result in loss of hardness.

Protects the parts against decarburisation and oxidation during hardening.

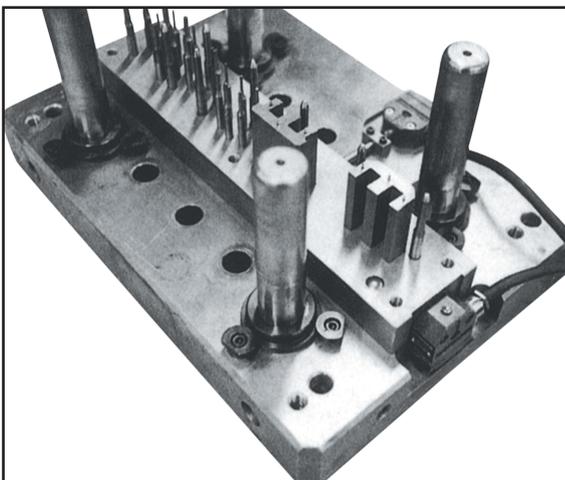
QUENCHING MEDIA

- Forced air/gas
- Vacuum furnace (gas overpressure 2 - 5 bar)
- Martempering bath or fluidised bed at 500 - 550°C
- Martempering bath or fluidised bed at 200 - 350°C whereby 350°C is preferred

Note 1: Temper the tool as soon as its temperature reaches 50 - 70°C.

Note 2: In order to obtain the optimum properties for the tool, the cooling rate should be as fast as possible while maintaining an acceptable level of distortion.

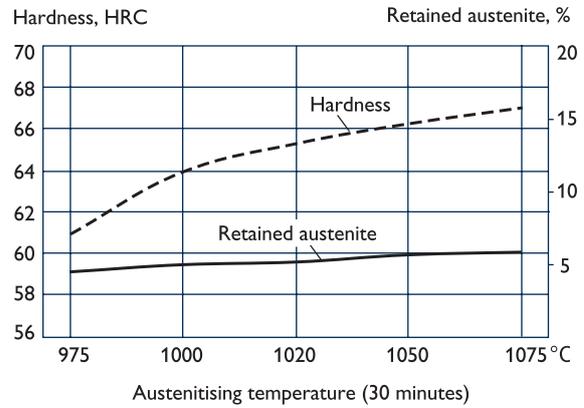
Note 3: Tools with sections >50 mm should be quenched in forced air. Quenching in still air will result in loss of hardness.



Typical application of Vanadis 10. Tool for blanking and forming electrical strip.

Hardness and retained austenite as functions of austenitising temperature

Air-cooling.

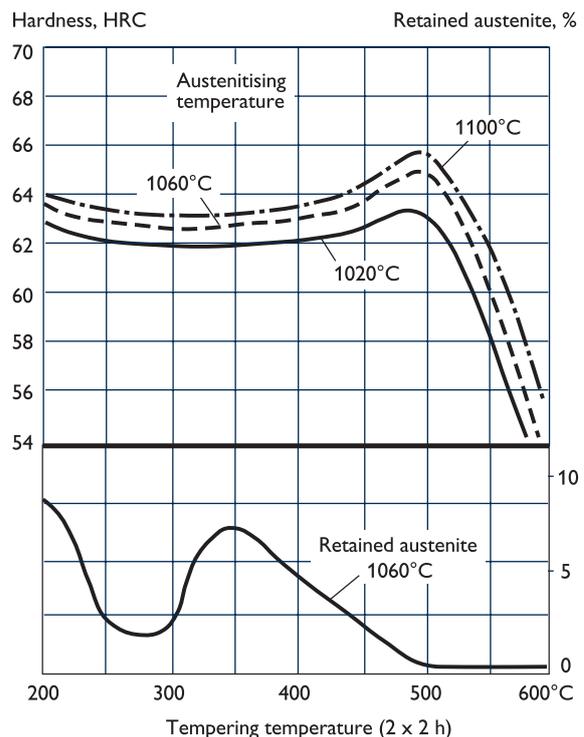


TEMPERING

Choose the tempering temperature according to the hardness required by reference to the tempering graph.

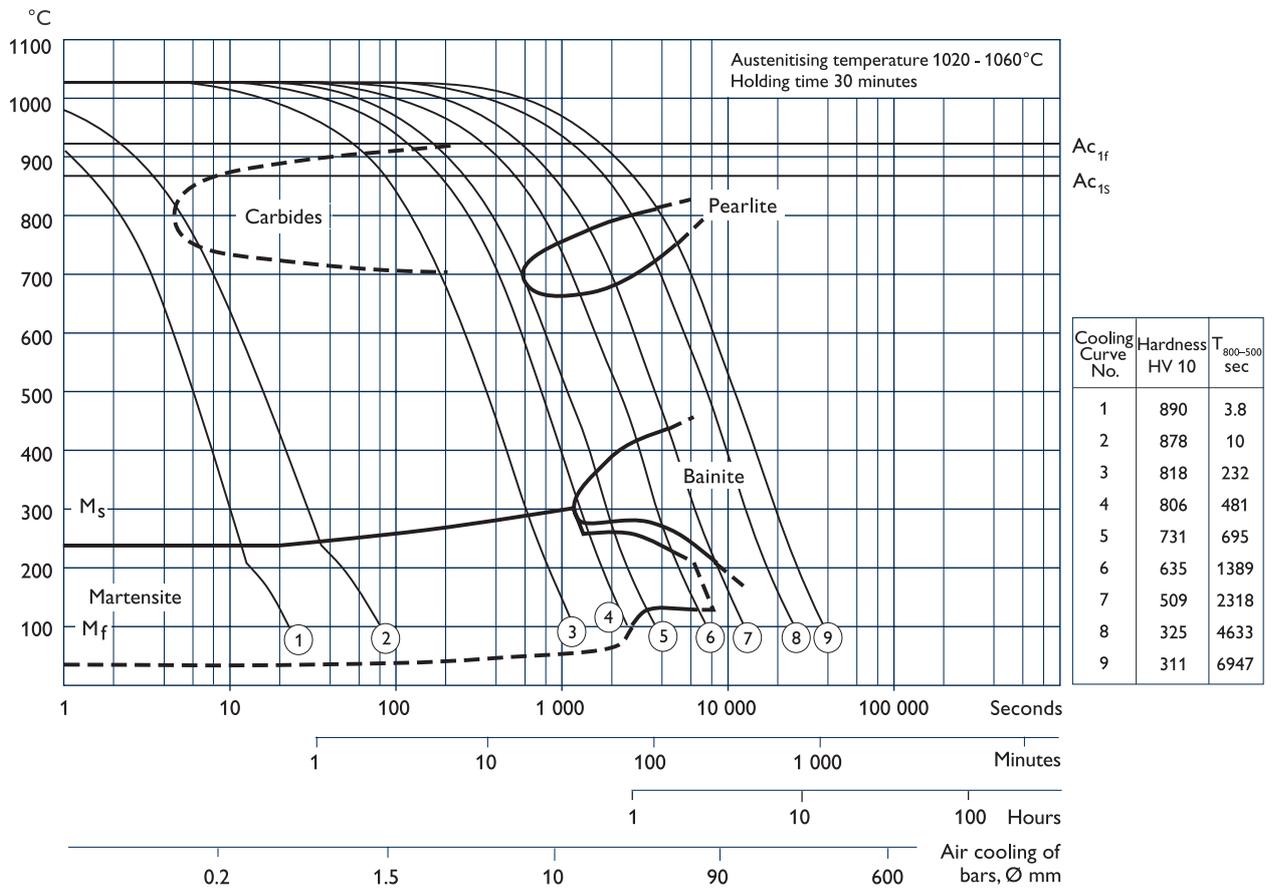
Temper at least twice with intermediate cooling to room temperature. The lowest tempering temperature which should be used is 180°C. The minimum holding time at temperature is 2 hours. At a hardening temperature of 1100°C or higher, Vanadis 10 should be tempered at minimum 525°C in order to reduce the amount of retained austenite.

Tempering graph



CCT graph

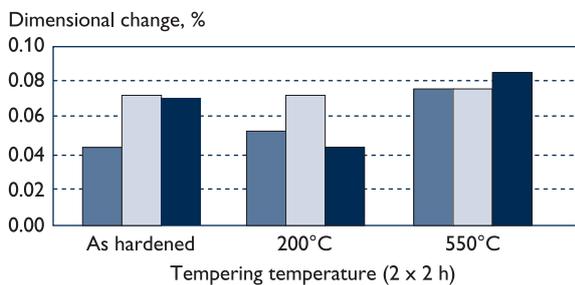
Austenitising temperature 1020 - 1060°C. Holding time 30 minutes.



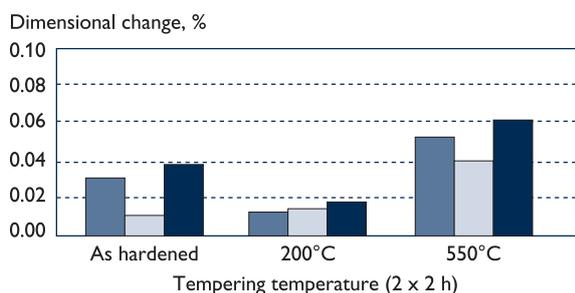
DIMENSIONAL CHANGES AFTER TEMPERING

Hardening temperature
 ■ 980°C ■ 1020°C ■ 1060°C

Specimen size: 65 x 65 x 65 mm



Specimen size: 125 x 125 x 25 mm



SUB-ZERO TREATMENT

Tools requiring maximum dimensional stability in service can be sub-zero treated as follows:

Immediately after quenching, the piece should be sub-zero treated, followed by tempering. Vanadis 10 is commonly sub-zero treated between -150°C and -196°C for 1 - 3 hours, although occasionally -40°C and lower temperatures (e.g., -80°C) are used due to constraints of the sub-zero medium and equipment available. The sub-zero treatment leads to a reduction of retained austenite content. This, in turn, will result in a hardness increase of ~1 HRC compared to non sub-zero treated tools if low temperature tempering is used.

Tools that are high temperature tempered, even without a sub-zero treatment, will have a low retained austenite content; and in most cases, a sufficient dimensional stability. However, for high demands on dimensional stability in service, it is also recommended to use a sub-zero treatment in combination with high temperature tempering.

Machining recommendations

The cutting data below are to be considered as guiding values and as starting points for developing your own best practice.

Condition: Soft annealed condition 280 - 310 HB

TURNING

Cutting data parameters	Turning with carbide		Turning with HSS [†]
	Rough turning	Fine turning	Fine turning
Cutting speed (v _c) m/min	50 - 80	80 - 100	5 - 8
Feed (f) mm/r	0.2 - 0.4	0.05 - 0.2	0.05 - 0.3
Depth of cut (a _p) mm	2 - 4	0.5 - 2	0.5 - 3
Carbide designation ISO	K20* Coated carbide	K15* Coated carbide or cermet	–

[†] High speed steel

* Use a wear-resistant Al₂O₃ coated carbide grade

DRILLING

High speed steel twist drill

Drill diameter mm	Cutting speed (v _c) m/min	Feed (f) mm/r
≤ 5	6 - 8*	0.05 - 0.15
5 - 10	6 - 8*	0.15 - 0.20
10 - 15	6 - 8*	0.20 - 0.25
15 - 20	6 - 8*	0.25 - 0.35

* For coated HSS drill, v_c = 12 - 14 m/min

Carbide drill

Cutting data parameters	Type of drill		
	Indexable insert	Solid carbide	Carbide tip ¹
Cutting speed (v _c) m/min	70 - 90	40 - 60	20 - 30
Feed (f) mm/r	0.05 - 0.15 ²	0.10 - 0.25 ²	0.15 - 0.25 ²

¹ Drill with replaceable or brazed carbide tip

² Depending on drill diameter

MILLING

Face and square shoulder milling

Cutting data parameters	Milling with carbide	
	Rough milling	Fine milling
Cutting speed (v _c) m/min	30 - 50	50 - 70
Feed (f _z) mm/tooth	0.2 - 0.4	0.1 - 0.2
Depth of cut (a _p) mm	2 - 4	≤ 2
Carbide designation ISO	K20 - P20* Coated carbide	K15 - P15* Coated carbide or cermet

* Use a wear-resistant Al₂O₃ coated carbide grade

End milling

Cutting data parameter	Type of end mill		
	Solid carbide	Carbide indexable insert	High speed steel ¹
Cutting speed (v _c) m/min	30 - 40	30 - 50	10 - 14
Feed (f _z) mm/tooth	0.03 - 0.20 ²	0.08 - 0.20 ²	0.05 - 0.35 ²
Carbide designation ISO	–	K15 ³ Coated carbide	–

¹ Uncoated HSS is not recommended

² Depending on radial depth of cut and cutter diameter

³ Use a wear-resistant Al₂O₃ coated carbide grade

GRINDING

Wheel recommendation

Type of grinding	Soft annealed condition	Hardened condition
Face grinding straight wheel	A 46 HV	B151 R50 B3 ¹ A 46 GV ²
Face grinding segments	A 36 GV	A 46 GV
Cylindrical grinding	A 60 KV	B151 R75 B3 ¹ A 60 JV ²
Internal grinding	A 60 JV	B151 R75 B3 ¹ A 60 IV
Profile grinding	A 100 IV	B126 R100 B6 ¹ A 100 JV ²

¹ If possible, use CBN wheels for this application

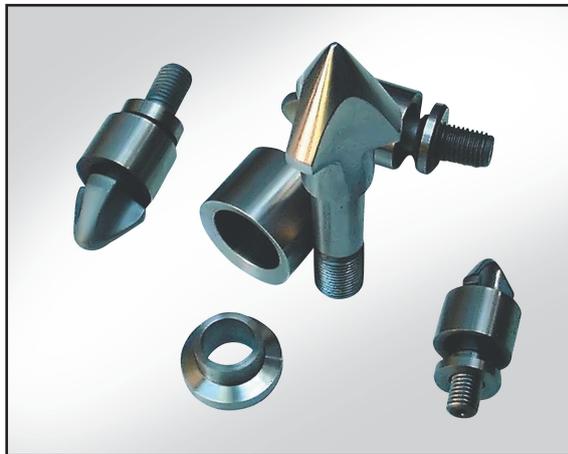
² Preferably a wheel type containing sintered Al₂O₃ (seeded gel)

Electrical discharge machining

If EDM is performed in the hardened and tempered condition, the EDM'd surface is covered with a resolidified layer (white layer) and a rehardened and untempered layer, both of which are very brittle and hence detrimental to the tool performance.

When a profile is produced by EDM, it is recommended to finish with "fine-sparking", i.e., low current, high frequency. For optimal performance, the EDM'd surface should be ground/polished to remove the white layer completely. The tool should then be retempered at approx. 25°C below the highest previous tempering temperature.

When EDM'ing larger sizes or complicated shapes, Vanadis 10 should be high temperature tempered above 500°C.



Nozzles and rings made of Vanadis 10 for extrusion screws, used for the extrusion of glass-reinforced plastic.

Surface treatment

NITRIDING

Nitriding produces a hard surface layer that increases wear resistance and reduces the tendency towards galling.

If high temperature tempered, Vanadis 10 is normally tempered at 525°C. This means that the nitriding temperature used should not exceed 500 - 525°C. Ion nitriding at a temperature below the tempering temperature used is preferred.

The surface hardness after nitriding is approximately 1250 HV_{0.2 kg}. The thickness of the layer should be chosen to suit the application in question.

Further information

For further information, i.e., steel selection, heat treatment, application and availability, please contact our ASSAB office* nearest to you.

*See back cover page.

Relative comparison of ASSAB cold work tool steels

MATERIAL PROPERTIES AND RESISTANCE TO FAILURE MECHANISMS

ASSAB grade	Hardness/ Resistance to plastic deformation	Machinability	Grindability	Dimension stability	Resistance to		Fatigue cracking resistance	
					Abrasive wear	Adhesive wear	Ductility/ resistance to chipping	Toughness/ gross cracking
DF-3	██████	██████	██████	█	██████	██████	██████	██████
CALMAX	██████	██████	██████	██████	██████	██████	██████	██████
CALDIE (ESR)	██████	██████	██████	██████	██████	██████	██████	██████
XW-10	██████	██████	██████	██████	██████	██████	██████	██████
ASSAB 88	██████	██████	██████	██████	██████	██████	██████	██████
XW-42	██████	██████	██████	██████	██████	██████	██████	██████
XW-5	██████	██████	██████	██████	██████	██████	██████	██████
VANADIS 4 EXTRA	██████	██████	██████	██████	██████	██████	██████	██████
VANADIS 10	██████	██████	██████	██████	██████	██████	██████	██████
VANCRON 40	██████	██████	██████	██████	██████	██████	██████	██████
ASP 23	██████	██████	██████	██████	██████	██████	██████	██████
ASP 30	██████	██████	██████	██████	██████	██████	██████	██████
ASP 60	██████	██████	██████	██████	██████	██████	██████	██████
AISI M2	██████	██████	██████	██████	██████	██████	██████	██████

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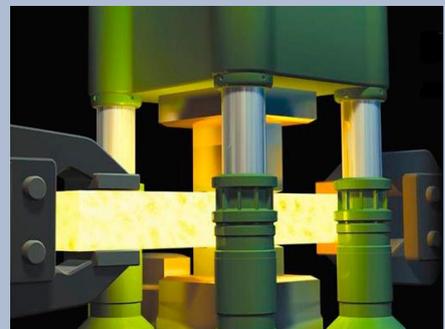
† Sales office only

ASSAB TOOL STEELS have been in Asia since 1945. Our customers associate ASSAB brand with tooling materials that are high in quality and consistency.

The ASSAB sales companies and distributors offer you well assorted stocks in a number of places covering the Asia Pacific region. To further shorten the lead time, ASSAB will mill, grind, drill and even wire-cut the tool steel to meet your requirements. ASSAB also provides state-of-the-art vacuum heat treatment services to enhance the steel properties.

Our engineers and metallurgists are always ready to assist you in your choice of the optimum steel grade and the best treatment for each application. We always carry out material examinations at our local mini laboratories and at the central laboratory in Sweden.

Our steel mill in Sweden, Uddeholm Tooling, is one of the few steelworks in the world that is dedicated to the manufacture of tool steels only. Uddeholm Tooling is certified to ISO 9001 and ISO 14001.



Our forging press is one of the most modern of its kind in the world.

Besides tool steels, the ASSAB services for tool makers include:

- Welding electrodes for repair welding of tools
- High strength aluminium for tooling purposes
- Copper alloys (e.g., beryllium copper) for inserts in moulds
- Alloy machinery steels
- Cold rolled strip steels for saws, compressor valves, coater blades, etc.
- High Performance Steels (HPS)
- Granshot