



Sales Office:

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1.2347

Conventional melting (EF+LF+VD)

GENERAL:

- better machinability than 1.2344, also in the hardened and tempered condition
- good resistance against abrasion at low and high temperatures
- excellent through-hardening properties
- good high-temperature strength
- very limited distortion during hardening

APPLICATIONS:

- die casting moulds
- plastic moulds
(without high polishing requirements of the surface)
- wear resisting parts
- insert, slider, ejector

CHEMICAL ANALYSIS: %

C	Si	Mn	P	S	Cr	Mo	V
0,37 - 0,42	0,9 - 1,2	0,3 – 0,5	≤ 0,030	0,08-0,12	5,0 – 5,5	1,2 – 1,5	0,9 – 1,1

PHYSICAL PROPERTIES:

Coefficient of thermal expansion [10 ⁻⁶ m/(m x K)]	20-100 °C	20-200 °C	20-300 °C	20-400 °C	20-500 °C	20-600 °C	20-700 °C
		10.9	11.9	12.3	12.7	13.0	13.3
Thermal conductivity [W/(m x K)]	20° C		350° C		700° C		
	25.2		27.0		30.3		

ULTRASONIC:

ASTM A388 - FBH max. 6 mm (1/4 inch) or
 SEP 1921 – test group 3 – class C , c or
 acc. to your request

CLEANLINESS:

ASTM E45- Method A with type B; C and D each ≤ 2 or
 DIN 50602– K4 ≤ 20 (without sulphide) or
 acc. to your request

DELIVERY CONDITION:

hardened and tempered

SERVICE HARDNESS:

37 – 41 HRC or acc. to your request

DELIVERY SIZES:

Rounds – up to 600 mm or
 Blocks – up to 500 mm thickness or acc. to your request



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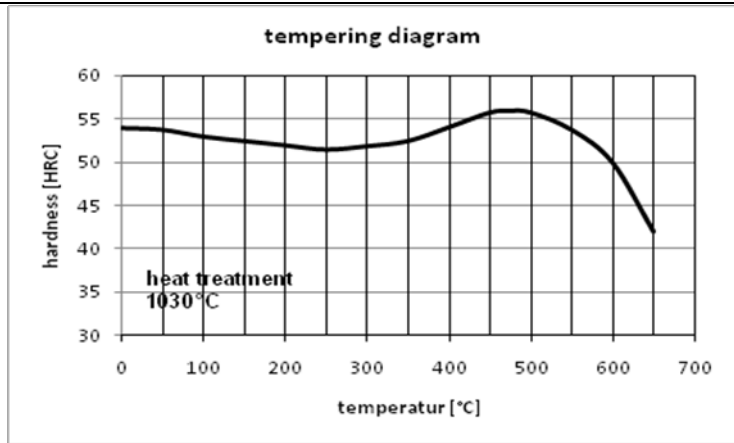
1.2347

HEAT TREATMENT:

<i>Hot forming</i>	<i>Soft annealing</i>	<i>Hardening</i>	<i>Tempering</i>
1050 – 850 °C	820 – 840 °C	1020 – 1050 °C	520 – 700 °C

TEMPERING DIAGRAM:

values in HRC
tested on samples
dia. 25 x 50 mm long
hardened at 1030 °C in oil



CCT GRAPH:

Austenitizing temperature 1020°C (1870°F). Holding time 30 minutes.

