

## CHEMICAL COMPOSITION

C	Cr	Mo	W	Co	V
1.28	4.2	5.0	6.4	8.5	3.1

ASP 2030 is a cobalt grade for high performance tools.

## STANDARDS

\_ Europe: HS 6-5-3-8

## DELIVERY HARDNESS

Soft annealed max. 300 HB  
Cold drawn max. 320 HB  
Cold rolled max. 320 HB

## FORM SUPPLIED

\_ Coils                      \_ Sheets  
\_ Round bars              \_ Laserstrip  
\_ Forged blanks          \_ Flat & square bars

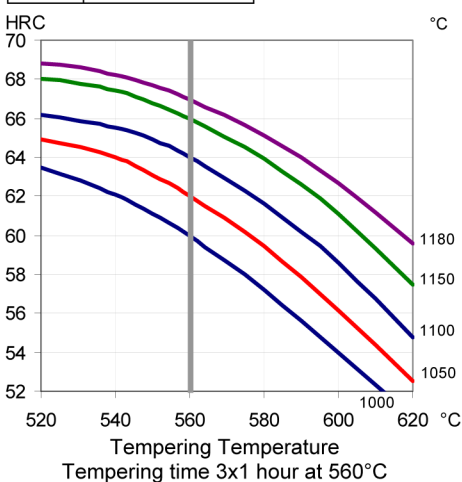
Available surface conditions : drawn, ground, hot worked, peeled, rough machined.

## HEAT TREATMENT

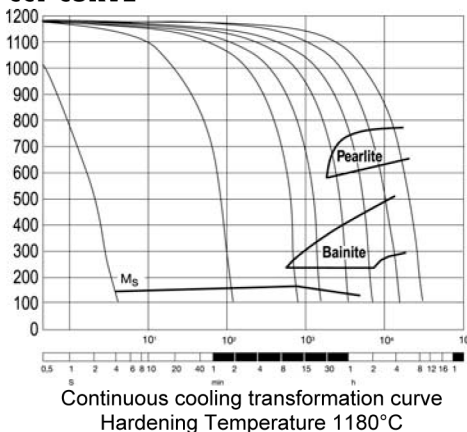
- \_ Soft annealing in a protective atmosphere at 850-900°C for 3 hours, followed by slow cooling at 10°C/h down to 700°C, then air cooling.
- \_ Stress-relieving at 600-700°C for approximately 2 hours, slow cooling down to 500°C.
- \_ Hardening in a protective atmosphere with pre-heating in 2 steps at 450-500°C and 850-900°C and austenitising at a temperature suitable for chosen working hardness. Cooling down to 40-50°C.
- \_ Tempering at 560°C three times for at least 1 hour each time. Cooling to room temperature (25°C) between temperings.

## GUIDELINES FOR HARDENING

Hardness HRC	Hardening temperature °C
56	950
58	960
59	980
60	1000
61	1020
62	1050
63	1075
64	1100
65	1125
66	1150
67	1180



## CCT CURVE



## PROCESSING

ASP 2030 can be worked as follows :

- \_ machining (grinding, turning, milling)
- \_ polishing
- \_ plastic forming
- \_ electrical discharge machining
- \_ welding (special procedure including preheating and filler materials of base material composition).



GRINDING

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

SURFACE TREATMENT

The steel grade is a good substrate material for PVD and CVD coating. If nitriding is requested a small zone of 2-15 µm is recommended. The steel grade can also be steam-tempered if so desired.

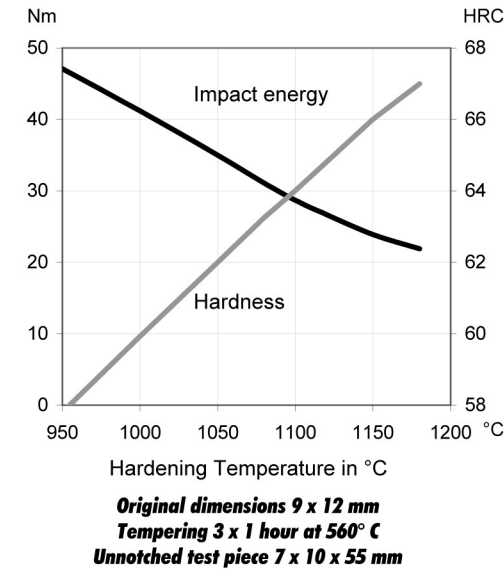
PROPERTIES

PHYSICAL PROPERTIES

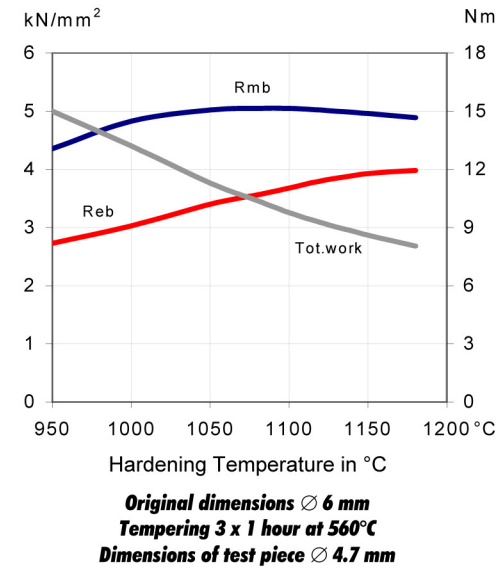
	Temperature		
	20°C	400°C	600°C
Density g /cm³ (1)	8.1	7.9	7.9
Modulus of elasticity kN/mm² (2)	240	214	192
Thermal expansion ratio per °C (2)	-	11.8x10 <sup>-6</sup>	12.3x10 <sup>-6</sup>
Thermal conductivity W/m°C (2)	24	28	27
Specific heat J/kg °C (2)	420	510	600

(1)=Soft annealed  
(2)=Hardened 1180°C and tempered 560°C, 3x1 hour

IMPACT STRENGTH

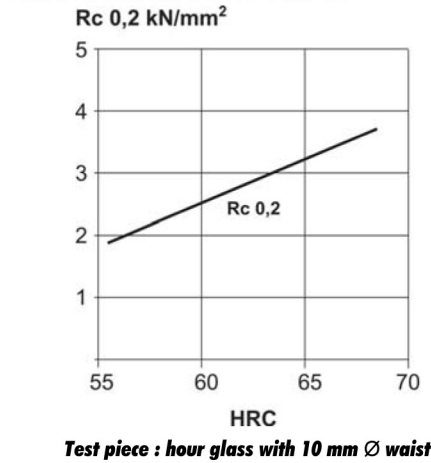


4-POINT BEND STRENGTH



Rmb = Ultimate bend strength in kN/mm²  
Reb = Bend yield strength in kN/mm²  
Tot. work = Total work in Nm

COMPRESSION YIELD STRESS



COMPARATIVE PROPERTIES

