Daido's Hot Work Die Steel

NADCA Spec. #207-2011 Grade C

DH31-EX

High tough and heat checking resistance Premium Hot Work Die Steel

Features

- High toughness due to fine grains by double melting
- High toughness even in large dies due to higher hardenability
- High elevated temperature strength and superior heat checking resistance

Applications and proper hardness

Applications	Hardness (HRC)
Al,Zn,Mg die casting molds	41～48HRC
Die casting parts (Plunger sleeve, chip etc.)	45～50HRC
Hot extrusion dies	43～50HRC
Hot shear blades	35～45HRC
Hot forging dies	42～50HRC

Chemistries

NADCA Spec. #207-2011	C	Mn	P	S	Si	Cr	Mo	V
Grade "C" Chemistry:	0.32-0.40	0.10-1.2	0.020 Max	0.003 Max	0.10-0.50	4.70-5.85	2.00-3.30	0.40-0.70

Heat treatment

Forging Temp. : C	Treating temperature : C			Hardness		Transformation point : C	
	Annealing	Quenching	Tempering	Annealed	Quenched & tempered	Ac	Ms
1200－900	820－870 Slow cooling	1000-1050 Air cooling	550～650 Air cooling	≦235HB	≦53HRC	805～885	300 Austenite temp : 1030 C

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1-800-625-6653
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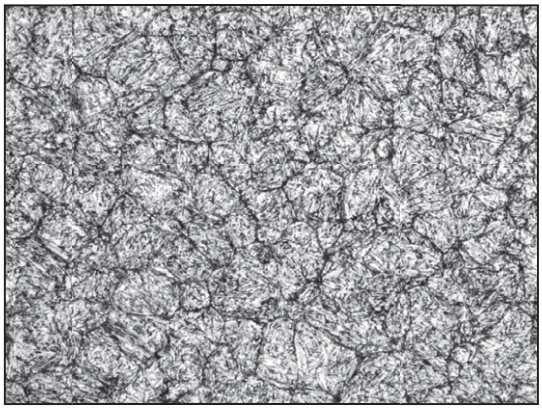
Properties

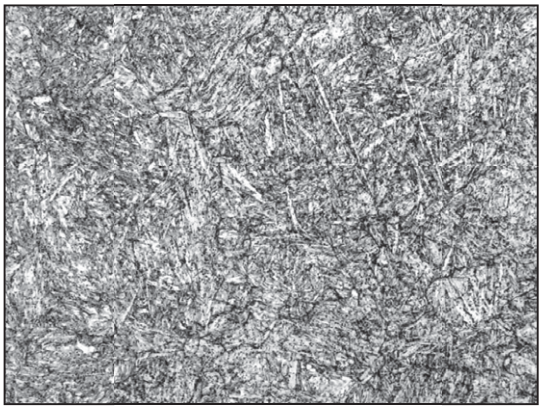
Microstructure （Quenched and tempered）

Specimen: 200H x 600W x 300L(Center)
Vacuum quenched and tempered

25 μ m

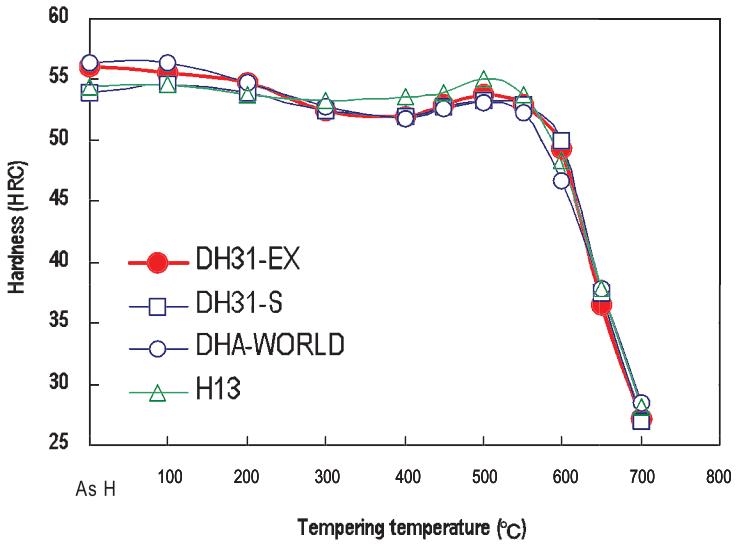


DH31－EX



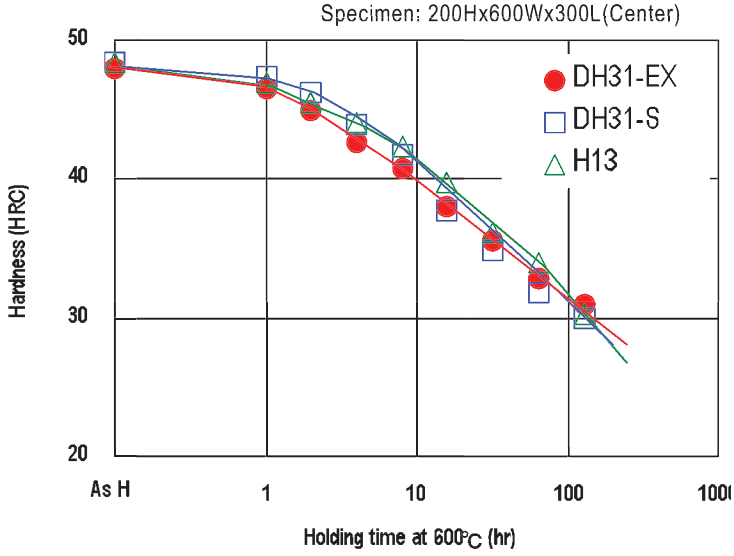
H13

Tempering hardness



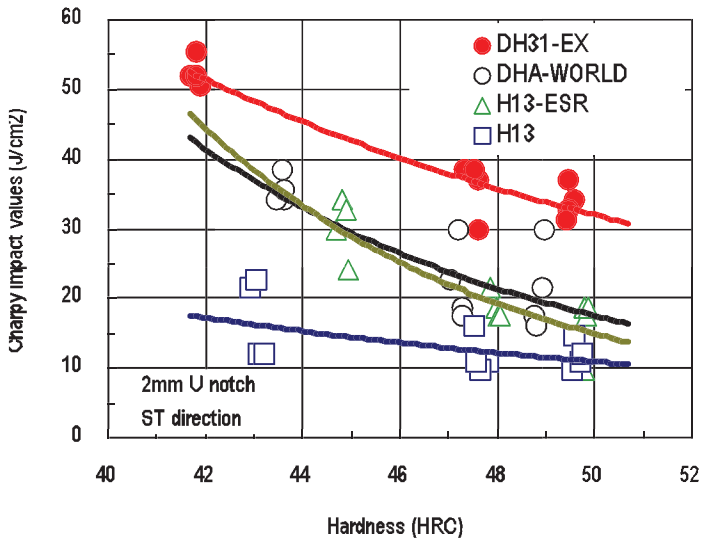
Softening resistance

Specimen: 200Hx600Wx300L(Center)

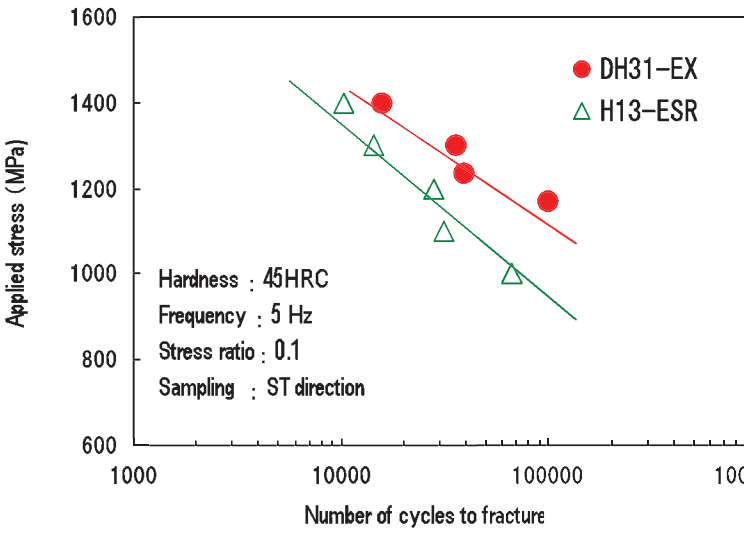


Toughness

Specimen: 200Hx600Wx300L(Center)

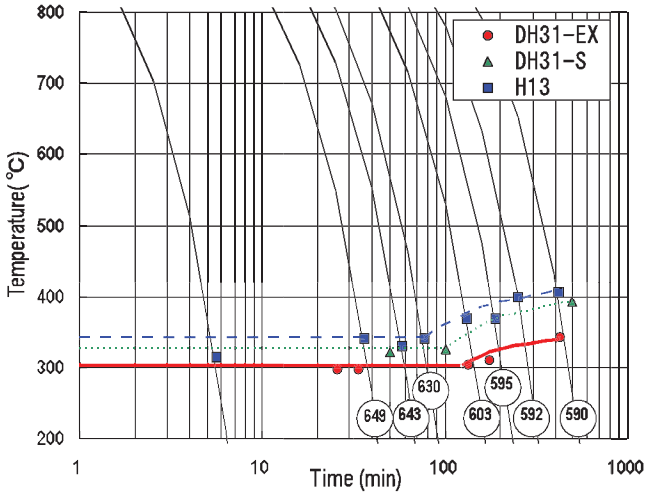


Fatigue properties

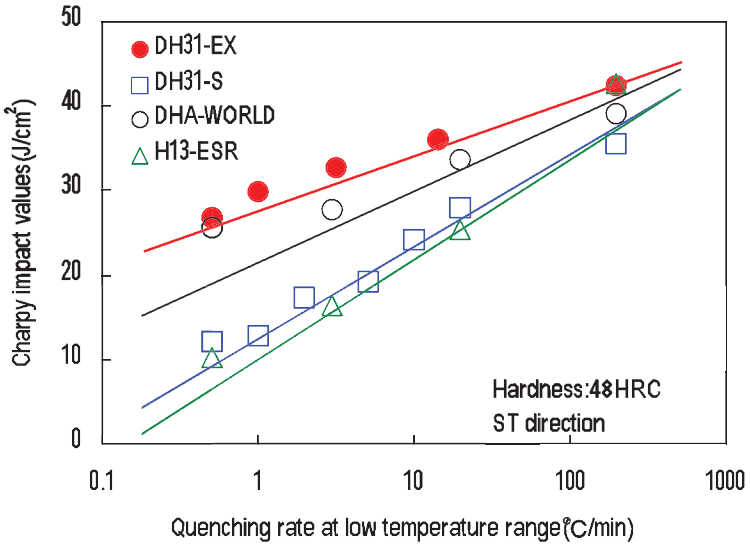


Properties

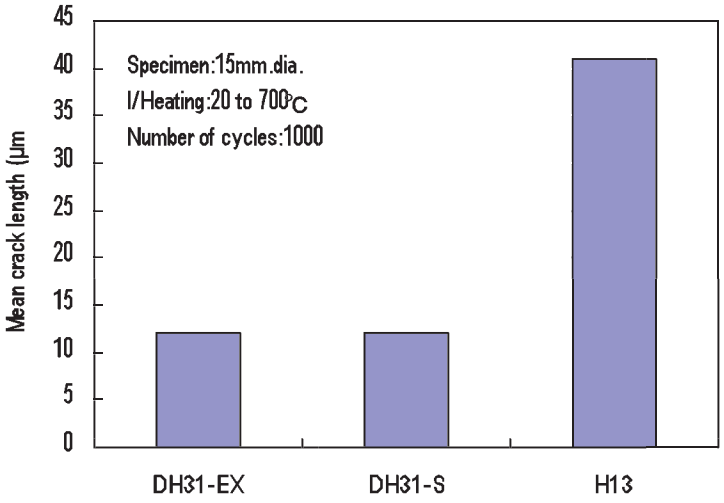
CCT Curves



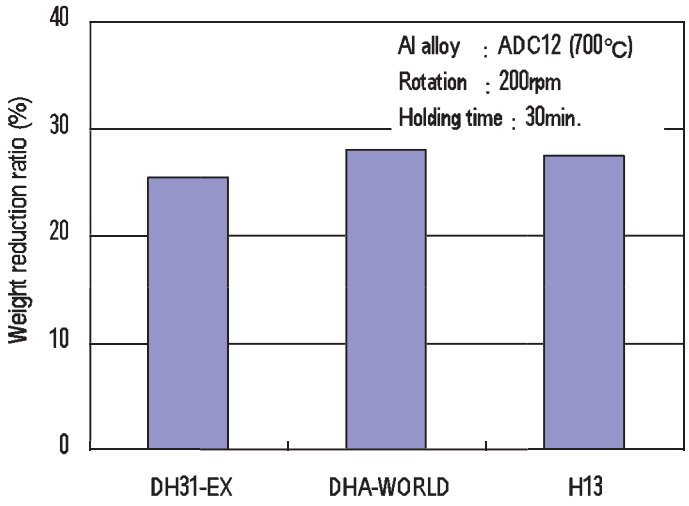
Quenching rate vs. Toughness



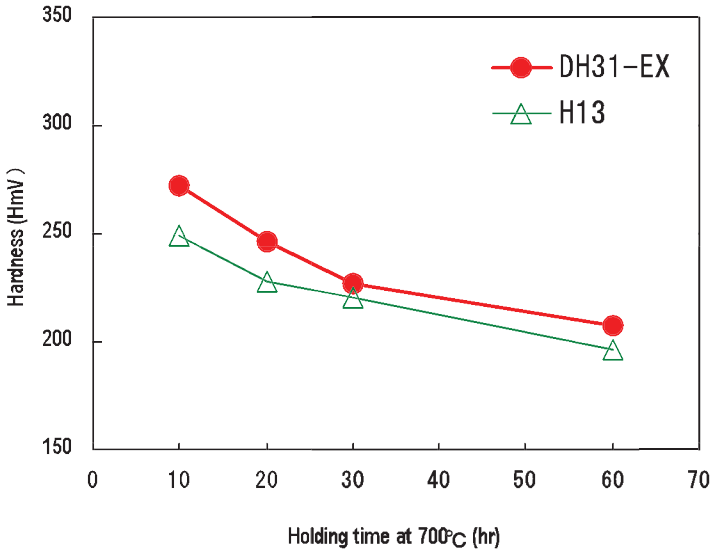
Heat checking resistance



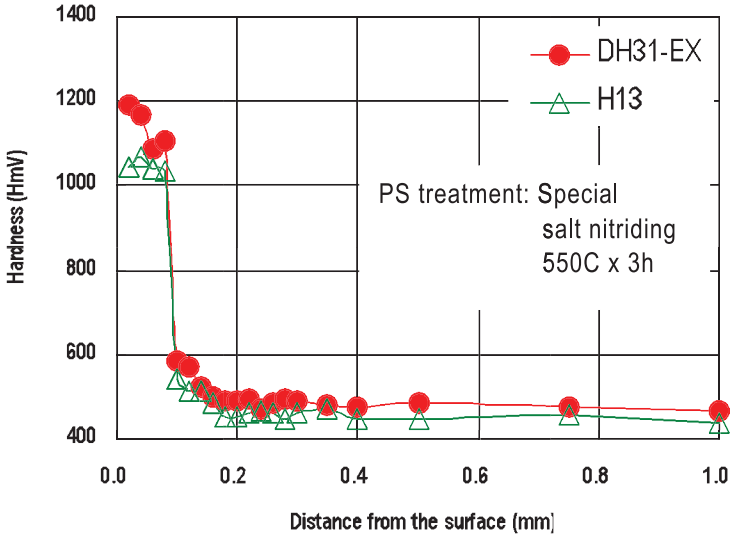
Al erosion resistance



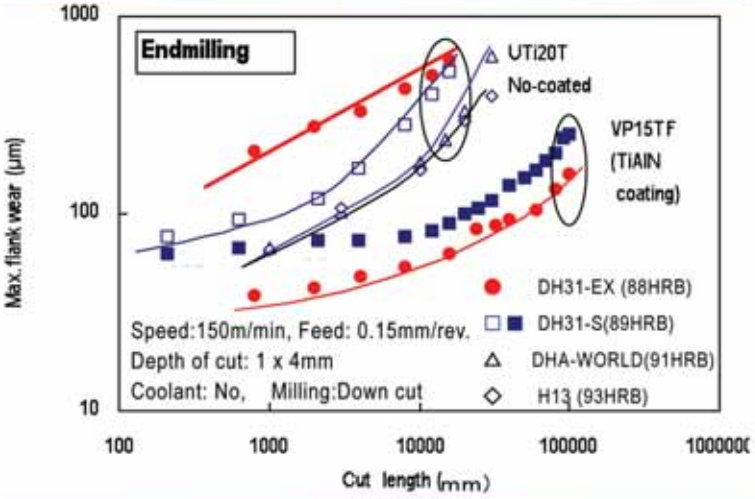
Hot hardness

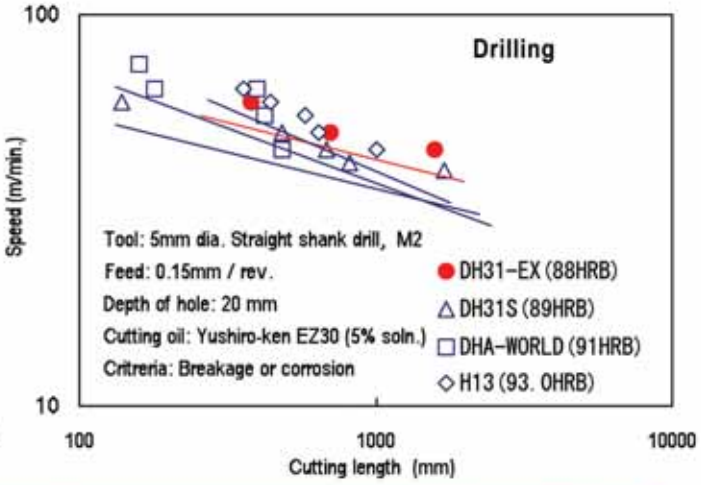


Nitriding characteristics



Machinability





Thermal expansion rate

Temperature	20～100℃	20～200℃	20～300℃	20～400℃	20～500℃	20～600℃	20～700℃
×10^{-6}/K	11.6	11.8	12.0	12.2	12.5	12.8	12.9

Thermal conductivity

Temperature	100℃	200℃	300℃	400℃	500℃	600℃	700℃
W/m·K	26.7	27.9	29.0	29.4	29.7	30.0	29.5

Specifc heat

Temperature	100℃	200℃	300℃	400℃	500℃	600℃	700℃
J/kg·K [cal/g·℃]	487 [0. 116]	527 [0. 126]	572 [0. 137]	626 [0. 150]	703 [0. 168]	802 [0. 192]	985 [0. 235]

Density

温度	20℃
kg/m^3 [g/cm^3]	7800. 0 [7. 80]

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