

# HIGH SPEED STEELS

## Application Segments

Cutting Tools

Automotive

## Available Product Variants

Long Products\*

Plates

\* Presented data refer exclusively to long products. Please observe the detailed explanations at the end of the data sheet (pdf).

## Product Description

### BÖHLER S705 – "The industrial one"

The conventional high-speed steel for industrial applications in machining. With a well-balanced alloy position and cobalt content, this type always manages to get the job done. Cobalt-alloyed molybdenum high-speed steel with high hardness, excellent cutting properties, outstanding compressive strength, high hot hardness, and good toughness.

## Process Melting

Airmelted

## Properties

- > Toughness & Ductility : good
- > Wear Resistance : high
- > Compressive strength : very high
- > Edge Stability : high
- > Grindability : good
- > Hot Hardness (red hardness) : very high

## Applications

- > Broaches and Reamers
- > End Mills
- > Gear Cutting, Shaving and Shaping Tools
- > Twist Drills and Taps
- > Special Cutting Tools
- > Blades for Sawing Machines

## Technical data

Material designation		Standards	
1.3243	SEL	4957	EN ISO
HS6-5-2-5	EN		

## Chemical composition (wt. %)

C	Cr	Mo	V	W	Co
0.92	4.1	5	1.9	6.2	4.8

## Material characteristics

	Compressive strength	Grindability	Red hardness	Toughness	Wear resistance	Edge Stability
BÖHLER S705	★★★	★★★	★★★★★	★★	★★	★★★★★
BÖHLER S200	★★★	★★	★★★	★★	★★★	★★
BÖHLER S401	★★	★★★	★★	★★★	★★	★★★
BÖHLER S404	★★	★★★	★★	★★★	★★	★★
BÖHLER S405	★★★	★★★	★★	★★★	★★	★★
BÖHLER S430	★★	★★★	★★	★★★	★★	★★
BÖHLER S500	★★★★	★★★	★★★★★	★★	★★★	★★★
BÖHLER S600	★★★	★★★	★★★	★★	★★	★★★
BÖHLER S607	★★★	★★★	★★★	★★	★★★	★★★
BÖHLER S630	★★★	★★★	★★★	★★	★★	★★★
BÖHLER S730	★★★	★★★	★★★★★	★★	★★	★★★★★

## Delivery condition

## Annealed

Hardness (HB)	max. 280   drawn execution max. 290HB
Tensile Strength (N/mm <sup>2</sup> )	max. 980

## Heat treatment

## Annealing

Temperature	770 to 840 °C	Controlled slow cooling in furnace ( 10 to 20°C/h / (50 to 68°F/h)) to approx. 600°C (1112°F), air cooling.
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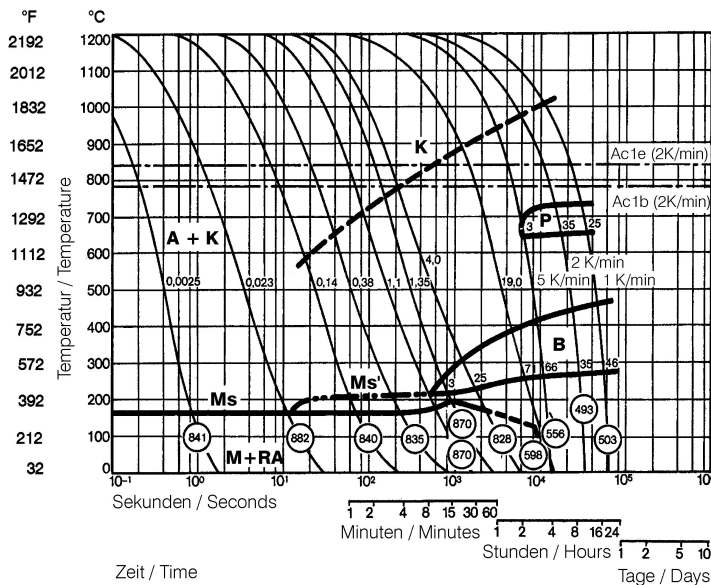
## Stress relieving

Temperature	600 to 650 °C	Slow cooling in furnace.    To relieve stresses set up by extensive machining or in tools of intricate shape.    After through heating, hold in neutral atmosphere for 1 to 2 hours.
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## Hardening and Tempering

Temperature	1,190 to 1,230 °C	Salt bath, vacuum    Preheating: 1st stage ~ 500 °C, 2nd stage ~ 850 °C, 3rd stage ~1050 °C    Austenitising: 1190 - 1230 °C, holding time after complete heating 80 seconds, maximum 150 seconds, to avoid material damage due to overheating.   Quenching: oil, warm bath (500 - 550 °C), gas
Temperature	550 to 570 °C	Slow heating to tempering temperature immediately after austenitising.    Dwell time in the furnace 1 hour per 20 mm material thickness (at least 1 hour)    Slow cooling to room temperature    3 tempering cycles recommended    Hardness see tempering chart

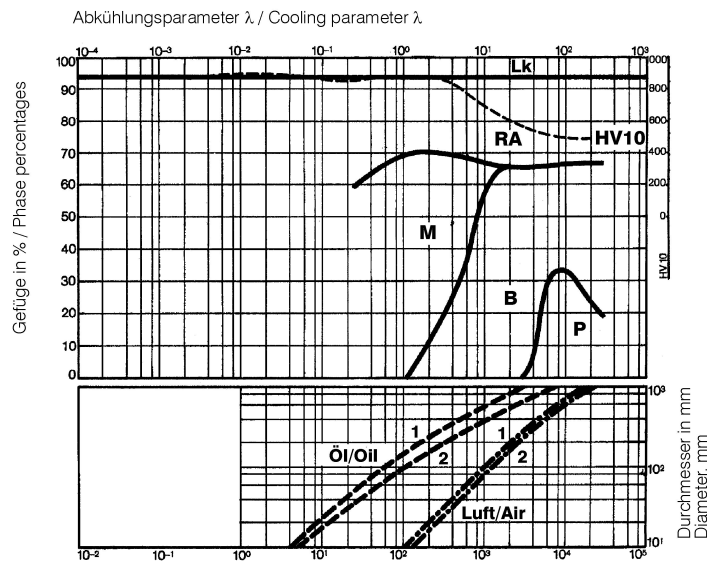
## Continuous cooling CCT curves



Austenitising temperature: 1200°C (2192°F)  
Holding time: 180 seconds

A....Austenite  
B....Bainite  
K....Carbide  
P....Pearlite  
M....Martensite  
RA...Retained Austenite

## Quantitative phase diagram

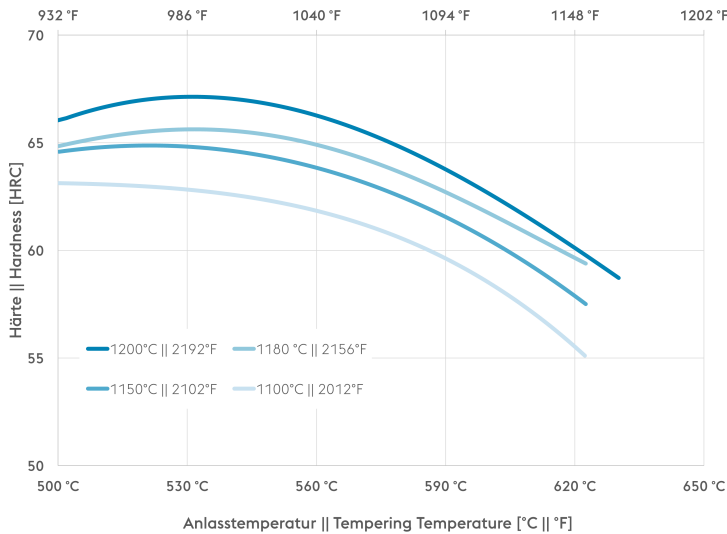


A....Austenite  
B....Bainite  
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M....Martensite  
RA...Retained Austenite

1....Edge or Face  
2....Core  
3....Jominy test: distance from quenched end

Kühlzeit von 800°C auf 500°C in Sek. / Cooling time in sec. from 800°C to 500°C (1472 - 932°F)

## Tempering Chart



Holding time 3 x 2 hours  
Specimen size: square 25 mm

## Physical Properties

Temperature (°C)	20
Density (kg/dm <sup>3</sup> )	7.9
Thermal conductivity (W/(m.K))	21
Specific heat (kJ/kg K)	0.42
Spec. electrical resistance (Ohm.mm <sup>2</sup> /m)	0.49
Modulus of elasticity (10 <sup>3</sup> N/mm <sup>2</sup> )	224

## Thermal Expansions between 20°C | 68°F and ...

Temperature (°C)	100	200	300	400	500	600	700
Thermal expansion (10 <sup>-6</sup> m/(m.K))	10.5	10.83	11.14	11.47	11.81	12.12	12.44

If other available product variants are listed in addition to long products, please note that these may differ in terms of melting process, technical data, delivery and surface condition as well as available product dimensions. For mandatory technical specifications, other requirements and dimensions, please contact our regional voestalpine BÖHLER sales companies. The data contained in this brochure is merely for general information and therefore shall not be binding on the company. We may be bound only through a contract explicitly stipulating such data as binding. Measurement data are laboratory values and can deviate from practical analyses. The manufacture of our products does not involve the use of substances detrimental to health or to the ozone layer.

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ONE STEP AHEAD.