

Superplast® 350: A patented mould steel that meets or exceeds standards for grades W 1.2738 HH.

Material properties

Prehardened steel for medium and very large – size moulds and tools with good machinability. Consistent texturing and polishing improved by **very low sulphur content**. Reliable repair welding and good thermal conductivity.

For which tools

Plastic injection or compression mould cores and cavities, large – size moulds for bumpers, dashboards, fenders, television panels, bottle crates, etc.

For which plastics

Thermoplastics (PE, PP, PS), thermosetting plastics, ABS, transparent melts. Injection moulding, compression moulding, RIM moulding, etc.

Properties

Chemical Analysis (% Weight).

C	Si	Mn	S	Ni	Cr	Mo	B
0.26	0.10	1.50	0.002	0.30	1.60	0.65	+

Mechanical Properties (typical values).

Superplast® 350 is delivered **quenched and tempered to 330 – 370 HB (35 – 39 Hrc)**.

Hardness	Rp 0.2 Yield Strength		Rm Tensile strength		Elongation	Reduction of area	KCV 20°C	Elastic modulus	
	MPa	ksi	MPa	ksi				MPa	ksi
HB					%	Z%	J	GPa	ksi
345	940	136	1095	159	15	50	25	205	29733

Physical Properties (typical values).

Thermal conductivity W.m ⁻¹ .K ⁻¹	Thermal expansion Coefficient (10 ⁻⁶ .K ⁻¹)			Specific heat J/kg.°C
20°C	20/100°C	20/200°C	20/300°C	
39	11.0	12.6	13.1	480

Through hardenability

Thanks to an optimal balance of alloying elements (especially Boron metallurgy) and high quality heat treatment, **Superplast® 350** exhibits a consistent hardness through large sections.

Diagram beside provides the hardness profile on a 530 mm - thick forged block.

A hardness difference of max 30HB all over the block is guaranteed.

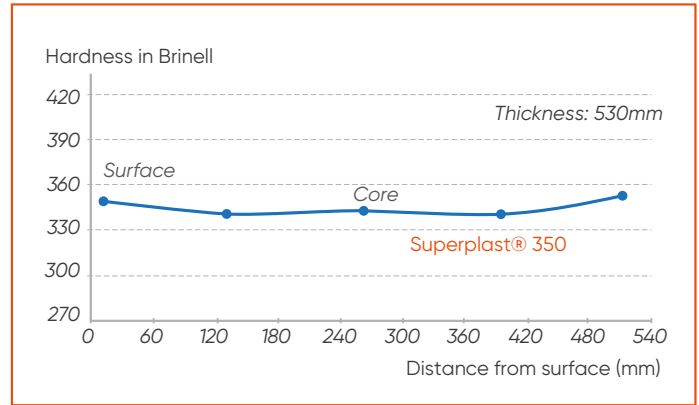


Plate processing

Welding

Cores and cavities can be polished and/or textured on welded areas if the following welding data provided below are respected.

Please consult the user guide for detailed information.



Process	Filler material	Preheating	Post heating	PWHT
GTAW	SP300 WELD - E DIN 25 CrMo 4	min. 150°C	150°C -2h	550°C - 2h

Dimensions

Typical delivery sizes

Manufacturing process	Thickness	Width
Hot rolling	8- 150 mm	1000 – 2000 mm
Hot forging	150 -1050 mm	1000 – 2000 mm

Your contact

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Technical data and information are to the best of our knowledge at the time of printing. However, they may be subject to some slight variations due to our ongoing research programme on steels. Therefore, we suggest that information be verified at time of enquiry or order. Furthermore, in service, real conditions are specific for each application. The data presented here are only for the purpose of description, and considered as guarantees when written formal approval has been delivered by our company. Further information may be obtained from the address opposite.