

Mars® 280

Rolled Homogeneous Armor heat treated for maximum resistance to shock.

Mars® 280 is a less hardness (typical 280 HBW), high toughness protection steel offering maximum resistance to shock and blast waves for all vehicle structures (main battle tanks, armoured personal carriers ...).

Properties

Standards

Mars® 280 can be ordered according to the following standard: MIL-DTL-12560 class 2 and TL 2350 Grade G.

Chemical composition - Ladle analysis - Max weight %

C	S	P	Si	Mn	Ni
0.27	0.002	0.012	0.4	1.2	1.8
Cr	Mo	V	B	CE ¹⁾	
1.5	0.6	0.10	0.003	0.80	

1) Carbon equivalence per ASTM A6/A6M, i.e. :
 $CE = C + [Mn/6] + [(Cr + Mo + V)/5] + [(Ni + Cu)/15]$

Mechanical Properties (in both directions)

MIL-DTL-12560 Version	Hardness	Yield Strength	UTS	Elongation	Charpy KV ²⁾ @-40°C standard 10 x 10 specimen ³⁾	
	HBW	MPa	Mpa	5d(%)	J	ft.lbs
Guarantees	260 - 310				≥ 43	≥ 32
Typical values	280	800	900	18%		

TL-2350 Version	Hardness	Yield Strength	UTS	Elongation	Charpy KV ²⁾ @-40°C standard 10 x 10 specimen ³⁾	
	HBW	MPa	Mpa	5d(%)	J	ft.lbs
Guarantees	280 - 310	750	900	12%	≥ 40	≥ 32
Typical values	290	800	900	18%		

Brinell hardness test according to relevant standard (EN ISO 65061 / ASTM E10/E110), Charpy Impact test according to relevant standard (EN ISO 148-1 / ASTM E23) on each heat and thickness from 6mm.

In service conditions

Ballistic properties

Mars® 280 exceeds the ballistic performance requirements of MIL-DTL-12560 for class 2 material. Ballistic test to be performed upon request.

Plate processing

Cutting

Mars® 280 can be cut either by abrasive waterjet, laser or plasma.

Bending

Mars® 280 offers ability to cold forming but as other protection steels must be used with caution. The elastic energy stored during forming may lead to rupture or shifting. It is essential to maintain a safety distance and not situate oneself in front of the plate while it is being formed. It is crucial to wear appropriate individual safety equipment and to equip machines with collective protection. The capacity of the machine and tools must be suitable information on bending loads in relation to tools, plate thickness and steel strength.

The most important parameter when bending are the use of a correct punch radius. Please contact us if you need assistance.

General recommendations :

- Minimal recommended temperature: 15°C
- Ensure that there are no obvious defects, especially on edges. Ideally, plate edges in the bending area should be ground smooth and rounded prior to operation.
- Die edges must remain clean, smooth, and ideally lubricated.
- Perform preliminary trials on prototypes and form the first pieces with low speed recommendation.
- Make sure that there is enough room in the die for the chosen punch together with the workpiece :

Die width > punch diameter + 3 x thickness

Grade	Mandrel Radius		Width of the die
Mars® 280	5t	5t	Die width > 2 x radius + 3 x thickness

Welding

Mars® 280 can be welded using common welding processes. Like the other protection steels, it can be sensitive to cold cracking in the heat affected zone of a weld. The best results can be obtained by :

- Make sure that the steel is at least at room temperature (≈ 20 °C). For thicknesses higher than 40mm, the steel must be preheated at a temperature maximum of 100°C (maximal temperature acceptable by plate to preserve mechanical proprieties).
- Clean the weld joint area, removing potential sources of hydrogen: rust, scale, moisture, grease, ...
- Using low hydrogen welding methods and consumables (filler material hydrogen content $HD \leq 5$ ml/100 g).
- Preferably use MAG welding and a welding sequence that is designed to minimize residual stresses.
- Austenitic consumables must be used. The recommended stainless austenitic consumables are of type AWS 307.

Delivery conditions

Heat treatment

Mars® 280 is quenched and tempered at high temperature ($\geq 480^{\circ}\text{C}$).

Surface properties

According to EN 10163 class B – subclass 3.

Shot blasting and weldable primer application can be performed upon request.

Sizes and tolerances

Mars® 280 can be supplied as quarto plates or cut-to-length sheets (from hot strip mill) in standard sizes or tailor made dimensions.

	Quarto plates			Cut-to-length sheets
Thicknesses	5.0 – 50.8 mm (.197" – 2")			5.0 – 10.0 mm (.197" – .393")
Thickness Tolerances	Th	For width ≤ 2000 mm	For width ≤ 2400 mm	
	≥ 5 to ≤ 12	0/+0.8	0/+0.8	≥ 5.0 to ≤ 8.5 :
	> 12 to 20	0/+1.0	0/+1.2	-0/+0.4
	> 20 to 35	0/+1.2	0/+1.4	> 8.5 to ≤ 10.0 :
	> 35 to 50.8	0/+1.6	0/+1.8	-0/+0.5
Width	1500 – 3500 mm (39" – 137")			1500 – 2000 mm (39" – 78")
Lenght	1200 – 8100 mm (47" – 319")			1800 – 8100 mm (71" – 319")
Shape, length, and width tolerances as per EN 10029				

For information purpose only, refer to the requirements of specified standard.

Flatness

Maximum flatness deviation is 3 mm/m (when measured according to EN 10029).

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Technical data and information are to the best of our knowledge at the time of editing. 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.