



Material No.: Code:
1.3247 HS2-9-1-8

DE - Brand:
EMo9CoH

Chemical composition:
(Typical analysis in %)

C	Cr	Mo	V	W	Co		
1,10	4,10	9,50	1,20	1,50	8,00		

Steel properties:

High Co-Mo-alloyed high-speed steel, high secondary hardness maximum, high wear resistance with good toughness. Similar to AISI M42.

Applications:

Die and engraver's milling cutters, tools for machining of aerospace material (for example Ti-alloys), cold extrusion punches, thread rolling dies and rolls.

Condition of delivery:

Soft annealed to max. 277 HB

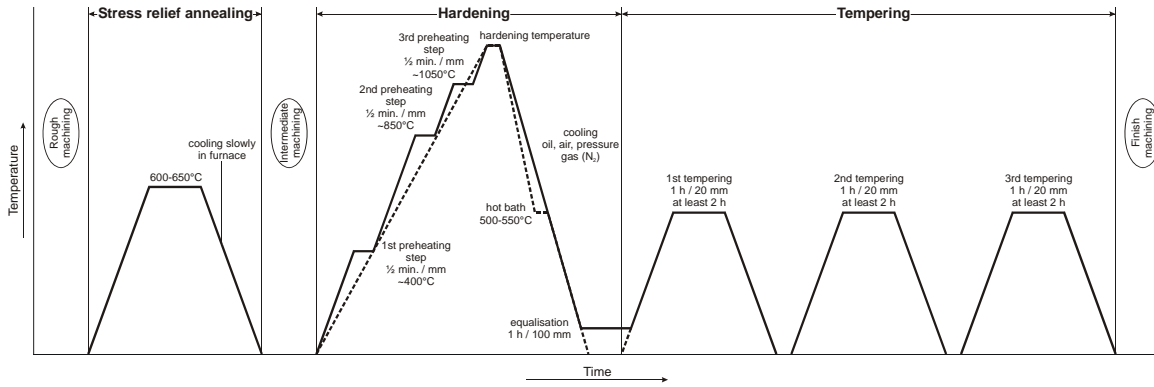
Physical properties:

Thermal expansion coefficient	$\left[\frac{10^{-6} \cdot \text{m}}{\text{m} \cdot \text{K}} \right]$	20-100°C	20-200°C	20-300°C	20-400°C
		8,5	9,8	10,8	11,1
Thermal conductivity	$\left[\frac{\text{W}}{\text{m} \cdot \text{K}} \right]$	20°C	350°C	700°C	
		27,2	26,8	25,9	

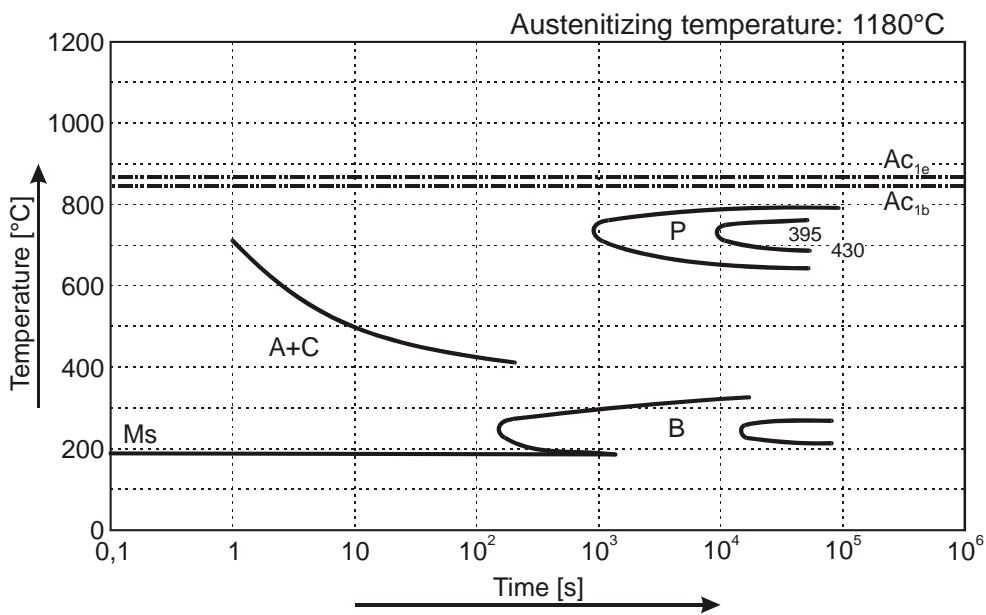
Heat treatment:

Soft annealing	<table border="1"><thead><tr><th>Temperature</th><th>Cooling</th><th>Hardness</th></tr></thead><tbody><tr><td>820 - 860°C</td><td>furnace</td><td>max. 277 HB</td></tr></tbody></table>	Temperature	Cooling	Hardness	820 - 860°C	furnace	max. 277 HB
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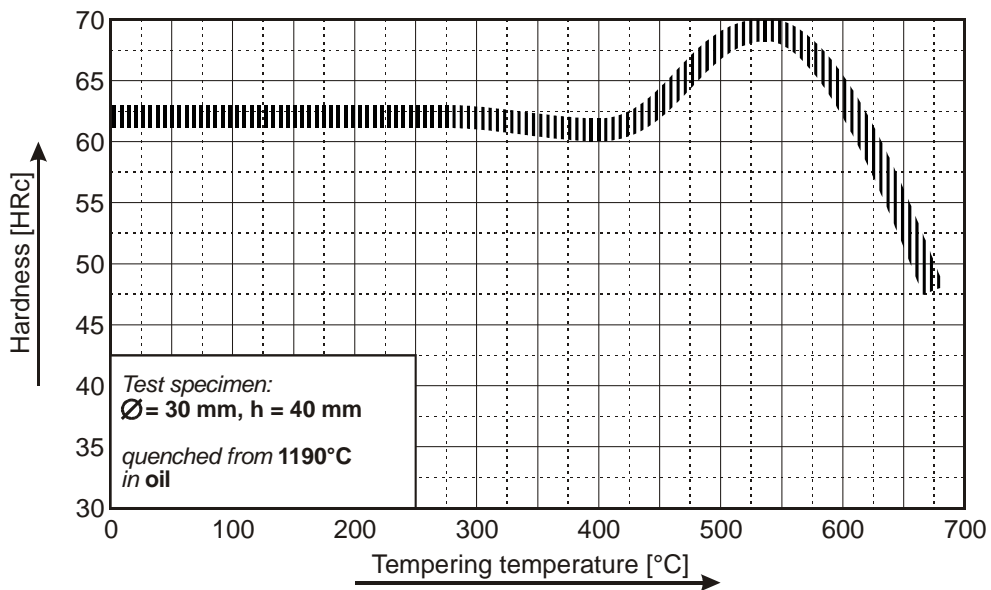
(1.3247) Thermal Cycle Diagram



Continuous Cooling Transformation Diagram (CCT)



Tempering Diagram



Remarks: All technical information is for reference only.