

ASSAB 2344



ASSAB 

General

ASSAB 2344 is a chromium-molybdenum-vanadium-alloyed tool steel which is characterised by:

- Good resistance to abrasion at both low and high temperatures
- High level of toughness and ductility
- Good machinability and polishability
- Good high-temperature strength and resistance to thermal fatigue
- Excellent through-hardening properties
- Very limited distortion during hardening

Typical analysis %	C 0.39	Si 1.1	Mn 0.4	Cr 5.2	Mo 1.4	V 0.9
Standard specification	AISI H13, WNr. 1.2344, SKD 61, EN X40CrMoV5-1					
Delivery condition	Soft-annealed to max. 205 HB					
Colour code	Orange / Violet					



Aluminium extrusion profiles.

Applications

PLASTIC MOULDING

Part	Aust. and tempering temp.	HRC
Injection moulds Compression/ transfer moulds	Austenitising 1020 - 1030°C Tempering 250°C	50-52

EXTRUSION

Part	Aluminium, magnesium alloys, HRC	Copper alloys HRC	Stainless steels HRC
Dies	44 - 50	43 - 47	45 - 50
Backers, die holders, liners, dummy blocks, stems	41 - 50	40 - 48	40 - 48
Austenitising temperature	1020 - 1030°C	1040 - 1050°C	

DIE CASTING

Part	Tin, lead zinc alloys HRC	Aluminium magnesium alloys, HRC
Dies	46 - 50	42 - 48
Fixed inserts, cores	46 - 52	44 - 48
Sprue parts	48 - 52	46 - 48
Nozzles	35 - 42	42 - 48
Ejector pins (nitrided)	46 - 50	46 - 50
Plunger, short-sleeve (normally nitrided)	42 - 46	42 - 48
Austenitising temp.	1020 - 1030°C	

OTHER APPLICATIONS

Application	Aust. and tempering temp.	HRC
Severe cold punching, scrap shears	Austenitising 1020 - 1030°C Tempering 250°C	50 - 52
Hot Shearing	Austenitising 1020 - 1030°C Tempering 250°C Tempering 575 - 600°C	50 - 52 45 - 50
Shrink rings (e.g., for cemented carbide dies)	Austenitising 1020 - 1030°C Tempering 575-600°C	45 - 50
Wear resisting parts	Austenitising 1020 - 1030°C Tempering 575°C Nitriding	Core 50 - 52 Surface ~1000HV ₁

Other applications also include forming dies, die inserts, and tools for the manufacture of screws, nuts, rivets & bolts.

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The information contained herein is based on our present state of knowledge and is intended to provide general notes on our products and their uses. It should not therefore be construed as a warranty of specific properties of the products described or a warranty for fitness for a particular purpose. Each user of ASSAB products is responsible for making its own determination as to the suitability of ASSAB products and services.

Edition 150725

Properties

PHYSICAL DATA

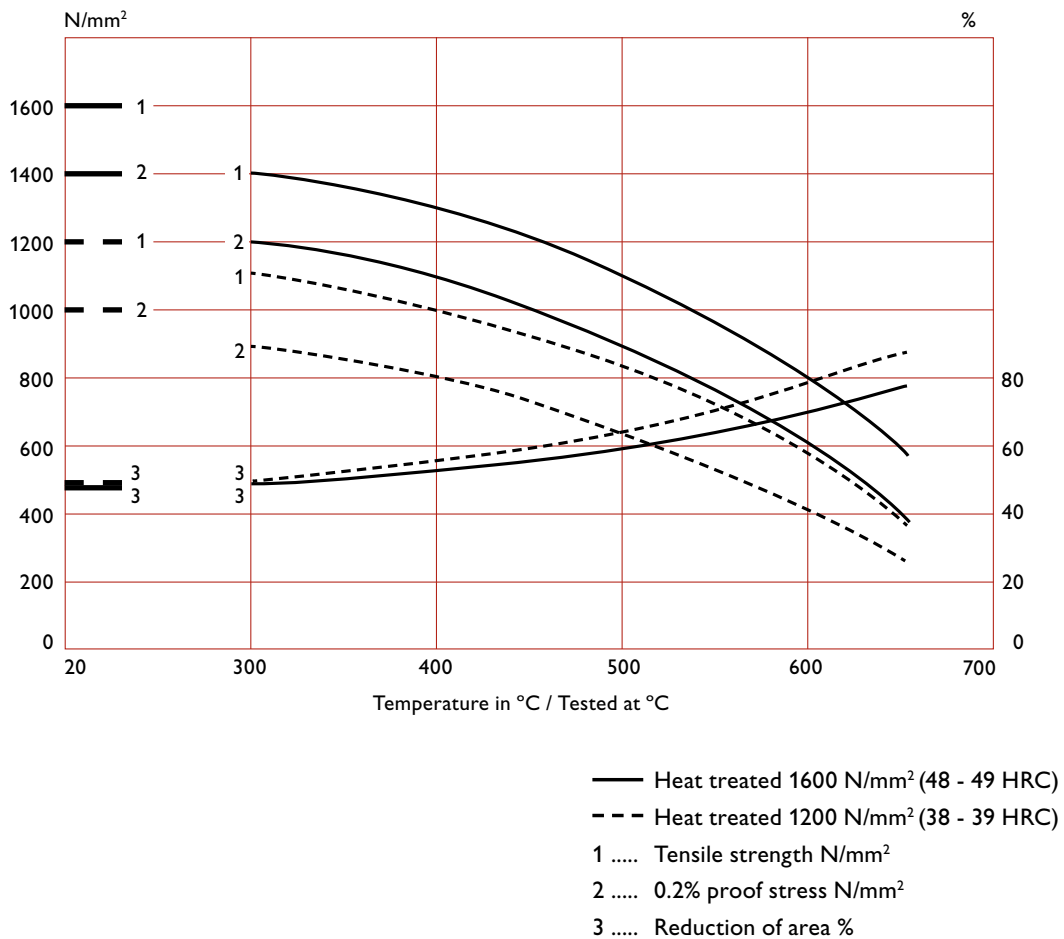
Unless otherwise indicated, all specimens were hardened 30 minutes at 1025°C, quenched in air and tempered 2 + 2 h at 610°C. The hardness were 45 ± 1 HRC.

Temperature	20°C	400°C	600°C
Density kg/m ³	7800	7700	7600
Modulus of elasticity MPa	215 000	180 000	165 000
Coefficient of thermal expansion per °C from 20°C	-	12.5 × 10 ⁻⁶	13.0 × 10 ⁻⁶
Thermal conductivity W/m °C	24	28	28



MECHANICAL PROPERTIES

Hot strength



Heat treatment

SOFT ANNEALING

Protect the steel and heat through to 750 - 800°C. Then cool in the furnace at 10 - 20°C per hour to 600°C, then freely in air.

STRESS RELIEVING

After rough machining, the tool should be heated through to 650°C, holding time 2 hours. Cool slowly to 500°C, then freely in air.

HARDENING

Preheating temperature: 600 - 850°C, normally in two preheating steps.

Austenitising temperature: 1020 - 1050°C, normally 1020 - 1030°C.

Temperature °C	Soaking time minutes	Hardness before tempering
1025	30	53±2 HRC
1050	15	54±2 HRC

Soaking time = time at hardening temperature after the tool is fully heated through.

Protect the tool against decarburisation and oxidation during hardening.

QUENCHING MEDIA

- High-speed gas/circulating atmosphere
- High-speed gas with sufficient positive pressure quenching in vacuum furnace. Interrupted quench is recommended for distortion control, or when quench cracking is a concern.
- Martempering bath or fluidised bed at 450 - 550°C, then cool in air
- Martempering bath or fluidised bed at approx. 180 - 220°C then cool in air
- Warm oil

Note 1: Temper the tool as soon as its temperature reaches 50 - 70°C.

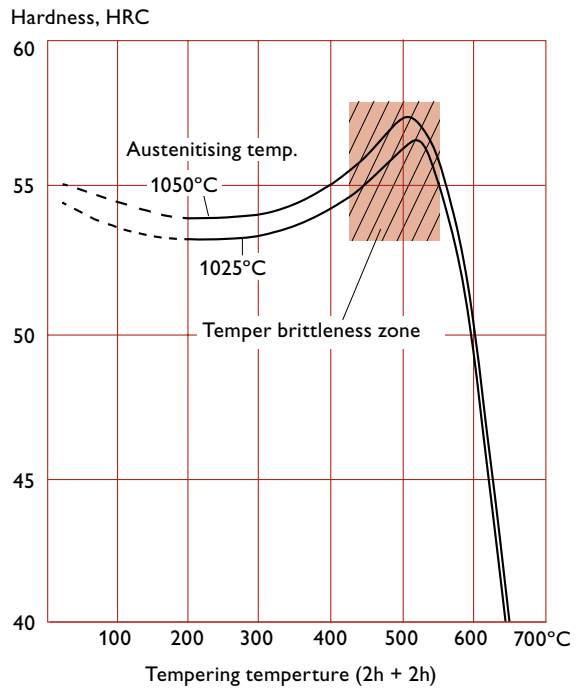
Note 2: In order to obtain the optimum properties for the tool, the cooling rate should be fast, but not at a level that gives excessive distortion or cracks.

TEMPERING

Choose the tempering temperature according to the hardness required by reference to the tempering graph. Temper at least twice with intermediate cooling to room temperature.

The lowest tempering temperature which should be used is 180°C. The minimum holding time at tempering temperature is 2 hours. To avoid “temper brittleness”, do not temper in the range 425 - 550°C, see graph.

Tempering graph



Tempering within the range 425 - 550°C is normally not recommended due to the reduction in toughness properties.

Machining recommendations

The cutting data below are to be considered as guiding values and as starting points for developing your own best practice.

Condition: Soft-annealed condition ~185 HB

TURNING

Cutting data parameters	Turning with carbide		Turning with HSS [†]
	Rough turning	Fine turning	Fine turning
Cutting speed (v _c) m/min	200 - 250	250 - 300	25 - 30
Feed (f) mm/r	0.2 - 0.4	0.05 - 0.2	0.05 - 0.3
Depth of cut (a _p) mm	2 - 4	0.5 - 2	0.5 - 3
Carbide designation ISO	P20 - P30 Coated carbide	P10 Coated carbide or cermet	-

[†] High-speed steel

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[†] High-speed steel

DRILLING

High-speed steel twist drill

Drill diameter mm	Cutting speed (v _c) m/min	Feed (f) mm/r
≤ 5	16 - 18*	0.05 - 0.15
5 - 10	16 - 18*	0.15 - 0.20
10 - 15	16 - 18*	0.20 - 0.25
15 - 20	16 - 18*	0.25 - 0.35

* For coated HSS drill, v_c ~ 28-30 m/min

Carbide drill

Cutting data parameters	Type of drill		
	Indexable insert	Solid carbide	Brazed carbide ¹
Cutting speed (v _c) m/min	220 - 240	130 - 160	80 - 110
Feed (f) mm/r	0.03 - 0.10 ²	0.10 - 0.25 ²	0.15 - 0.25 ²

¹ Drill with interntal cooling channels and brazed carbide tip

² Depending on drill diameter

MILLING

Face and square shoulder milling

Cutting data parameters	Milling with carbide	
	Rough milling	Fine milling
Cutting speed (v _c) m/min	180 - 260	260 - 300
Feed (f _z) mm/tooth	0.2 - 0.4	0.1 - 0.2
Depth of cut (a _p) mm	2 - 5	≤ 2
Carbide designation ISO	P20 - P40 Coated carbide	P10 - P20 Coated carbide or cermet

End milling

Cutting data parameters	Type of end mill		
	Solid carbide	Carbide indexable insert	High-speed steel
Cutting speed (v _c) m/min	160 - 200	170 - 230	35 - 40 ¹
Feed (f) mm/tooth	0.03 - 0.20 ²	0.08 - 0.20 ²	0.05 - 0.35 ²
Carbide designation ISO	-	P20 - P30	-

¹ For coated HSS end mill, v ~ 55-60 m/min

² Depending on radial depth of cut and cutter diameter

GRINDING

Wheel recommendation

Type of grinding	Soft- annealed condition	Hardened condition
Face grinding straight wheel	A 46 HV	A 46 HV
Face grinding segments	A 24 GV	A 36 GV
Cylindrical grinding	A 46 LV	A 60 KV
Internal grinding	A 46 JV	A 60 IV
Profile grinding	A 100 LV	A 120 KV

Surface treatment

NITRIDING AND NITROCARBURISING

Nitriding and nitrocarburising result in a hard surface layer which is very resistant to wear and erosion. The nitrided layer is, however, brittle and may crack or spall when exposed to mechanical or thermal shock, the risk increasing with layer thickness. Before nitriding, the tool should be hardened and tempered at a temperature at least 25 - 50°C above the nitriding temperature.

Nitriding in ammonia gas at 510°C, or plasma nitriding in a 75% hydrogen/25% nitrogen mixture at 480°C, both result in a surface hardness of about 1100 HV_{0.2}. In general, plasma nitriding is the preferred method because of better control over nitrogen potential. Particularly, plasma nitriding can readily avoid the formation of so-called white layer, which is not recommended for hot work service. However, careful gas nitriding can give perfectly acceptable results.

ASSAB 2344 can also be nitrocarburised in either gas or salt bath. The surface hardness after nitrocarburising is 900 - 1000 HV_{0.2}.

Depth of nitriding

Process	Time, h	Depth, mm
Gas nitriding at 510°C	10	0.12
	30	0.20
Plasma nitriding at 480°C	10	0.12
	30	0.18
Nitrocarburising – in gas at 580°C – in salt bath at 580°C	2.5	0.11
	1	0.06

Nitriding to case depths >0.3 mm is not recommended for hot-work applications. ASSAB 2344 can be nitrided in the soft-annealed condition. The hardness and depth of case will, however, be reduced somewhat in this case.

HARD CHROME PLATING

After plating, parts should be tempered at 180°C for 4 hours, within 4 hours of plating, to avoid the risk of hydrogen embrittlement.

Electrical discharge machining

If spark-erosion is performed in the hardened and tempered condition, the white re-cast layer should be removed mechanically by grinding or stoning. The tool should then be given an additional temper at approx. 25°C below the previous tempering temperature.

Welding

Welding of tool steel can be performed with good results if proper precautions are taken regarding elevated temperature, joint preparation, choice of consumables and welding procedure. The following guidelines summarise the most important welding process parameters.

Welding method	TIG	MMA
Working temp.	325 - 375°C	325 - 375°C
Filler material	QRO 90 TIG-WELD DIEVAR TIG-WELD UTP A 673	QRO 90 WELD UTP 673
Cooling rate	20 - 40°C/h for the first 2 to 3 hours and then freely in air	
Hardness after welding	QRO 90 TIG-WELD DIEVAR TIG-WELD 48 - 53 HRC UTP A 673 57 - 60 HRC	QRO 90 WELD 48 - 53 HRC UTP 673 55 - 58 HRC
Heat treatment after welding		
Hardened condition	Temper at 25°C below the original tempering temperature.	
Soft-annealed condition	Soft anneal according to the "Heat treatment" recommendation.	

Polishing

ASSAB 2344 exhibits good polishability in the hardened and tempered condition. Polishing after grinding can be effected using aluminium oxide or diamond paste.

TYPICAL PROCEDURE

1. Rough grinding to 180 - 320 grain size using a wheel or stone.
2. Fine grinding with abrasive paper or powder, down to 400 - 800 grain size.
3. Polish with diamond paste grade 15 (15µm grain size) using a polishing tool of soft wood or fibre.
4. Polish with diamond paste 8-6-3 (8-6-3µm grain size) using a polishing tool of soft wood or fibre.
5. When demands on surface finish are high, grade 1 (1µm grain size) diamond paste can be used for final polishing with a fibre polishing pad.

Photo-etching

ASSAB 2344 is suitable for texturing by the photo-etching method. Its high level of homogeneity and low sulphur content ensures accurate and consistent pattern reproduction.

Further information

For further information, i.e., steel selection, heat treatment, application and availability, please contact our ASSAB office nearest to you.

REGIONAL HEAD OFFICE

SINGAPORE

ASSAB Pacific Pte Ltd
Tel : +65 6534 5600
Fax: +65 6534 0655
info@assab.com
www.assab.com

CHINA

Beijing

ASSAB Tooling (Beijing) Co., Ltd.
Tel : +86 10 6786 5588
Fax: +686 10 6786 2988
info.beijing@assab.com

Changsha*

ASSAB Tooling (Dong Guan)
Co., Ltd., Hunan Branch
Tel : +86 731 8452 3986
Fax: +86 731 8452 3986
info.changsha@assab.com

Chongqing

ASSAB Tooling Technology
(Chongqing) Co., Ltd.
Tel : +86 23 6745 5698
Fax: +86 23 6745 5699
info.chongqing@assab.com

Changzhou*

ASSAB Tooling Technology (Shanghai)
Co., Ltd. - Changzhou Branch
Dalian Branch
Tel : +86 519 8188 0008
Fax: +86 519 8510 2820
info.changzhou@assab.com

Dalian

ASSAB Tooling (Beijing) Co., Ltd.,
Dalian Branch
Tel : +86 411 8761 8080
Fax: +86 411 8761 9595
info.dalian@assab.com

Dongguan

ASSAB Tooling (Dong Guan)
Co., Ltd.
Tel : +86 769 2289 7888
Fax: +86 769 2289 9312
info.dongguan@assab.com

Guangzhou*

ASSAB Tooling (Dong Guan)
Co., Ltd., Guangzhou Branch
Tel : +86 020 3482 8891
Fax: +86 020 3482 5329
info.guangzhou@assab.com

Hong Kong*

ASSAB Steels (HK) Ltd.
Tel : +852 2487 1991
Fax: +852 2489 0938
info.hongkong@assab.com

Nanchang*

ASSAB Tooling (Dong Guan)
Co., Ltd., Jiangxi Branch
Tel : +86 769 2289 7888
Fax: +86 769 2289 9312
info.jiangxi@assab.com

Ningbo

ASSAB Tooling Technology
(Ningbo) Co., Ltd.
Tel : +86 574 8680 7188
Fax: +86 574 8680 7166
info.ningbo@assab.com

Qingdao

ASSAB Tooling (Qingdao) Co., Ltd.
Tel : +86 532 8752 9999
Fax: +86 532 8752 9588
info.qingdao@assab.com

Shanghai

ASSAB Tooling Technology
(Shanghai) Co., Ltd.
Tel : +86 21 2416 9688
Fax: +86 21 5442 4244
info.shanghai@assab.com

Suzhou*

ASSAB Tooling Technology
(Shanghai) Co., Ltd. - Suzhou Branch
Tel : +86 512 6900 0161
Fax: +86 512 6252 9227
info.suzhou@assab.com

Tianjin*

ASSAB Tooling (Beijing) Co., Ltd.,
Tianjin Branch
Tel : +86 22 2370 7808
Fax: +86 22 2370 7806
info.tianjin@assab.com

Wuhan

ASSAB Tooling Technology
(Shanghai) Co., Ltd. - Wuhan Branch
Tel : +86 27 6930 0156
Fax: +86 27 6934 6326
info.wuhan@assab.com

Xiamen

ASSAB Tooling (Xiamen) Co., Ltd.
Tel : +86 592 562 4678
Fax: +86 592 568 3703
info.xiamen@assab.com

Yantai*

ASSAB Tooling (Qingdao) Co., Ltd.
Tel : +86 535 693 4100
Fax: +86 535 693 4200
info.yantai@assab.com

INDONESIA

Jakarta - Head Office

PT. ASSAB Steels Indonesia
Tel : +62 21 461 1314
Fax: +62 21 461 1306/
+62 21 461 1309
info.jakarta@assab.com

Bandung*

PT. ASSAB Steels Indonesia
Tel : +62 22 5234 017
Fax: +62 22 5234 020
info.bandung@assab.com

Cikarang*

PT. ASSAB Steels Indonesia
Tel : +62 21 461 1314
Fax: +62 21 461 1306/
+62 21 461 1309
info.cikarang@assab.com

Medan*

PT. ASSAB Steels Indonesia
Tel : +62 61 8477 935
Fax: +62 61 8477 936
info.medan@assab.com

Semarang*

PT. ASSAB Steels Indonesia
Tel : +62 24 7071 2574/
+62 24 7658 4803
Fax: +62 24 674 7145
info.semarang@assab.com

Surabaya

PT. ASSAB Steels Indonesia
Tel : +62 31 849 9606
Fax: +62 31 843 2040
info.surabaya@assab.com

Tangerang*

PT. ASSAB Steels Indonesia
Tel : +62 21 5316 0720-1
Fax: +62 21 5316 0794
info.tangerang@assab.com

JAPAN

Tokyo - Head Office*

Bohler-Uddeholm KK
Tel : +81 3 5226 3771
Fax: +81 3 5226 6110
info@bohler-uddeholm.jp

Fukuroi*

Bohler-Uddeholm KK
Tel : +81 538 43 9240
Fax: +81 538 43 9244
info@bohler-uddeholm.jp

Nagoya*

Bohler-Uddeholm KK
Tel : +81 52 979 5081
Fax: +81 52 933 6461
info@bohler-uddeholm.jp

Osaka*

Bohler-Uddeholm KK
Tel : +81 6 6307 7621
Fax: +81 6 6307 7627
info@bohler-uddeholm.jp

KOREA

Incheon - Head Office

ASSAB Steels (Korea) Co., Ltd.
Tel : +82 32 821 4300
Fax: +82 32 821 3311
info.korea@assab.com

Busan

ASSAB Steels (Korea) Co., Ltd.
Tel : +82 51 831 3315
Fax: +82 51 831 3319
info.korea@assab.com

Daegu

ASSAB Steels (Korea) Co., Ltd.
Tel : +82 53 384 3315
Fax: +82 53 384 3317
info.korea@assab.com

Gwangju

ASSAB Steels (Korea) Co., Ltd.
Tel : +82 53 384 3315
Fax: +82 53 384 3319
info.korea@assab.com

MALAYSIA

Kuala Lumpur - Head Office

ASSAB Steels (Malaysia) Sdn. Bhd. (79223-X)
Tel : +60 3 6189 0022
Fax: +60 3 6189 0044/55
info.kualalumpur@assab.com

Penang

ASSAB Steels (Malaysia) Sdn. Bhd. (79223-X)
Tel : +60 4 507 2020
Fax: +60 4 507 6323
info.penang@assab.com

Johor

ASSAB Steels (Malaysia) Sdn. Bhd. (79223-X)
Tel : +60 7 598 0011
Fax: +60 7 599 4890
info.johor@assab.com

PHILIPPINES

Manila

ASSAB Pacific Pte Ltd -
Philippine Branch
Tel : +63 29 539 0441 to 0442
Fax: +63 49 539 1075
info.philippines@assab.com

Cebu

ASSAB Pacific Pte Ltd -
Philippine Branch
Tel : +63 32 236 0706
Fax: +63 32 236 0338
info.philippines@assab.com

SINGAPORE

ASSAB Steels Singapore (Pte) Ltd
Tel : +65 6862 2200
Fax: +65 6862 0162
info.singapore@assab.com

TAIWAN

Taipei - Head Office

ASSAB Steels Taiwan Co., Ltd
Tel : +886 2 2299 2849
Fax: +886 2 2299 0147
info.taipei@assab.com

Kaoshiung

ASSAB Steels Taiwan Co., Ltd
Tel : +886 7 624 6600
Fax: +886 7 624 0012
info.kaoshiung@assab.com

Nantou

ASSAB Steels Taiwan Co., Ltd
Tel : +886 49 225 1702
Fax: +886 49 225 3173
info.nantou@assab.com

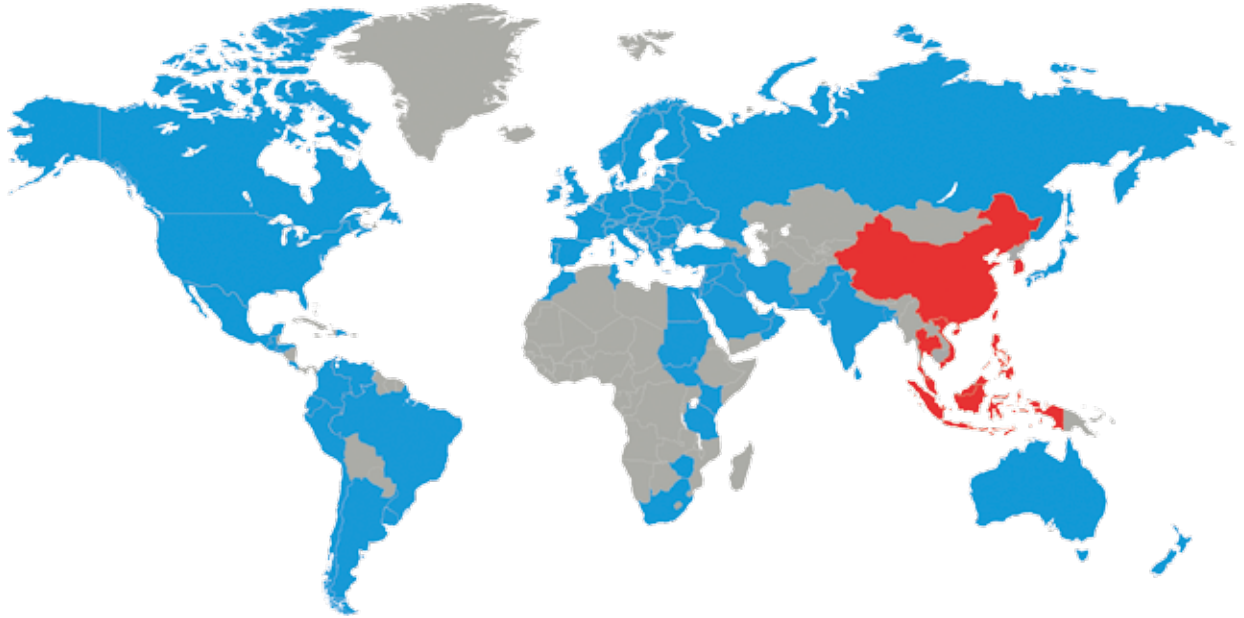
THAILAND

ASSAB Steels (Thailand) Ltd.
Tel : +66 2 757 5017
Fax: +66 2 385 5943
info.thailand@assab.com

VIETNAM

ASSAB Steels (Vietnam) Co. Ltd
Tel : +84 61 8899 099
Fax: +84 61 8899 191
info.vietnam@assab.com

* Sales office



Choosing the right steel is of vital importance. ASSAB engineers and metallurgists are always ready to assist you in your choice of the optimum steel grade and the best treatment for each application. ASSAB not only supplies steel products with superior quality, we offer state-of-the-art machining, heat treatment and surface treatment services to enhance steel properties to meet your requirement in the shortest lead time. Using a holistic approach as a one-stop solution provider, we are more than just another tool steel supplier.

ASSAB and Uddeholm are present on every continent. This ensures you that high-quality tool steels and local support are available wherever you are. Together we secure our position as the world's leading supplier of tooling materials.

For more information, please visit www.assab.com