

# Product sheet: Toolox<sup>®</sup> 44, 450 HBW (~45 HRC) with ESR properties

## Specification

<b>Hardness</b>	HBW 410 - 475		
<b>Impact toughness</b>	Test temperature 20 °C	Impact energy, Charpy-V-test for plate, transverse direction; min J ≤ 130 mm 18	Impact energy, Charpy-V-test for forged bar, thickness direction; min J > 130 mm 11
<b>Ultrasonic inspection</b>	Ultrasonic inspection is carried out according to: EN 10 160 (rolled plates) EN 10228-3 (forged bars) with extra demands according to specification SSAB V6		
<b>Etching</b>	Toolox 44 fulfils the etching requirements of NADCA # 207-2006.		
<b>Dimensions</b>	Toolox 44 is supplied as plate in thicknesses between 5 - 130 mm, or as forged bars in thicknesses between 150 - 300 mm.		
<b>Delivery condition</b>	Quenched and tempered at a minimum temperature of 590 °C.		
<b>Heat treatment</b>	Toolox 44 is not intended for further heat treatment. If Toolox 44 is heated above 590 °C after delivery from SSAB Plate no guarantees for the properties of the steel are given.		
<b>Nitriding/coating</b>	Nitriding or surface coating may be carried out if the temperature is below 590 °C.		
<b>Testing</b>	Testing according to EN 10 025 and EN ISO 6506-1. Hardness is measured on a milled surface 0.5 - 2 mm below the original surface.		
<b>Tolerances</b>	Thickness, length, width and flatness tolerances according to "Dimension program and tolerances for new rolling of tool steel plates from SSAB Plate". Forged bars: According to DIN 7527.		
<b>Surface finish</b>	On delivery from SSAB Plate the plate meets the following specifications: - free from mill scale - not repair welded - surface defects below the nominal ordered thickness are not permitted. Forged bars according to DIN 7527.		

**SSAB Oxelösund AB**  
SE-613 80 Oxelösund  
Sweden

Tel: +46 155 25 40 00  
Fax: +46 155 25 55 34  
contact@ssab.com

[www.toolox.com](http://www.toolox.com)

# Technical information

## Toolox<sup>®</sup> 44

### Usage

Toolox 44 is a new steel delivered quenched and tempered with high impact toughness and very low residual stresses to get good dimensional stability. Despite its hardness of 450 HBW (~45 HRC), Toolox 44 is easily machined. Toolox 44 has high strength at elevated temperature and is suitable for dies and tools such as plastic, rubber, die casting, bending and sheet forming tools. Toolox 44 is also well suited as machine components such as wear parts, guide rails, hot applications. With proper surface treatment, the service life of the tool/component can be prolonged.

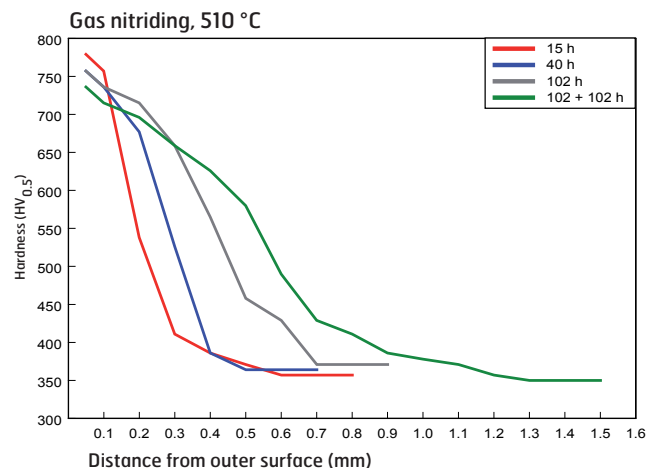
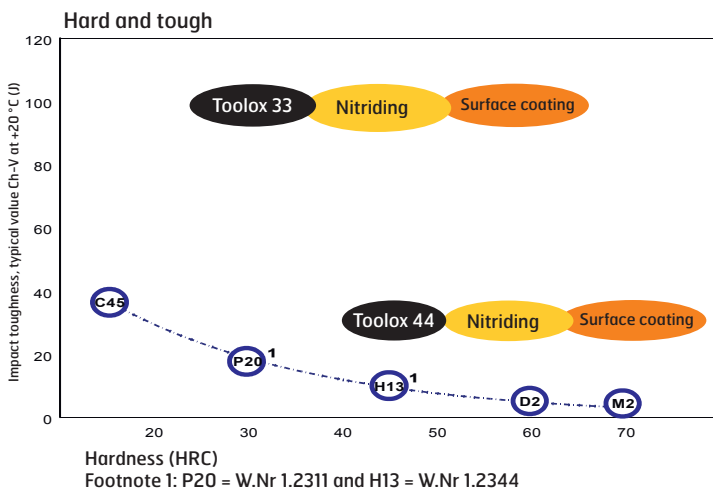
### Typical Values

CHEMICAL COMPOSITION		MECHANICAL PROPERTIES					
C	0.32%		+20 °C	+200 °C	+300 °C	+400 °C	+500 °C
Si	0.6-1.1%	Tensile strength, R <sub>m</sub> [MPa]	1450	1380			
Mn	0.8%	Yield strength, R <sub>p0.2</sub> [MPa]	1300	1200			
P	max 0.010%	Elongation, A <sub>5</sub> [%]	13	10			
S	max 0.003%	Compressive yield strength, R <sub>c0.2</sub> [MPa]					
Cr	1.35%	- after 170 h soaking time	1250	1120	1120	1060	930
Mo	0.80%	Impact toughness [J]	30	60	80	80	
V	0.14%	Hardness [HBW]	450				
Ni	max 1%	Hardness [HRC]	45				
CEIIW	0.92-0.96						
CET	0.55-0.57						

INCLUSIONS		PHYSICAL PROPERTIES			
Inclusion size (equiv. diam)	6 μm	+20 °C	+200 °C	+400 °C	
Area fraction	0.015%	Heat conductivity [W/m • K]	34	32	31
Aspect ratio	1.2	Thermal expansion coefficient, [10 <sup>-6</sup> /K]	13.5	13.5	13.5

### Surface technology



# Machining Toolox® 44

Toolox 44 can be machined using conventional machines. It is important that sharp tools are used, with a positive cutting angle and that vibration is avoided. Use the following recommendations as guidelines and the starting point for your own evaluation of best practice.

## Milling

### Cemented carbide cutter ISO class P 20

Always use a positive cutting angle

Cutting speed  $V_c = 100-150$  m/min

Feed  $f = 0.10-0.15$  mm/tooth

Speed (rpm)  $n = \frac{V_c \times 1000}{\pi \times D}$



### Roughing

Use milling cutters with circular inserts

### Finishing

Use milling cutters with a 45° setting angle



## Drilling

### Carbide

Cutting speed  $V_c = 30-40$  m/min

$f = 0.10-0.15$  mm/revolution

Feed (f) and speed (rpm) (n)

are dependent on the drill bit

diameter D

Use coolant



### High speed steel HSS-Co

Cutting speed  $V_c = 6-8$  m/min

Speed (rpm)

$n = \frac{V_c \times 1000}{\pi \times D}$

Use coolant



D [mm]	FEED, f [mm/rev]
5	0.05
10	0.09
15	0.15
20	0.20
25	0.25
30	0.30

## Threading

### Thread milling

Cutting speed  $V_c = 30$  m/min

Feed (f) = 0.03 mm/tooth



### Threading HSS-Co

Cutting speed

$V_c = 2.5-4$  m/min



DIMENSION	SPEED
M6	160
M8	120
M10	95
M12	80
M16	60
M20	50

## Gas cutting / Welding

Recommended preheat temperature when gas cutting and welding.

**Min. 250 °C**

Recommended stress relief annealing (after slow cooling to room temperature).

after gas cutting and welding.

**580 °C**

For further information see Best Practice or please contact SSAB Plate.

# Standard dimensions

## Toolox<sup>®</sup> 44

THICKNESS MM	WIDTH AND LENGTH
8 9,5 11,5 14 18 22 28 35 40 43 50 53 60 66 80 84	The standard width is 2100 mm and lengths between 4 and 5.8 m. Plates are delivered with mill edges. If necessary, the plates can be divided.
THICKNESS MM	WIDTH AND LENGTH
104 120 130	The standard width is 1700 mm and lengths between 4 and 5.8 m. Plates are delivered with mill edges. If necessary, the plates can be divided.
THICKNESS MM	WIDTH AND LENGTH
180 220 270 320	Forged bars in widths of 600 -1200 mm, dependent on thickness, and lengths of approximately 2.8 m. Please contact SSAB Plate or representatives for further information.

If you require smaller sizes than those offered in the stock list please contact your Approved Toolox Dealer.  
If larger formats are required, please contact SSAB Plate.

Toolox is the registered trademark for tool steels produced by SSAB Plate.  
For more information about Toolox 44, contact SSAB Plate.

**SSAB Oxelösund AB**  
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Sweden

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