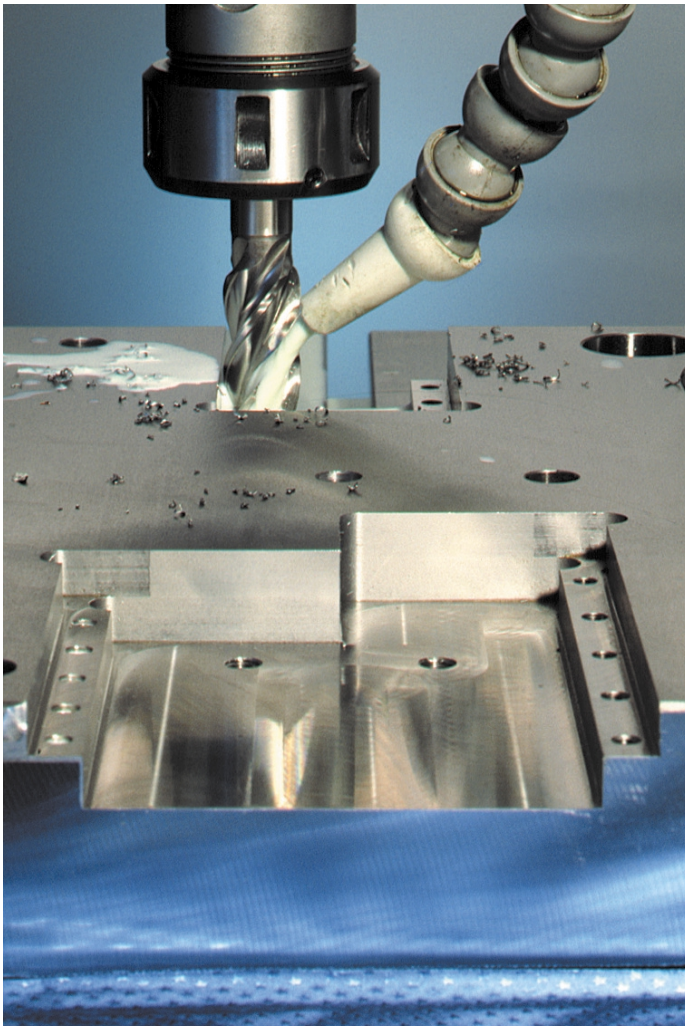
BÖHLER M315 EXTRA

BÖHLER EDELSTAHL

HARDENED AND TEMPERED CORROSION RESISTANT MOULD FRAME / BOLSTER STEEL.

BÖHLER M315 EXTRA is a corrosion resistant mould frame / bolster steel with improved machinability compared to 1.2085 steels.



PROPERTIES

- **excellent machinability**
- **good corrosion resistance**
- **hardened and tempered 1000 N/mm²**

APPLICATIONS

- **Mould frames and bolsters**
- **Frame superstructures**
- **Moulds requiring corrosion resistance and needing extensive machining**
- **Components**



CHEMICAL COMPOSITION

C	Si	Mn	Cr	S	Ni
0.05	0.20	0.90	12.80	0.12	+

(Average values, in wt%)

HEAT TREATMENT

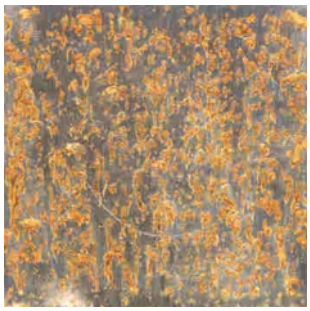
Since **BÖHLER M315 EXTRA** is supplied in the hardened and tempered condition (280 – 330 HB), no heat treatment is generally required. If necessary the steel can be supplied with a hardness of up to 350 HB (~ Rm = 1200 N/mm^2).

Stress relieving as necessary: at least 2 hours following temperature equalisation at max. 480°C.

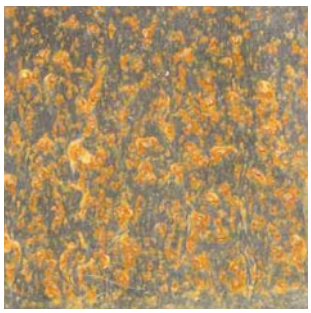
CORROSION RESISTANCE

Because of its optimised composition, **BÖHLER M315 EXTRA** is similarly corrosion resistant to 1.2085 grades.

Salt spray test according to DIN 50021:

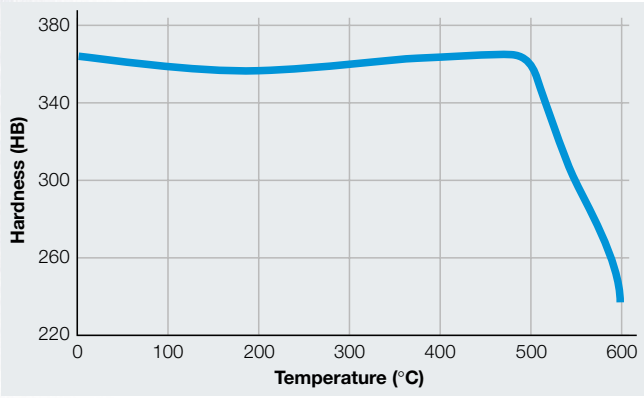


BÖHLER M315 EXTRA



1.2085

Tempering chart



Austenitising parameters:

Austenitising temperature: 1050°C

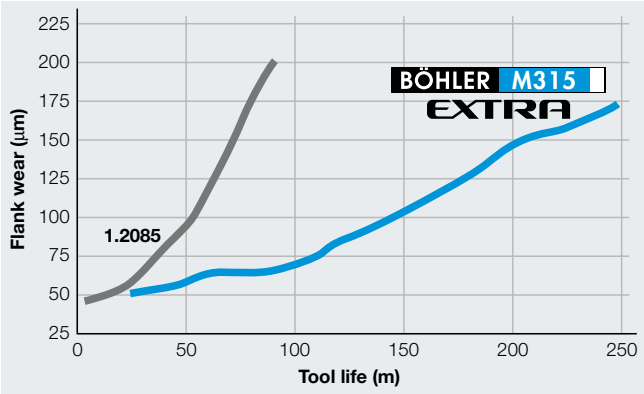
Holding time: 30 minutes following temperature equalisation

Quenching medium: oil

Tempering time: at least 2 x 2 hours

MACHINABILITY

The machinability was investigated in milling tests. The flank wear of the milling cutter was measured over the tool life.



Tests using solid carbide indexable inserts:

Cutting speed: 350 m/min.

Feed/tooth: 0.3 mm

Width of cut: 3 mm