



T1 HIGH-SPEED STEEL

COMPOSITION %	C	Cr	Mo	W	V
	0.75	4.10	< 0.8	18.0	1.10
STANDARDS	1.3355, ASIS: T1, S 18-0-1				

T1 is a high speed alloy steel on tungsten base with low susceptibility to hardening, high cutting power and good toughness.

APPLICATIONS

Machining of soft and medium-hard materials, as for instance steel, cast steel, grey cast iron and non-ferrous metals, milling cutters, twist drills, taps, reamers and broaches.

HEAT TREATMENT

Soft annealing		Cooling		Annealed hardness in HB	
770 - 840		Furnace		240 - 300	
1st pre-heating	2nd and 3rd pre-heating	Hardening from	In	Tempering	Hardness after tempering HRC
up to approx. 400°C in air circulating furnace	a) 850 b) 850 and 1050	1240°C to 1290°C	a) hot bath 550°C / air or b) oil c) air	min. two times 550°C - 570°C	63 - 66