

Uddeholm Orvar Supreme

Superior H13 ESR per NADCA 207 Grade B

	Vacuum	Salt Bath** / Fluidized Bed	Atmosphere Furnace Muffle Furnace / Packed												
Preheating Temperature	1. Bring up to 1200°F, equalize 2. Heat up to 1550°F, equalize	1. 800 – 900°F, equalize 2. 1100 – 1200°F, equalize 3. 1500 – 1600°F, equalize Step 1 only for big blocks (cross section above 6")	1. Bring up to 1200°F, equalize 2. Heat up to 1550°F, equalize												
Hardening Temperature (Austenitizing)	1850 – 1920°F (Normally 1885°F) Holding time after the tool or part has fully heated through at the hardening temperature: minimum 30 minutes, maximum 1 hour. Alternatively hold 20 minutes for first 1" and then 15 minutes for each additional inch of wall thickness.														
Quenching*	Alt. 1 Inert gas, positive pressure Alt. 2 Back-filled pressurized gas to 750-850°F, then equalize center and surface (maximum holding time 30 minutes). Continue forced cooling to 150°F.	Alt. 1 Quench in Salt 950-1050°F Alt. 2 Quench in oil 150°F until the die is black Alt. 3 Forced air circulation	Alt. 1 Oil 150°F until the part is black, then air cool Alt. 2 Circulated inert gas Alt. 3 Circulated air												
	*Cooling rate must be adequate to avoid any transformation products, with decreased properties as a result. However, also consider the risk of excessive distortion from very fast cooling. A minimum quench rate of 50°F/minute as measured at a depth of ~5/8" is recommended to optimize tool properties.														
Tempering (minimum two times) Temper immediately after quenching when the tool or part reaches 150°F	Hardening Temperature: 1885 °F <table border="1"> <thead> <tr> <th><u>Tempering Temperature</u></th> <th><u>Hardness</u></th> </tr> </thead> <tbody> <tr> <td>1020 °F</td> <td>48-52 HRC</td> </tr> <tr> <td>1050 °F</td> <td>46-50 HRC</td> </tr> <tr> <td>1080 °F</td> <td>44-48 HRC</td> </tr> <tr> <td>1110 °F</td> <td>42-46 HRC</td> </tr> <tr> <td>1140 °F</td> <td>40-44 HRC</td> </tr> </tbody> </table> Time: 1 hour per inch of wall thickness, or hold at temperature a minimum of 2 hours. Check hardness between tempers.			<u>Tempering Temperature</u>	<u>Hardness</u>	1020 °F	48-52 HRC	1050 °F	46-50 HRC	1080 °F	44-48 HRC	1110 °F	42-46 HRC	1140 °F	40-44 HRC
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Stress Temper performed on hardened tools after EDM, welding with QRO 90 or DIEVAR TIG Rods, or during preventative maintenance	Check hardness to confirm tool status. Temperature: Shall be 50°F below the lowest tempering temperature or 1020°F minimum, whichever is higher. Time: Soak 30 minutes per inch of maximum section with a minimum of 2 hours once tool comes to temperature. Cool in still air for simple shapes. For complex shapes furnace cool to 800°F, then air cool.														
Dimensional Stability	Average size change as a result of hardening and tempering may not exceed .005 inch/inch/maximum dimension if the tool has been stress relieved before finish machining. If stress relieving is not performed as recommended, dimensional stability may be inconsistent and cannot be guaranteed.														

Characteristics

- Isotropic mechanical properties – greater reliability in production
- Increased center toughness – less sensitivity in heat treatment
- Higher hardness level in use – improved tool life

This information 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. It is your responsibility to confirm you have the latest revision of this document (verify on our website) and that you forward to your Heat Treatment service provider. Failure to do so may result in inferior material properties. Revision Date: December 7, 2020