

Stellapur PM 60

Ultra Clean Powder Metallurgy Steel

Chemical composition

C	Cr	Mo	W	V	Co
2,30	4,2	7,0	6,5	6,5	10,5

Standards:

Europe HS 6-7-6-10
W.Nr. (1.3241)

Delivery hardness

Max 340 HB

Characteristics

Stellapur PM 60 is a very high alloyed grade able to reach hardness up to 70 HRC. The grade combines high wear resistance and high compressive strength like no other grades. In applications where cemented carbide tools are too brittle, Stellapur PM 60 can be an alternative.

Typical applications:

Gear cutting tools	Taps
Broaches	Drills
End mills	Cold work tools

Form supplied

Forging

Round	90 – 380 mm
Flat/square	Max width 450 mm Max thickness. 5- 40

mm

Rolling

Peeled	10 – 72 mm
Flat black	Width 20 -260 mm Thickness 5 – 55 mm

Profiles

On request

PM Block

400 x 500 x 2100 mm
400 x 500 x 1100 mm



Stellapur PM 60. High alloyed, easy to machine

Heat treatment

Soft annealing

Protective atmosphere 850 – 900°C followed by slow cooling at 10°C/h down to 700°C. After that, air cooling.

Stress-relieving

600 – 700°C for approximately 2 hours and slow cooling down to 500°C.

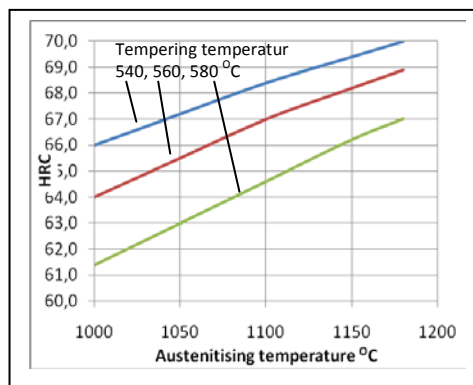
Hardening

Protective atmosphere with pre-heating in 2 steps at 400 – 500°C and 850 – 900°C and austenitizing at a temperature suitable for chosen hardness followed by rapid cooling down to 40 – 50°C

Tempering

560°C three times for at least 1 hour each time.

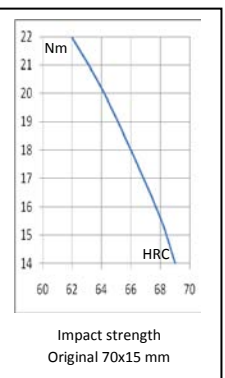
Cooling to room temperature (20-30°C) between tempering.



Austenitizing temperature

HRC	°C
61	960
63	980
64	1000
65	1030
66	1070
67	1100
68	1150
69	1180

Tempering
3 x at 560°C



Impact strength
Original 70x15 mm