



Product sheet:

# TOOLOX44<sup>®</sup>

## 45 HRC with ESR properties



November-07

## Specification

<b>Hardness</b>	HBW 410 - 475		
<b>Impact toughness</b>	Test temperature °C 20	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>Milling</b>	At a cutting speed of 140 m/min, feed 0.15 mm and 10 min effective machining time using Sandvik Coromill 200 and inserts GC 1025, we guarantee maximum edge wear of 0.3 mm.		
<b>Ultrasonic inspection</b>	All plates and forged bars tested in accordance with SSAB Standard V6.		
<b>Etching</b>	TOOLOX 44 fulfils the etching requirements of NADCA 207-2003.		
<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 Oxelösund AB 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>	Plate;	According to EN 10 029 - thickness tolerance according to Class C. - flatness tolerance according to Class N, steel type L.	
	Forged bars;	According to DIN 7527	
<b>Surface finish</b>	On delivery from SSAB Oxelösund AB the plate meets the following specifications: - free from mill scale - not repair welded - surface defects deeper than the nominal ordered thickness are not permitted. Forged bars according to DIN 7527		