Uddeholm Corrax®

Precipitation Hardening Stainless Mold Steel

Aging	Aging Temperature/Time*	Hardness
Hardness as a Function of Temperature, 4 hours at temperature		
Heat tool from cold furnace to minimize distortion	975°F (525°C)/4hr 1050°F (565°C)/4hr 1075°F (580°C)/4hr 1100°F (600°C)/4hr 1150°F (620°C)/4hr	49-51 HRC 45-47 HRC 43-45 HRC 39-42 HRC 33-35 HRC
*Holding time after the tool or part has fully heated through		

Thickness	Aging Time Once Tool Comes to Temperature
1-6”	4 hours
6-10”	6 hours**
>10”	8 hours**
**Hardness of surface and core will be 1-2 HRC points less than shown for 4 hour aging time.	

Dimensional Changes as a Function of Temperature, %				
Dimensional Changes	**Aging**	**Longitudinal**	**Transverse**	**Short Transverse**
As a function of temperature shrinkage will occur as shown, dependent on the aging temperature	975°F (525 C)/4h 1050°F (565 C)/4h 1075°F (580 C)/4h 1100°F (600 C)/4h 1150°F (620 C)/4h	-0.07 -0.08 -0.10 -0.14 -0.25	-0.07 -0.08 -0.10 -0.14 -0.25	-0.07 -0.08 -0.10 -0.14 -0.25

Characteristics

- Extremely high corrosion resistance: low maintenance costs
- Simple heat treatment, 33-50 HRC: great flexibility
- High toughness, excellent stability: long-life molds

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