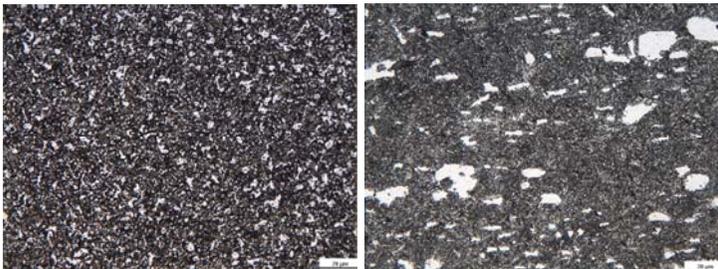


CPM S110V is a high alloy martensitic stainless tool steel produced by the Crucible Particle Metallurgy (CPM) process. CPM S110V contains a high volume fraction of both vanadium-rich and niobium-rich primary alloy carbides for exceptionally good wear resistance compared to other commercially available PM tool steels. It also offers better corrosion resistance than 440C or CPM S90V.

CPM S110V is currently only available on special request in the as-HIP condition or as a HIP-clad layer on components. It is not available in forged or rolled bar lengths.

The CPM process results in a fine and uniform carbide distribution in CPM S110V compared to conventionally produced high alloy tool steels which results in relatively good machining, grinding, and toughness characteristics despite the high alloy content.



CPM S110V

AISI 440C

## Typical Applications

As-HIP solid or HIP-clad components requiring a combination of high wear resistance and good corrosion resistance, such as:

- Screw elements, barrels and barrel liners for compounding machines
- Industrial knives, slitters and circular cutters
- Rolls and wear components for food and chemical processing applications

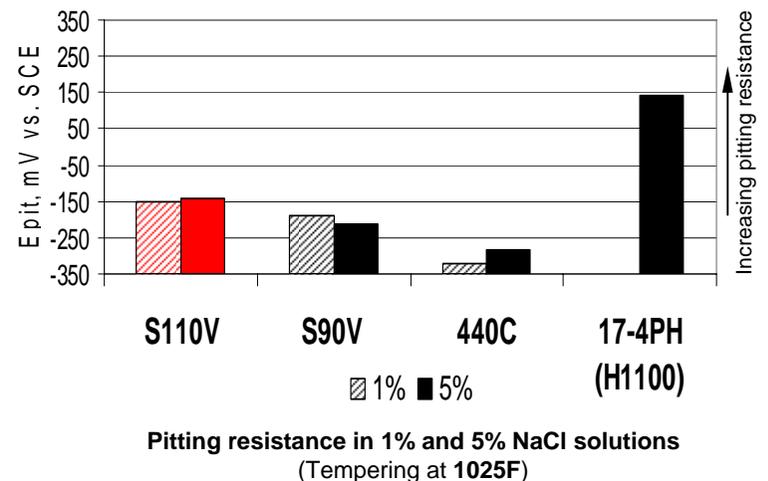
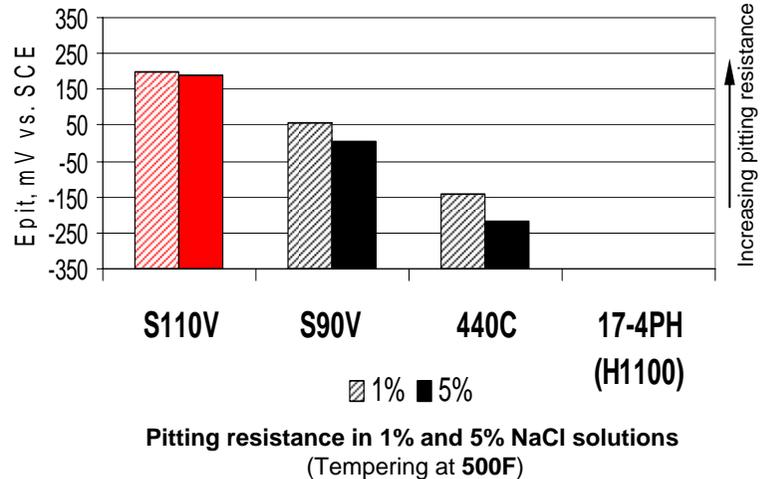
## Machining and Grinding

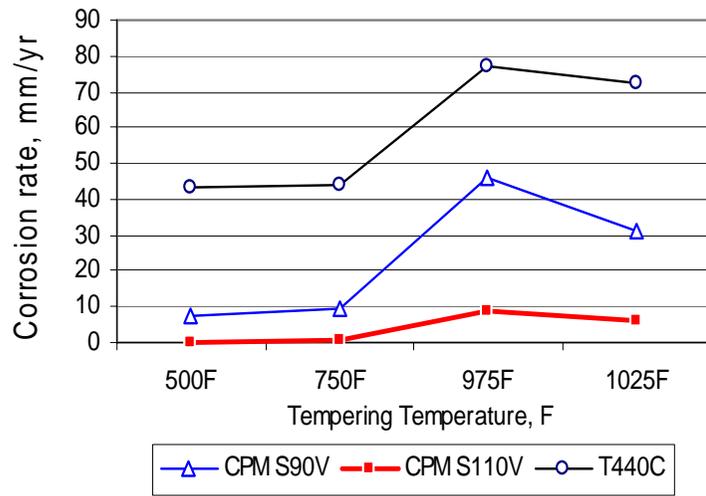
Due to its carbide content and high annealed hardness, machining and grinding CPM S110V will be more difficult than 440C (or D2), and comparable to or slightly more difficult than CPM S90V. Grinding equipment and practices similar to those used for CPM S90V are acceptable. SG type alumina wheels or CBN wheels are recommended for best performance with CPM steels

<b>Carbon</b>	<b>2.8%</b>
<b>Chromium</b>	<b>14.0%</b>
<b>Vanadium</b>	<b>9.0%</b>
<b>Niobium (Columbium)</b>	<b>3.5%</b>
<b>Molybdenum</b>	<b>3.5%</b>
<b>Cobalt</b>	<b>2.0%</b>

## Corrosion Resistance

CPM S110V displays enhanced corrosion resistance compared to other high hardness martensitic stainless tool steels such as 440C and CPM S90V. Corrosion tests results in representative media are illustrated by the following laboratory test data.

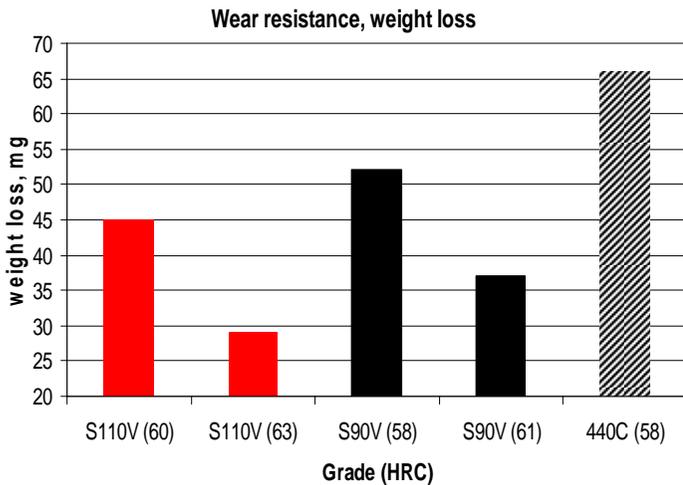




**Corrosion Rate in Dilute Aqua Regia**  
(2.5% HNO<sub>3</sub> + 0.5% HCl + H<sub>2</sub>O)

## Wear Resistance

CPM S110V features the same high vanadium content as CPM S90V, plus the added contribution of 3.5% niobium, resulting in 25% greater volume of wear-resistant carbides, including 50% more of the wear-resistant MC type. The abrasive wear resistance of CPM S110V at various hardnesses is compared to other wear- and corrosion-resistant grades below.



## Thermal Treatments

### Annealing

Heat to 1650°F (900°C), hold 2 hours, slow cool at a maximum rate of 25°F (15°C) per hour to 1100°F (595°C), then furnace cool or cool in still air to room temperature

**Annealed Hardness:** Approximately 350-400 BHN

### Stress Relieving

**Annealed Material:** Heat to 1100-1300°F (595-705°C), hold 2 hours, then furnace cool or cool in still air.

**Hardened Material:** Heat to 25-50°F (15-30°C) below original tempering temperature, hold 2 hours, then furnace cool or cool in still air.

## Thermal Treatments (cont'd.)

### Hardening

**Austenitize:** 2150°F (1175°C) Hold 20 minutes

**Quench:** Salt quench, interrupted oil quench, positive pressure gas quench or air cool at a minimum cooling rate of 250°F/min (140°C/min) to below 1000°F (540°C). Cool to below 125°F (50°C) before tempering. For optimum vacuum heat treatment response, a minimum 4 bar gas quench is recommended.

**Temper:** Temper three times, minimum hold time 2 hours at temperature each temper. Cool completely to room temperature between tempers.

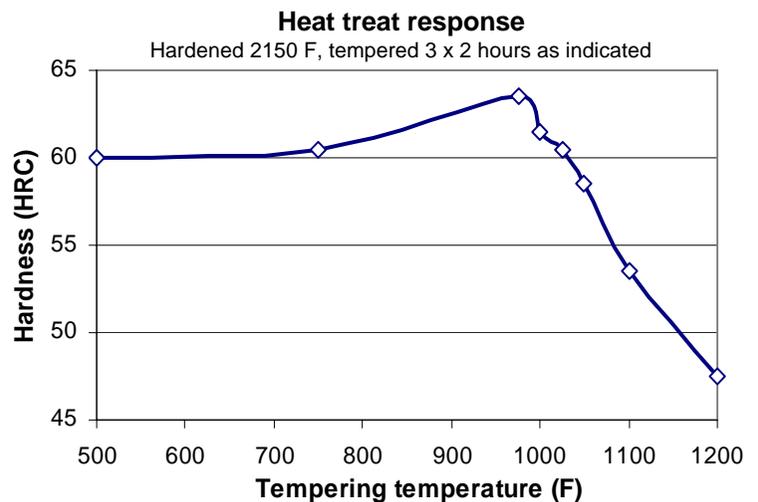
#### Tempering temperatures:

400-750°F (200-400°C): Best corrosion resistance

975-1000°F (525-540°C): Maximum hardness and compressive yield strength, reduced corrosion resistance

1025-1050°F (550-565°C): Optimum for best stress relieving and dimensional stability

*Note: Tempering any martensitic stainless steel above 750°F (400°C) may reduce its corrosion resistance.*

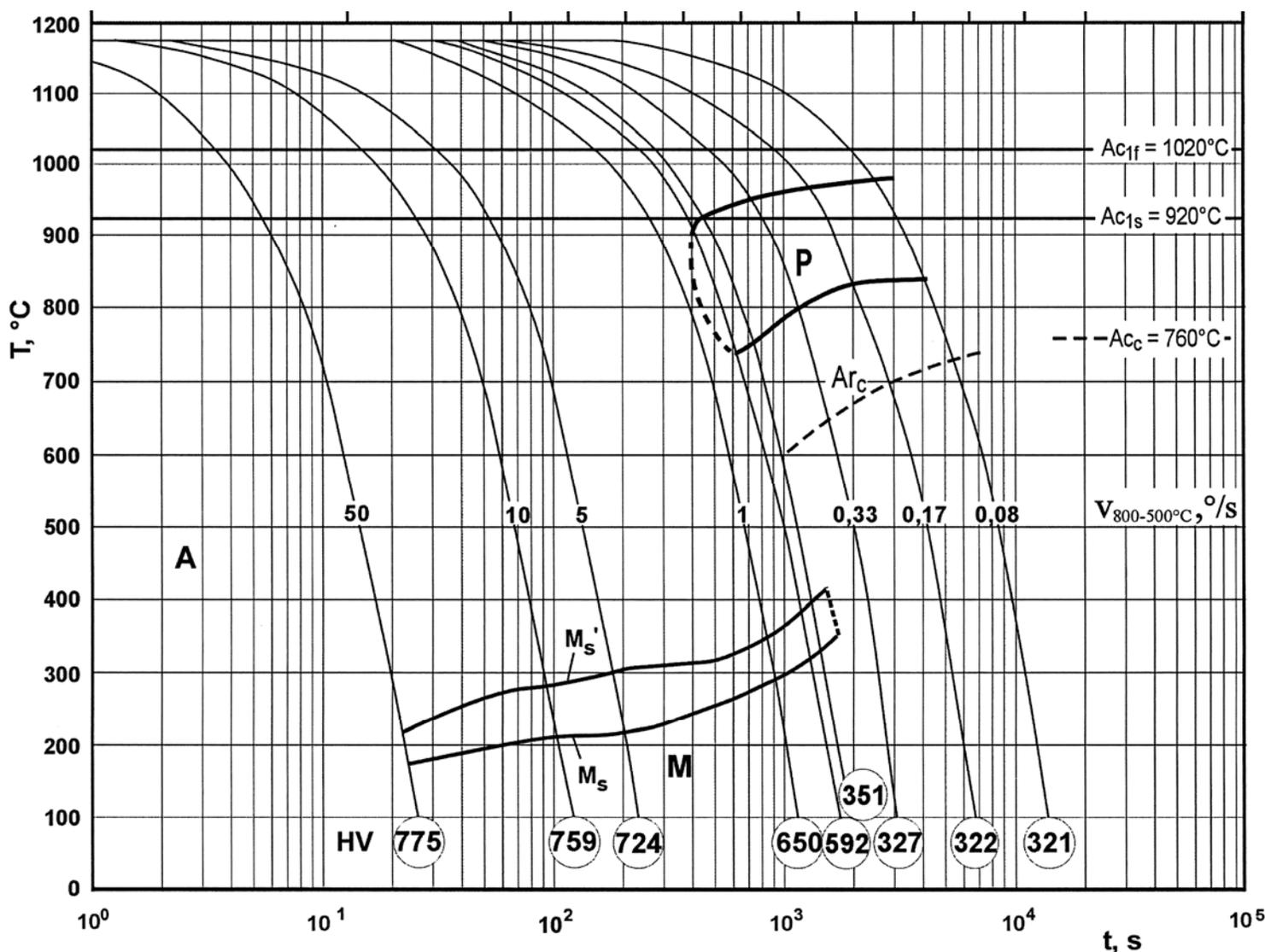


°F	500	750	975	1000	1025	1050	1100	1200
HRC	60	60.5	63.5	61.5	60.5	58.5	53.5	47.5

**Deep freezing (optional):** When tempering at or below 750°F (400°C), a freezing treatment may be used between the first and second tempers to reduce retained austenite and maximize hardness. Freezing treatments should always be followed by at least one temper.

**Size Change:** +0.03 to +0.05% for a fully martensitic microstructure. The presence of retained austenite may reduce the net growth.

**Typical Application Hardness:** 58/61 HRC



Continuous cooling diagram for CPM S110V, austenitized at 2150 F (1175 C)

Note: Properties shown throughout this data sheet are typical values. Normal variations in chemistry, size and heat treat conditions may cause deviations from these values. For additional data or metallurgical engineering assistance, consult your local Crucible Service Center.

Location	Phone	Toll Free	Fax	Location	Phone	Toll Free	Fax
<b>United States</b>				Grand Rapids, MI	616 554 9699	800 365 1137	616 554 9328
Auburn, MA	508 832 5353	800 365 1101	508 832 2217	Huntsville, AL	256 772 0201	800 365 1161	256 772 3361
Charlotte, NC	704 372 3073	800 365 1160	704 342 0985	Meadville, PA	814 337 8804	800 365 0530	814 337 8808
Chicago, IL	630 378 0093	800 365 1151	630 378 1965	Milwaukee, WI	262 781 6710	800 242 0948	262 781 6743
Cleveland, OH	216 573 0346	---	216 573 0414	Minneapolis, MN	612 331 5210	800 365 1153	612 331 4137
Dallas, TX	817 649 2800	800 365 1168	817 633 8142	St. Louis, MO	636 272 5730	877 201 4049	636 272 2861
Dayton, OH	937 885 8400	800 365 1163	937 885 5973	<b>Canada</b>			
Detroit, MI	248 528 0332	800 365 1133	248 528 1977	Blenheim, ONT	519 354 4420	800 265 5293	519 354 4401



**Divisional Headquarters**

Syracuse, NY 315 487 0800 800 365 1185 315 487 4028  
[www.crucibleservice.com](http://www.crucibleservice.com) [crucible@crucible.com](mailto:crucible@crucible.com)