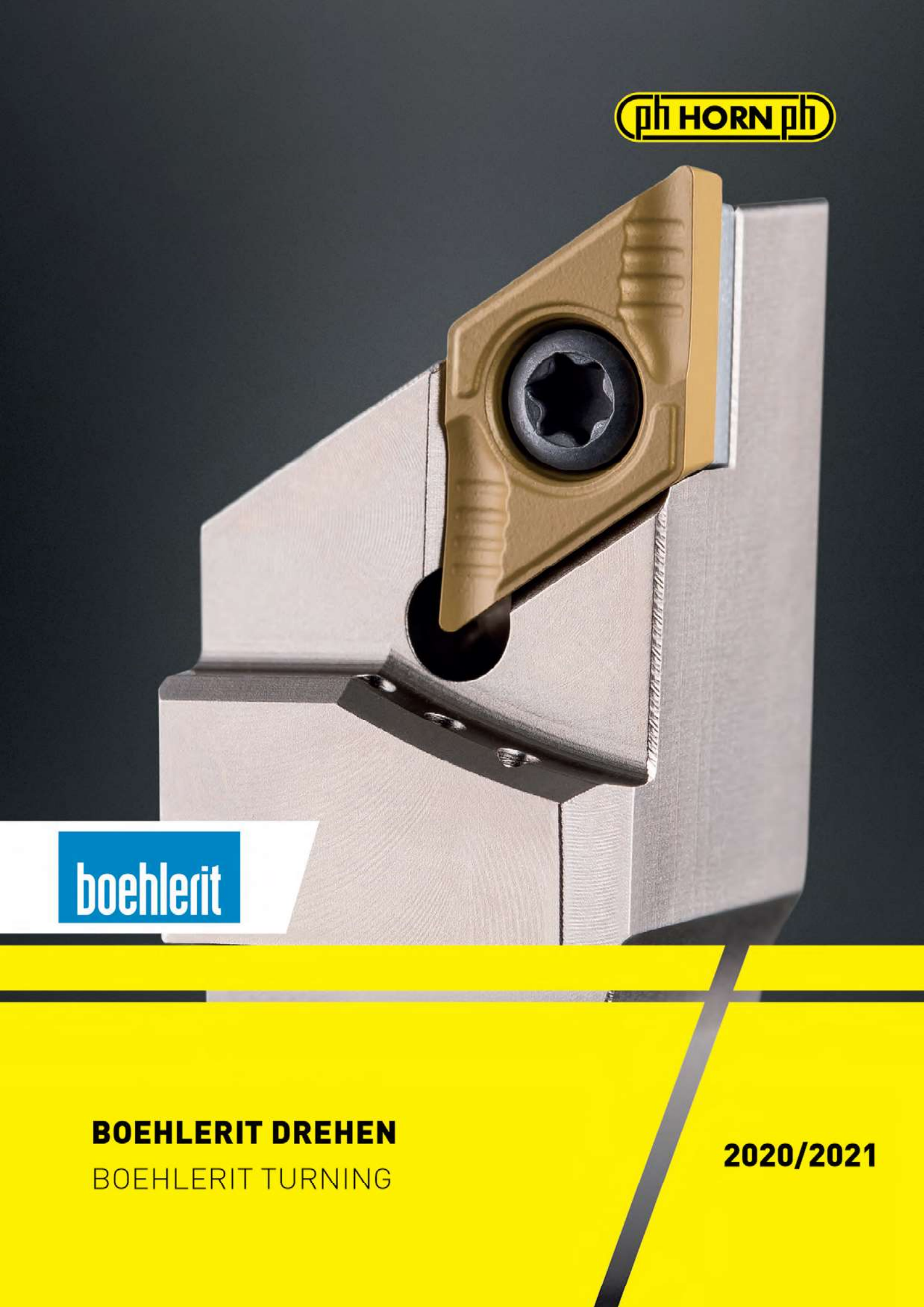

BOEHLERIT DREHEN

BOEHLERIT TURNING

2020/2021

DAS WERKZEUG
HORN TOOLS

boehlerit

Anhang
Attachment

Werkstückstoff - Vergleichstabelle
Comparison table of materials to be machined

Werkstoff-Gruppe Material group	Deutschland Germany		Großbritannien Great Britain		Frankreich France	Italien Italy
	W-Nr.	DIN	BS	EN	AFNOR	UNI
P	Baustahl und Konstruktionsstahl Constructional steels					
	1.0401	C15	080M15	-	CC12	C15C16
	1.0402	C22	050A20	2C	CC20	C20C21
	1.0501	C35	060A35	-	CC35	C35
	1.0503	C45	080M46	-	CC45	C45
	1.0535	C55	070M55	-	-	C55
	1.0601	C60	080A62	43D	CC55	C60
	1.0715	9SMn28	230M07	-	S250	CF9SMn28
	1.0718	9SMnPb28	-	-	S250Pb	CF9SMnPb28
	1.0722	10SPb20	-	-	10PbF2	CF10SPb20
	1.0726	35S20	212M36	8M	35MF4	-
	1.0736	9SMn36	240M07	1B	S300	CF9SMn36
	1.0737	9SMnPb36	-	-	S300Pb	CF9SMnPb36
	1.0904	55Si7	250A53	45	55S7	55Si8
	1.0961	60SiCr7	-	-	60SC7	60SiCr8
	1.1141	Ck15	080M15	32C	XC12	C16
	1.1157	40Mn4	150M36	15	35M5	-
	1.1158	Ck25	-	-	-	-
	1.1167	36Mn5	-	-	40M5	-
	1.1170	28Mn6	150M28	14A	20M5	C28Mn
	1.1183	Cf35	060A35	-	XC38TS	C36
	1.1191	Ck45	080M46	-	XC42	C45
	1.1203	Ck55	070M55	-	XC55	C50
	1.1213	Cf53	060A52	-	XC48TS	C53
	1.1221	Ck60	080A62	43D	XC60	C60
	1.1274	Ck101	060A96	-	-	-
	1.3401	X120Mn12	Z120M12	-	Z120M12	XG120Mn12
	1.3505	100Cr6	534A99	31	100C6	100Cr6
	1.5415	15Mo3	1501-240	-	15D3	16Mo3KW
	1.5423	16Mo5	1503-245-420	-	-	16Mo5
	1.5622	14Ni6	-	-	16N6	14Ni6
	1.5662	X8Ni9	1501-509;510	-	-	X10Ni9
	1.5680	12Ni19	-	-	Z18N5	-
	1.5710	36NiCr6	640A35	111A	35NC6	-
	1.5732	14NiCr10	-	-	14NC11	16NiCr11
	1.5752	14NiCr14	655M13;	36A	12NC15	-
			655A12			
	1.6511	36CrNiMo4	816M40	110	40NCD3	38NiCrMo4(KB)
	1.6523	21NiCrMo2	805M20	362	20NCD2	20NiCrMo2
	1.6546	40NiCrMo22	311-Type 7	-	-	40NiCrMo2(KB)
	1.6582	34CrNiMo6	817M40	24	35NCD6	35NiCrMo6(KB)
	1.6587	17CrNiMo6	820A16	-	18NCD6	-
	1.6657	14NiCrMo134	832M13	36C	-	15NiCrMo13
	1.7015	15Cr3	523M15	-	12C3	-
	1.7033	34Cr4	530A32	18B	32C4	34Cr4(KB)
	1.7035	41Cr4	530M40	18	42C4	41Cr4
	1.7045	42Cr4	-	-	-	-
	1.7131	16MnCr5	(527M20)	-	16MC5	16MnCr5
	1.7176	55Cr3	527A60	48	55C3	-
	1.7218	25CrMo4	1717CDS110	-	25CD4	25CrMo4(KB)
	1.7220	34CrMo4	708A37	19B	35CD4	35CrMo4
	1.7223	41CrMo4	708M40	19A	42CD4TS	41CrMo4
	1.7225	42CrMo4	708M40	19A	42CD4	42CrMo4

	Belgien Belgium	Schweden Sweden	Spanien Spain	USA U.S.A.
	NBN	SS	UNE	AISI/SAE
	-	1350	F.111	1015
	C25-1	1450	F.112	1020
	C35-1	1550	F.113	1035
	C45-1	1650	F.114	1045
	C55-1	1655	-	1055
	C60-1	-	-	1060
	-	1912	11SMn28	1213
	-	1914	11SMnPb28	12L13
	-	-	10SPb20	-
	-	1957	F210G	1140
	-	-	12SMn35	1215
	-	1926	12SMn35	12L14
	55Si7	2085	56Si7	9255
	60SiCr8	-	60SiCr8	9262
	C16-2	1370	C15K	1015
	-	-	-	1039
	C25-2	-	-	1025
	-	2120	36Mn5	1335
	28Mn6	-	-	1330
	C36	1572	-	1035
	C45-2	1672	C45K	1045
	C55-2	-	C55K	1055
	C53	1674	-	1050
	C60-2	1678	-	1060
	-	1870	-	1095
	-	-	XG120Mn12	-
	-	2258	F.131	52100
	16Mo3	2912	16Mo3	ASTM A204Gr.A
	16Mo5	-	16Mo5	4520
	18Ni6	-	15Ni6	ASTM A350LF5
	10Ni36	-	XBNi09	ASTM A353
	12Ni20	-	-	2515
	-	-	-	3135
	-	-	15NiCr11	3415
	13NiCr12	-	-	3415;3310
	-	-	35NiCrMo4	9840
	-	2506	20NiCrMo2	8620
	40NiCrMo2	-	40NiCrMo2	8740
	35CrNiMo6	2541	-	4340
	17CrNiMo7	-	14NiCrMo13	-
	14NiCrMo132	-	14NiCrMo131	-
	15Cr2	-	-	5015
	34Cr4	-	35Cr4	5132
	42Cr4	-	42Cr4	5140
	-	2245	42Cr4	5140
	16MnCr5	2511	16MnCr5	5115
	55Cr3	-	-	5155
	25CrMo4	2225	55Cr3	4130
			AM26CrMo4	
	34CrMo4	2234	34CrMo4	4137;4135
	41CrMo4	2244	42CrMo4	4140;4142
	42CrMo4	2244	42CrMo4	4140

Werkstückstoff - Vergleichstabelle
Comparison table of materials to be machined

Werkstoff-Gruppe Material group	Deutschland Germany		Großbritannien Great Britain		Frankreich France	Italien Italy
	W-Nr.	DIN	BS	EN	AFNOR	UNI
P	Baustahl und Konstruktionsstahl Constructional steels					
	1.7262	15CrMo5	-	-	12CD4	-
	1.7335	13CrMo4 4	1501-620Gr27	-	15CD3.5	14CrMo4 5
					15CD4.5	
	1.7361	32CrMo12	722M24	40B	30CD12	32CrMo12
	1.7380	10CrMo9 10	1501-622	-	12CD9,10	12CrMo9,10
			Gr.31;45	-	-	
	1.7715	14MoV6 3	1503-660-440	-	-	-
	1.8159	50CrV4	735A50	47	50CV4	50CrV4
	1.8509	41CrAlMo7	905M39	41B	40CAD6,12	41CrAlMo7
	1.8523	39CrMoV13 9	897M39	40C	-	36CrMoV12
	Werkzeugstähle Tool steels					
	1.1545	C105W1	-	-	Y1 105	C98KU
						C100KU
	1.1663	C125W	-	-	Y2 120	C120KU
	1.2067	100Cr6	BL3	-	Y100C6	-
	1.2080	X210Cr12	BD3	-	Z200C12	X210Cr13KU
						X250Cr12KU
	1.2344	X40CrMoV51	BH13	-	Z40CDV5	X35CrMoV05KU
						X40CrMoV511KU
	1.2363	X100CrMoV51	BA2	-	Z100CDV5	X100CrMoV51KU
	1.2419	105WCr6	-	-	105WC13	10WCr6
					107WCr5KU	
	1.2436	X210CrW12	-	-	-	X215CrW121KU
	1.2542	45WCrV7	BS1	-	-	45WCrV8KU
	1.2581	X30WCrV9 3	BH21	-	Z30WCV9	X28W09KU
		X30WCrV9 3KU				X30WCrV9 3KU
	1.2601	X165CrMoV12	-	-	-	X165CrMoW12KU
	1.2713	55NiCrMoV6	-	-	55NCDV7	-
	1.2833	100V1	BW2	-	Y1 105V	-
	Schnellarbeitsstähle High speed steels					
	1.3243	S 6-5-2-5	-	-	Z85WDKCV	HS 6-5-2-5
					06-05-04-02	
	1.3255	S 18-1-2-5	BT4	-	Z80WKCV	X78WCo1805KU
				-	18-05-04-01	
	1.3343	S 6-5-2	BM2	-	Z85WDCV	X82WMo0605KU
					06-05-04-02	
	1.3348	S 2-9-2	-	-	Z100WCWV	HS 2-9-2
					09-04-02-02	
	1.3355	S 18-0-1	BT1	-	Z80WCV	X75W18KU
					18-04-01	

	Belgien Belgium	Schweden Sweden	Spanien Spain	USA U.S.A.
	NBN	SS	UNE	AISI/SAE
	-	2216	12CrMo4	-
	14CrMo45	-	14CrMo45	ASTM A182
				F11;F12
	32CrMo12	2240	F.124.A	-
	-	2218	TU.H	ASTM A182
			-	F.22
	13MoCrV6	-	13MoCrV6	-
	50CrV4	2230	51CrV4	6150
	41CrAlMo7	2940	41CrAlMo7	-
	39CrMoV13	-	-	-
	-	1880	F.515	W.110
			F.516	
	-	-	(C120)	W.112
	-	-	100Cr6	L3
	-	-	X210Cr12	D3
	-	2242	X40CrMoV5	H13
	-	2260	X100CrMoV5	A2
	-	2140	105WCr5	-
	-	2312	X210CrW12	-
	-	2710	45WCrSi8	S1
	-	-	X30WCrV9	H21
	-			
	-	2310	X160CrMoV12	-
	-	-	F.520.S	L6
	C98KU	-	-	W210
	102V2KU			
	-	2723	HS 6-5-2-5	-
	-	-	HS 18-1-1-5	T4
	-	2722	HS 6-5-2	M2
	-	2782	HS 2-9-2	M7
	-	-	HS 18-0-1	T1

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	W-Nr.	DIN	BS	EN	AFNOR	UNI
	Rostfreie und warmfeste Stähle Stainless and heat resisting steels					
M	1.4000	X6Cr13	403S17	-	Z6C13	X6Cr13
	1.4001	X7Cr14				
	1.4006	X10Cr13	410S21	56A	Z10C14	X12Cr13
	1.4016	X6Cr17	430S15	60	Z8C17	X8Cr17
	1.4027	G-X200Cr14	420C29	56B	Z20C13M	-
	1.4034	X46Cr13	420S45	56D	Z40CM	X40Cr14
					Z38C13M	
	1.4057	X20CrNi172	431S29	57	Z15CNi6.02	X16CrNi16
	1.4104	X12CrMoS17	-	-	Z10CF17	X10CrS17
	1.4113	X6CrMo171	434S17	-	Z8CD17.01	X8CrMo17
	1.4313	X5CrNi134	425C11	-	Z4CND13.4M	-
	1.4408	G-X6CrNiMo1810	316C16	-	-	-
	1.4718	X45CrSi93	401S45	52	Z45Cs9	X45CrSi8
	1.4724	X10CrAl13	403S17	-	Z10C13	X10CrA112
	1.4742	X10CrAl18	430S15	60	Z10CAS18	X8Cr17
	1.4747	X80CrNiSi20	443505	59	Z80CSN20.02	X8CrSiNi20
	1.4762	X10CrAl24	-	-	Z10CAS24	X16Cr26
	1.4301	X5CrNi1810	304S15	58E	Z6CN18.09	X5CrNi1810
	1.4305	X10CrNiS189	303S21	58M	Z10CNF 18.09	X10CrNiS18.09
	1.4306	X2CrNi1911	304S12	-	Z2CN 18.10	X2CrNi18.11
			304C12		Z3CN 19.10	
	1.4308	G-X6CrNi18 9	304C15	-	Z6CN18.10M	-
	1.4310	X12CrNi177	-	-	Z12CN17.07	X12CrNi1707
	1.4311	X2CrNiN1810	304S26	-	Z2CN18.10	-
	1.4401	X5CrNiMo17122	316S16	58J	Z6CND17.11	X5CrNiMo1712
	1.4429	X2CrNiMoN17133	-	-	Z2CND17.13	-
	1.4435	X2CrNiMo18143	316S12	-	Z2CND17.13	X2CrNiMo1713
	1.4438	X2CrNiMo17133	317S12	-	Z2CND1915	X2CrNiMo1816
	1.4460	X8CrNiMo275	-	-	-	-
	1.4541	X6CrNiTi1810	2337	312S12	Z6CNT18.10	X6CrNiTi1811
	1.4550	X6CrNiNb1810	347S17	58F	Z6CNNb18.10	X6CrNiNb1811
	1.4571	X6CrNiMoTi17122	320S17	58J	Z6NDT17.12	X6CrNiMoTi1712
	1.4581	G-X5CrNi	318C17	-	Z4CNDNb	XG8CrNiMo1811
		MoNb1810			18 12M	
	1.4583	X10CrNi	-	-	Z6CNDNb	X6CrNiMoNb1713
		MoNb1812			17 13B	
	1.4828	X15CrNiSi2012	309S24	-	Z15CNS20.12	-
	1.4845	X12CrNi25 21	310S24	-	Z12CN2520	X6CrNi2520
	1.4864	X12NiCrSi3616	-	-	Z12NCS35.16	-
	1.4865	G-X40NiCrSi3818	330C11	-	-	XG50NiCr3919
	1.4871	X53CrMnNiN219	349S54	-	Z52CMN21.09	X53CrMnNiN219
			321S12	58B		
	1.4878	X12CrNiTi189	321S20	58C	Z6CNT18.12B	X6CrNiTi1811

	Belgien Belgium	Schweden Sweden	Spanien Spain	USA U.S.A.
	NBN	SS	UNE	AISI/SAE
	-	2301	F.3110	403
			F.8401	
	-	2302	F.3401	410
	-	2320	F.3113	430
	-	-	-	-
	-	2304	F.3405	-
	-	2321	F.3427	431
	-	2383	F.3117	430F
	-	2325	-	434
	-	-	-	-
		F.8414		
		-	F.322	HW3
	-	-	F.311	405
	-	-	F.3113	430
		-	F.320B	HNV6
	-	2322	-	446
	-	2332	F.3551	304
			F.3541	
			F.3504	
	-	2346	F.3508	303
	-	2352	F.3503	304L
		2333		
	-	-	-	-
	-	2331	F.3517	301
	-	2371	-	304LN
	-	2347	F.3543	316
	-	2375	-	316LN
	-	2353	-	316L
	-	2367	-	317L
	-	2324	-	329
	-	58B	F.3553, F.3523	321
	-	2338	F.3552, F.3524	347
	-	2350	F.3535	316Ti
	-	-	-	-
	-	-	-	318
	-			
	-	-	-	309
	-	2361	F.331	310S
	-	-	-	330
	-	-	-	-
	-	-	-	EV8
	-	-	F.3523	321

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Comparison table of materials to be machined

Werkstoff-Gruppe Material group	Deutschland Germany		Großbritannien Great Britain		Frankreich France	Italien Italy	
	W-Nr.	DIN	BS	EN	AFNOR	UNI	
K	Grauguss (unlegiert) Unalloyed grey cast iron						
		GG 10			Ft 10 D		
		GG 15	Grade 150		Ft 15 D		
		GG 20	Grade 220		Ft 20 D		
		GG 25	Grade 260		Ft 25 D		
		GG 30	Grade 300		R 30 D		
		GG 35	Grade 350		Ft 35 D		
		GG 40	Grade 400		Ft 40 D		
	Grauguss (legiert) Alloyed grey cast iron						
		DIN4694	3468; 1974				
		GGL-			A32-301		
		NiCr 20 2	L-NiCr 20 2		L-NC 20 2		
	Kugelgraphitguss Unalloyed nodular cast						
			2789; 1973		NF A32-201		
		GGG 40	SNG 420/12		FCS 400-12		
		GGG 40.3	SNG 370/17		FGS 370-17		
		GGG 35.3	-		-		
		GGG 50	SNG 500/7		FGS 500-7		
		GGG 60	SNG 600/3		FGS 600-3		
		GGG 70	SNG 700/2		FGS 700-2		
	Legierter Guss Alloyed cast steels						
		DIN 1694					
		GGG NiMn 13 7	L-NiMn 13 7		L-NM 13 7		
		GGG NiCr 20 2	L-NiMn 20 2		L-NC 20 2		
	Temperguss Malleable cast iron						
		-	8 290/6		MN 32-8		
		GTS-35	B 340/12		MN 35-10		
		GTS-45	P 440/7				
		GTS-55	P 510/4		MP 50-5		
		GTS-65	P 570/3		MP 60-3		
		GTS-70	P 690/2		IP 70-2		

	Belgien Belgium	Schweden Sweden	Spanien Spain	USA U.S.A.
	NBN	SS	UNE	AISI/SAE
				ASTM A48-76
		01 00		
		01 10		No 20 B
		01 15		No 25 B
		01 20		No 30 B
		01 25		No 35 B
				No 40 B
		01 30		No 45 B
		01 35		No 50 B
		01 40		No 55 B
		MB		ASTM
		ISO-215		A436-72
		05 23		Type 2
				A536-72
		07 17-02		60-40-18
		07 17-12		-
		07 17-15		-
		07 27-02		80-55-06
		07 32-03		-
		07 37-01		100-70-03
		07 72		-
		07 76		Type 2
				ASTM A47-74
				A 220-762)
		08 14		
		08 15		32510
		08 52		40010
		08 54		50005
		08 58		70003
		08 62		(002)