

DILLIDUR 325 L

Air hardened wear resistant steel

Material data sheet, edition January 2024¹

DILLIDUR 325 L is successfully applied by the customers where high resistance to wear is required together with good weldability and good machinability, especially if heat treatment or hot forming is provided.

Examples of application are loading machines, dredgers, skip cars, conveying plants, trucks, cutting edges, knives and breakers.

In spite of their high tensile properties, DILLIDUR steels are not intended for safety relevant components. For this purpose, high strength steels DILLIMAX are available.

Product description

Designation and range of application

DILLIDUR 325 L can be delivered in thicknesses from 6 mm to 100 mm ($\frac{1}{4}$ in. to 4 in.)² according to the dimensional program. It may be possible to supply other dimensions on request.

Chemical composition

For the ladle analysis, the following limiting values in % are applicable:

C max.	Si	Mn	P max.	S max.	Mo max.	Ni max.	Cu max.	Cr	Nb + V + Ti max.
0.23	0.30 - 0.70	1.2 - 1.7	0.025	0.005	0.50	0.60	0.60	1.0 - 1.6	0.20

The steel is fully killed and fine grain treated.

Delivery condition

The plates are delivered normalized or in an equivalent condition obtained by normalizing rolling (short designation in the certificate for both delivery conditions: N). Depending on the thickness, a complementary tempering treatment may be performed.

¹ The current version of this material data sheet can be also found on www.dillinger.de.

² The approximately converted values in brackets are for information only.

Mechanical properties in the delivery condition

Plate thickness t [mm] (in.) ^a	Brinell surface hardness at room temperature [HBW]
t ≤ 15 (0.6)	≥ 280
15 (0.6) < t ≤ 25 (1)	≥ 260
25 (1) < t ≤ 100 (4)	≥ 240

^a The approximately converted values in brackets are for information only.

Indicative values for 10 mm plate thickness

Hardness 325 HBW

Impact energy: Charpy-V longitudinal specimens: 20 J (15 ft·lbf) at -20 °C (-4 °F)³

Testing

Brinell hardness testing acc. to EN ISO 6506-01 or Leeb hardness testing acc. to EN ISO 16859-01 on a ground surface in general 0.5 mm - 2.0 mm below the sheet surface.

Brinell surface hardness tested once per heat and 40 t.

Unless otherwise agreed, the test results are documented in an inspection certificate 3.1 in accordance with EN 10204.

Identification

Unless otherwise agreed the marking is carried out via steel stamps with at least the following information:

- steel grade (DILLIDUR 325 L)
- heat number
- number of mother plate and individual plate
- the manufacturer's symbol
- inspector's sign

Processing

The entire processing and application techniques are of fundamental importance to the reliability of the products made from this steel. The user should ensure that his design, construction and processing methods are aligned with the material, correspond to the state of the art that the fabricator has to comply with and are suitable for the intended use. The customer is responsible for the selection of the material. The recommendations in accordance with EN 1011-2 (Welding) and CEN/TR 10347 (Forming) as well as recommendations regarding job safety in accordance with national rules should be observed while considering the higher strength and hardenability.

The steel can be heated to about 500 °C (932 °F) without any substantial drop in hardness.

For further processing recommendations, please refer to the corresponding processing information.

³ The approximately converted values in brackets are for information only.

General technical delivery requirements

Unless otherwise agreed, the general technical requirements in accordance with EN 10021 are applicable.

Tolerances

Unless otherwise agreed, the tolerances are in accordance with EN 10029, with class A for thickness.

Surface quality

Unless otherwise agreed, the provisions in accordance with EN 10163-2, class A2 are applicable.

General note

If special requirements, which are not covered in this material data sheet, are to be met by the steel due to its intended use or processing, these requirements are to be agreed before placing the order.

The information in this data sheet is a product description. This data sheet is updated at irregular intervals. The current version is relevant. The latest version is available from the mill or as download at www.dillinger.de.

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