



This information is based on our present state of knowledge and is intended to provide general notes on our products and their uses. It should not therefore be construed as a warranty of specific properties of the products described or a warranty for fitness for a particular purpose.

Classified according to EU Directive 1999/45/EC  
For further information see our "Material Safety Data Sheets".

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The latest revised edition of this brochure is the English version,  
which is always published on our web site [www.uddeholm.com](http://www.uddeholm.com)



SS-EN ISO 9001  
SS-EN ISO 14001

## Applications

Vanadis 30 is a cobalt alloyed high performance PM high speed steel. The cobalt addition of approx. 8,5% has a positive influence on the hot strength/hot hardness, temper resistance and modulus of elasticity. The presence of cobalt has little influence on wear resistance. As cobalt does not form carbides, the wear resistance of Vanadis 30 is more or less the same as for steels with the same base analysis but without cobalt (e.g. Vanadis 23). On the other hand, its presence reduces the toughness and hardenability somewhat but increases compressive strength and high temperature properties.

### FOR COLD WORK

- The combination of high wear resistance and unusually good compressive strength can be put to use in tooling for heavy forming operations.
- In some cold work operations, the active surface (e.g. cutting edge or forming surface) of a tool can reach temperatures in excess of 200°C (390°F). Such conditions can be found in tooling running on high speed presses. Also, development of high temperatures in the tooling can be expected in heavy forming operations.

## General

Vanadis 30 is a W-Mo-V-Co alloyed PM high speed steel characterized by:

- High wear resistance
- High compressive strength at high hardness
- Good through hardening properties
- Good toughness
- Good dimensional stability on heat treatment
- Good grindability and machinability
- Very good temper resistance.

Typical analysis %	C 1,28	Cr 4,2	Mo 5,0	W 6,4	V 3,1	Co 8,5
Standard specification	(W.-Nr. 1.3207) AISI M2+Co					
Delivery condition	Soft annealed, max. 300 HB Drawn, max. 320 HB					
Colour code	Dark green					

*Punches for high performance.  
A suitable application for Vanadis 30.*

## Properties

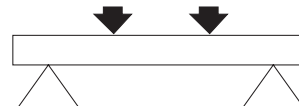
### PHYSICAL DATA

Temperature		20°C (68°F)	400°C (750°F)	600°C (1112°F)
Density, kg/m <sup>3</sup> (1) lbs/in <sup>3</sup> (1)		8040 0,287	7935 0,285	7880 0,284
Modulus of elasticity MPa (2) ksi (2)		240 000 34 x 10 <sup>3</sup>	214 000 31 x 10 <sup>3</sup>	192 000 28 x 10 <sup>3</sup>
Coefficient of thermal expansion per °C from 20°C (2) °F from 68°F (2)		— —	11,8 x 10 <sup>-6</sup> 6,5 x 10 <sup>-6</sup>	12,3 x 10 <sup>-6</sup> 6,8 x 10 <sup>-6</sup>
Thermal conductivity W/m•°C (2) Btu in/(ft <sup>2</sup> h•°F) (2)		22 152	26 180	25 173
Specific heat J/kg °C (2) Btu/lb °F (2)		420 0,10	510 0,12	600 0,14

(1) = for the soft annealed condition.

(2) = for the hardened and tempered condition.

### BEND STRENGTH AND DEFLECTION



Four-point bend testing.

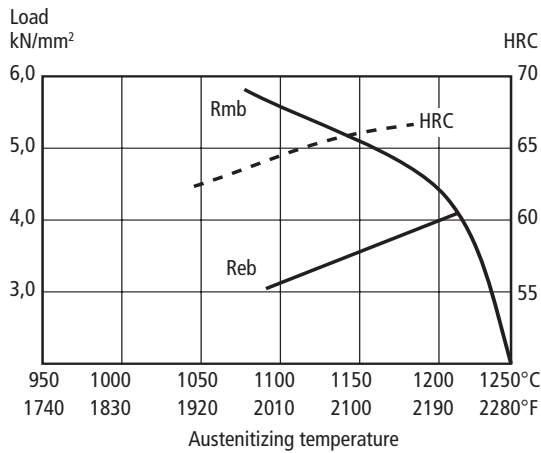
*Specimen size:* 5 mm (0,2") Ø.

*Loading rate:* 5 mm/min (0,2"/min.).

*Austenitizing temperature:* 1050–1180°C (1920–2160°F).

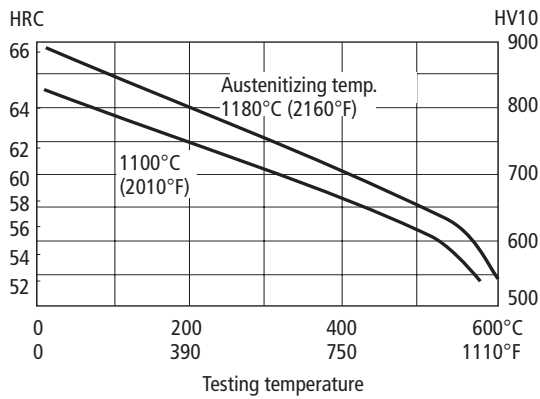
*Tempering:* 3 x 1 h at 560°C (1040°F), air cooling to room temperature.





**HIGH TEMPERATURE PROPERTIES**

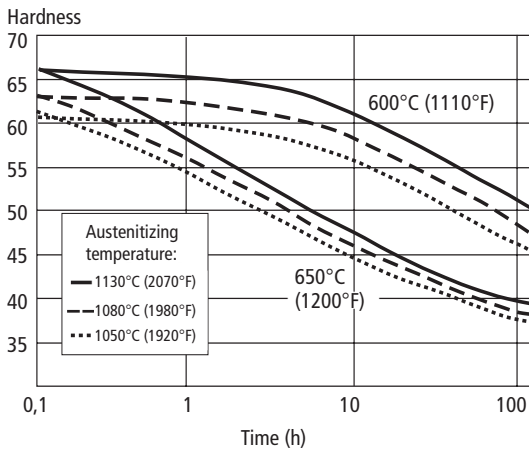
*Vanadis 30 hot hardness*



*Change in hardness versus holding time for different working temperatures*

Austenitizing temperature: 1050–1130°C (1920–2070°F).

Tempering: 3 x 1 h at 560°C (1040°F).



**Heat treatment**

**SOFT ANNEALING**

Protect the steel and heat through to 850–900°C (1560–1650°F). Then cool in the furnace at 10°C/h (20°F/h) to 700°C (1290°F), then freely in air.

**STRESS RELIEVING**

After rough machining the tool should be heated through to 600–700°C (1110–1290°F), holding time 2 hours. Cool slowly to 500°C (930°F), then freely in air.

**HARDENING**

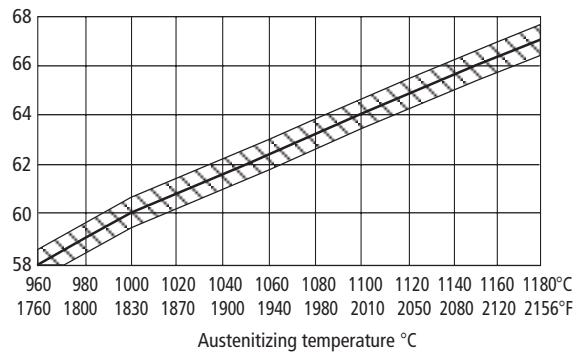
*Pre-heating temperature:* 450–500°C (840–930°F) and 850–900°C (1560–1650°F).

*Austenitizing temperature:* 1050–1180°C (1920–2160°F), according to the desired final hardness, see diagram below.

The tool should be protected against decarburization and oxidation during hardening.

*Hardness after tempering 3 times for one hour at 560°C (1040°F)*

Final hardness HRC

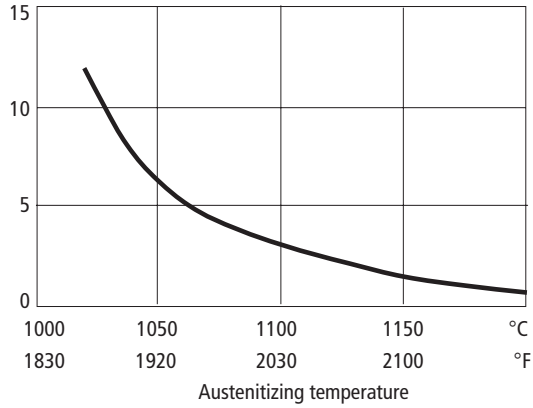


*Hardness for different austenitizing temperatures after tempering 3 times for one hour at 560°C (± 1 HRC)*

HRC	°C	°F
60	1000	1832
62	1050	1922
64	1100	2012
66	1150	2102
67	1180	2156

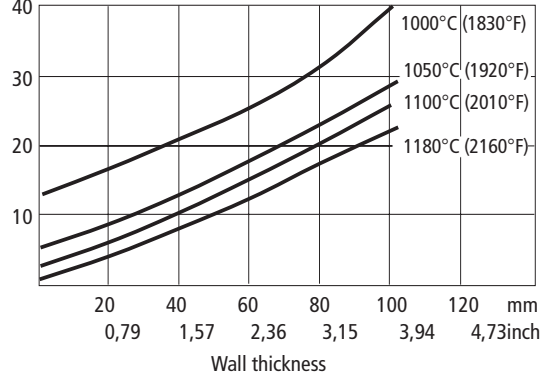
*Recommended holding time*

Holding time\* min.



*Total soaking time in a salt bath after pre-heating in two stages at 450°C (840°F) and 850°C (1560°F)*

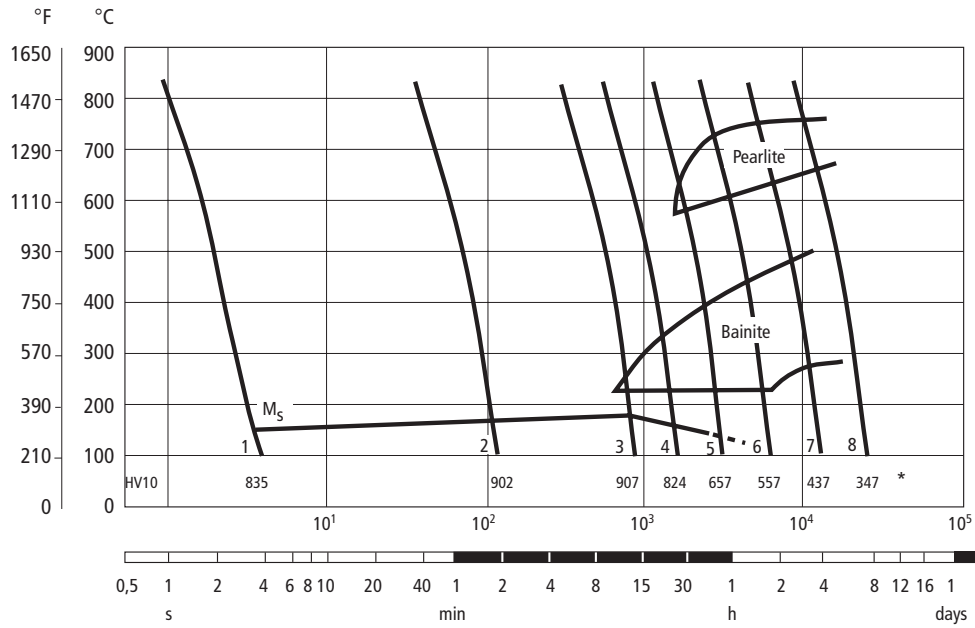
Holding time, min.



\* Holding time = time at austenitizing temperature after the tool is fully heated through.

*CCT-graph (continuous cooling)*

Austenitizing temperature 1180°C (2160°F).



## QUENCHING MEDIA

- Martempering bath at approx. 540°C (1004°F)
- Vacuum furnace with high speed gas at sufficient overpressure.

*Note. 1:* Quenching should be continued until the temperature of the tool reaches approx. 50°C (122°F). The tool should then be tempered immediately.

*Note. 2:* In order to obtain a high toughness, the cooling speed in the core should be at least 10°C/sec. (20°F/sec.). This is valid for cooling from the austenitizing temperature down to approx. 540°C (1004°F). After temperature equalization between the surface and core, the cooling rate of approx. 5°C/sec. (10°F/sec.) can be used. The above cooling cycle results in less distortion and residual stresses.

## TEMPERING

Tempering should always be carried out at 560°C (1040°F) irrespective of the austenitizing temperature. Temper three times for one hour at full temperature. The tool should be cooled to room temperature between the tempers. The retained austenite content will be less than 1% after this tempering cycle.

## DIMENSIONAL CHANGES

Dimensional changes after hardening and tempering.

*Heat treatment:* austenitizing between 1050–1140°C (1920–2080°F) and tempering 3 x 1h at 560°C (1040°F).

*Specimen size:* 80 x 80 x 80 mm (2,91 x 2,91 x 2,91 in.) and 100 x 100 x 25 mm (3,94 x 3,94 x 0,99 in.).

*Dimensional changes:* growth in length, width and thickness: +0,03% to +0,13%.

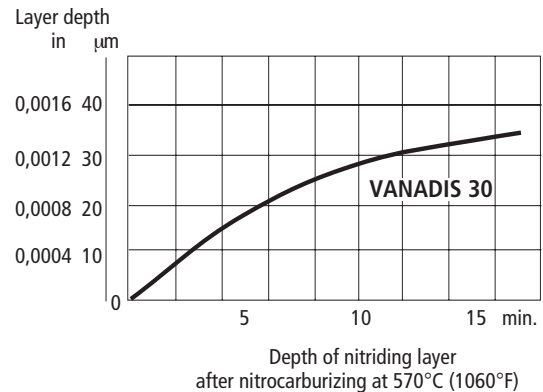
## Surface treatments

Some tools are given a surface treatment in order to reduce friction and increase tool wear resistance. The most commonly used treatments are nitriding and surface coating with wear resistant layers of titanium carbide and titanium nitride (CVD, PVD).

Vanadis 30 has been found to be particularly suitable for titanium carbide and titanium nitride coatings. The uniform carbide distribution in Vanadis 30 facilitates bonding of the coating and reduces the spread of dimensional changes resulting from hardening. This, together with its high strength and toughness, makes Vanadis 30 an ideal substrate for high-wear surface coatings.

## NITRIDING

A brief immersion in a special salt bath to produce a nitrided diffusion zone of 2–20 µm is recommended. This reduces friction on the envelope surface of punches and has various other advantages.



## PVD

Physical vapour deposition, PVD, is a method of applying a wear-resistant coating at temperatures between 200–500°C (390–930°F). As Vanadis 30 is high temperature tempered at 560°C (1040°F), there is no danger of dimensional changes during PVD coating.

## CVD

Chemical vapour deposition, CVD, is used for applying wear resistant surface coatings at a temperature of around 1000°C (1830°F). It is recommended that the tools should be separately hardened and tempered in a vacuum furnace after surface treatment.

## Cutting data recommendations

The cutting data below are to be considered as guiding values which must be adapted to existing local conditions. More information can be found in the Uddeholm publication "Cutting data recommendations"

**Condition: Soft annealed to approx. 300 HB**

### TURNING

Cutting data parameters	Turning with carbide		Turning with HSS Fine turning
	Rough turning	Fine turning	
Cutting speed ( $v_c$ ) m/min f.p.m.	80–110 262–361	110–140 361–459	10–15 33–49
Feed ( $f$ ) mm/r i.p.r.	0,2–0,4 0,008–0,016	0,05–0,2 0,002–0,008	0,05–0,3 0,002–0,012
Depth of cut ( $a_p$ ) mm inch	2–4 0,08–0,16	0,5–2 0,02–0,08	0,5–3 0,02–0,12
Carbide designation ISO	K20, P10–P20 Coated carbide*	K15, P10 Coated carbide*	–

\* Use a wear resistant CVD-coated carbide grade

### DRILLING

#### High speed steel twist drill

Drill diameter		Cutting speed $v_c$		Feed $f$	
mm	inch	m/min.	f.p.m.	mm/r	i.p.r.
– 5	–3/16	8–10*	27–33*	0,05–0,15	0,002–0,006
5–10	3/16–3/8	8–10*	27–33*	0,15–0,20	0,006–0,008
10–15	3/8–5/8	8–10*	27–33*	0,20–0,25	0,008–0,010
15–20	5/8–3/4	8–10*	27–33*	0,25–0,35	0,010–0,014

For coated HSS drill  $v_c = 14–16$  m/min. (46–52 f.p.m.)

#### Carbide drill

Cutting data parameters	Type of drill		
	Indexable insert	Solid carbide	Brazed carbide <sup>1)</sup>
Cutting speed, $v_c$ m/min f.p.m.	100–130 328–435	50–70 164–230	25–35 82–115
Feed, $f$ mm/r i.p.r.	0,05–0,15 <sup>2)</sup> 0,002–0,006 <sup>2)</sup>	0,10–0,25 <sup>2)</sup> 0,004–0,010 <sup>2)</sup>	0,15–0,25 <sup>2)</sup> 0,006–0,010 <sup>2)</sup>

<sup>1)</sup> Drill with internal cooling channels and brazed tip.

<sup>2)</sup> Depending on drill diameter.

### MILLING

#### Face and square shoulder milling

Cutting data parameters	Milling with carbide	
	Rough milling	Fine milling
Cutting speed ( $v_c$ ) m/min f.p.m.	40–80 131–265	80–110 265–361
Feed ( $f_z$ ) mm/tooth inch/tooth	0,2–0,4 0,008–0,016	0,1–0,2 0,004–0,008
Depth of cut ( $a_p$ ) mm inch	2–4 0,08–0,16	–2 –0,08
Carbide designation ISO	K20–P20 Coated carbide*	K15–P15 Coated carbide* or cermet

\* Use a wear resistant CVD-coated carbide grade

#### End milling

Cutting data parameters	Type of mill		
	Solid carbide	Carbide indexable insert	High <sup>2)</sup> speed steel
Cutting speed ( $v_c$ ) m/min f.p.m.	35–45 115–150	70–90 230–300	12–16 39–52
Feed ( $f_z$ ) mm/tooth inch/tooth	0,01–0,2 <sup>1)</sup> 0,0004–0,008 <sup>1)</sup>	0,06–0,2 <sup>1)</sup> 0,002–0,008 <sup>1)</sup>	0,01–0,3 <sup>1)</sup> 0,0004–0,012 <sup>1)</sup>
Carbide designation ISO	–	K15, P10–P20 Coated carbide <sup>3)</sup>	–

<sup>1)</sup> Depending on radial depth of cut and cutter diameter.

<sup>2)</sup> Uncoated high speed steel mill is not recommended

<sup>3)</sup> Use a wear resistant CVD-coated carbide grade

### GRINDING

General grinding wheel recommendation is given below. More information can be found in the Uddeholm publication "Grinding of Tool Steel".

Type of grinding	Annealed condition	Hardened condition
Face grinding straight wheel	A 46 HV	B151 R50 B3 <sup>1)</sup> A 46 HV <sup>2)</sup>
Face grinding segments	A 36 GV	A 46 GV
Cylindrical grinding	A 60 KV	B151 R50 B3 <sup>1)</sup> A 60 KV <sup>2)</sup>
Internal grinding	A 60 JV	B151 R75 B3 <sup>1)</sup> A 60 IV
Profile grinding	A 100 JV	B126 R100 B6 <sup>1)</sup> A 120 JV <sup>2)</sup>

<sup>1)</sup> If possible use CBN wheels for this application.

<sup>2)</sup> Preferable a wheel type containing sintered  $Al_2O_3$  (seeded gel)

## EDM

If EDM is performed in the hardened and tempered condition, finish with "finesparking", i.e. low current, high frequency. For optimal performance the EDM'd surface should then be ground/polished and the tool retempered at approx. 535°C (995°F).

## Further information

Please, contact your local Uddeholm office for further information on the selection, heat treatment, application and availability of Uddeholm tool steels.

## Relative comparison of Uddeholm cold work tool steels

### MATERIAL PROPERTIES AND RESISTANCE TO FAILURE MECHANISMS

Uddeholm grade	Hardness/ Resistance to plastic deformation	Machinability	Grindability	Dimension stability	Resistance to		Fatigue cracking resistance	
					Abrasive wear	Adhesive wear	Ductility/ resistance to chipping	Toughness/ gross cracking
ARNE	████	██████	██████	█	████	████	████	████
CALMAX	████	██████	██████	██████	████	████	██████	██████
CALDIE	██████	██████	██████	██████	████	██████	██████	██████
RIGOR	████	██████	████	██████	████	████	████	████
SLEIPNER	██████	██████	████	██████	██████	██████	████	████
SVERKER 21	████	██████	██	██████	██████	██	██	████
SVERKER 3	████	██	█	██████	██████	██	██	██
VANADIS 4 Extra	██████	██████	████	██████	██████	██████	██████	████
VANADIS 6	██████	██	██	██████	██████	██████	████	██
VANADIS 10	██████	██	██	██████	██████	██████	████	██
VANADIS 23	██████	████	████	██████	██████	██████	████	████
VANADIS 30	██████	████	████	██████	██████	██████	██	████
VANADIS 60	██████	██	██	██████	██████	██████	██	████
AISI M:2	██████	████	████	██████	██████	████	██	██

## UDDEHOLM EUROPE

### AUSTRIA

UDDEHOLM  
Hansaallee 321  
D-40549 Düsseldorf  
Telephone: +49 211 535 10  
Telefax: +49 211 535 12 80

### BELGIUM

UDDEHOLM N.V.  
Waterstraat 4  
B-9160 Lokeren  
Telephone: +32 9 349 11 00  
Telefax: +32 9 349 11 11

### CROATIA

BOHLER UDDEHOLM Zagreb  
d.o.o. za trgovinu  
Zitnjak b.b.  
10000 Zagreb  
Telephone: +385 1 2459 301  
Telefax: +385 1 2406 790

### CZECHIA

BOHLER UDDEHOLM CZ s.r.o.  
Division Uddeholm  
U silnice 949  
161 00 Praha 6 Ruzyně  
Czech Republic  
Telephone: +420 233 029 850,8  
Telefax: +420 233 029 859

### DENMARK

UDDEHOLM A/S  
Kokmose 8, Bramdrupdam  
DK-6000 Kolding  
Telephone: +45 75 51 70 66  
Telefax: +45 75 51 70 44

### ESTONIA

UDDEHOLM TOOLING ESTI OÜ  
Silikatsiidi 7  
EE-11216 Tallinn, Estonia  
Telephone: +372 655 9180  
Telefax: +372 655 9181

### FINLAND

OY UDDEHOLM AB  
Ritakuja 1, PL 57,  
FIN-01741 VANTAA  
Telephone: +358 9 290 490  
Telefax: +358 9 2904 9249

### FRANCE

UDDEHOLM S.A.  
12 Rue Mercier, Z.I. de Mitry-Compans  
F-77297 Mitry Mory Cedex  
Telephone: +33 (0)1 60 93 80 10  
Telefax: +33 (0)1 60 93 80 01

#### Branch office

UDDEHOLM S.A.  
77bis, rue de Vesoul  
La Nef aux Métiers  
F-25000 Besançon  
Telephone: +33 381 53 12 19  
Telefax: +33 381 53 13 20

### GERMANY

UDDEHOLM  
Hansaallee 321  
D-40549 Düsseldorf  
Telephone: +49 211 535 10  
Telefax: +49 211 535 12 80

#### Branch offices

UDDEHOLM  
Falkenstraße 21  
D-65812 Bad Soden/TS.  
Telephone: +49 6196 659 60  
Telefax: +49 6196 659 625

### UDDEHOLM

Albstraße 10  
D-73765 Neuhausen  
Telephone: +49 715 898 65-0  
Telefax: +49 715 898 65-25

### GREAT BRITAIN, IRELAND

UDDEHOLM UK LIMITED  
European Business Park  
Taylors Lane, Oldbury  
West Midlands B69 2BN  
Telephone: +44 121 552 55 11  
Telefax: +44 121 544 29 11

Dublin Telephone: +353 1 45 14 01

### GREECE

UDDEHOLM STEEL TRADING  
COMPANY  
20, Athinou Street  
G-Piraeus 18540  
Telephone: +30 2 10 41 72 109/41 29 820  
Telefax: +30 2 10 41 72 767

#### Agency

SKLERO S.A.  
Steel Trading Comp. and  
Hardening Shop  
Frixou 11/Nikif. Ouranou  
G-54627 Thessaloniki  
Telephone: +30 31 51 46 77  
Telefax: +30 31 54 12 50

### SKLERO S.A.

Heat Treatment and Trading of Steel  
Uddeholm Tool Steels  
Industrial Area of Thessaloniki  
P.O. Box 1123  
G-57022 Sindos, Thessaloniki  
Telephone: +30 23 10 79 76 46  
Telefax: +30 23 10 79 76 78

### HUNGARY

UDDEHOLM TOOLING/BOK  
Dunaharaszti, Jedlik Ányos út 25  
H-2331 Dunaharaszti 1.Pf. 110  
Telephone/Telefax: +36 24 492 690

### ITALY

UDDEHOLM div. della Bohler  
Uddeholm Italia S.p.A.  
Via Palizzi, 90  
I-20157 Milano  
Telephone: +39 02 35 79 41  
Telefax: +39 02 390 024 82

### LATVIA

UDDEHOLM TOOLING AB  
Piedrujas street 7  
LV-1037 Riga, Latvia  
Telephone: +371 7 701 983, -981, -982  
Telefax: +371 7 147 373

### LITHUANIA

UDDEHOLM TOOLING AB  
BE PLIENAS IR METALAI  
T. Masiulio 18b  
LT-52459 Kaunas  
Telephone: +370 37 370613, -669  
Telefax: +370 37 370300

### THE NETHERLANDS

UDDEHOLM B.V.  
Isolatorweg 30  
NL-1014 AS Amsterdam  
Telephone: +31 20 581 71 11  
Telefax: +31 20 684 86 13

### NORWAY

UDDEHOLM A/S  
Jernkroken 18  
Postboks 85, Kalbakken  
N-0902 Oslo  
Telephone: +47 22 91 80 00  
Telefax: +47 22 91 80 01

### POLAND

INTER STAL CENTRUM  
Sp. z o.o./Co. Ltd.  
ul. Kolejowa 291, Dziekanów Polski  
PL-05-092 Lomianki  
Telephone: +48 22 429 2260  
Telefax: +48 22 429 2266

### PORTUGAL

F RAMADA Aços e Industrias S.A.  
P.O. Box 10  
P-3881 Ovar Codex  
Telephone: +351 56 58 61 11  
Telefax: +351 56 58 60 24

### ROMANIA

BÖHLER Romania SRL  
Uddeholm Branch  
Str. Atomistilor Nr 14A  
077125 Magurele Jud Ilfov  
Telephone: +40 214 575007  
Telefax: +40 214 574212

### RUSSIA

UDDEHOLM TOOLING CIS  
25 A Bolshoy pr PS  
197198 St. Petersburg  
Telephone: +7 812 233 9683  
Telefax: +7 812 232 4679

### SLOVAKIA

UDDEHOLM Slovakia  
Nástrojové ocele, s.r.o  
KRÁČINY 2  
036 01 Martin  
Telephone: +421 842 4 300 823  
Telefax: +421 842 4 224 028

### SLOVENIA

UDDEHOLM div. della Bohler  
Uddeholm Italia S.p.A.  
Via Palizzi, 90  
I-20157 Milano  
Telephone: +39 02 35 79 41  
Telefax: +39 02 390 024 82

### SPAIN

UDDEHOLM  
Guifré 690-692  
E-08918 Badalona, Barcelona  
Telephone: +34 93 460 1227  
Telefax: +34 93 460 0558

#### Branch office

UDDEHOLM  
Barrio San Martin de Arteaga, 132  
Pol.Ind. Torrelarragoiti  
E-48170 Zamudio  
(Bizkaia)  
Telephone: +34 94 452 13 03  
Telefax: +34 94 452 13 58

### SWEDEN

UDDEHOLM TOOLING  
SVENSKA AB  
Aminogatan 25  
SE-431 53 Mölndal  
Telephone: +46 31 67 98 50  
Telefax: +46 31 27 02 94

### SWITZERLAND

HERTSCH & CIE AG  
General Wille Strasse 19  
CH-8027 Zürich  
Telephone: +41 44 208 16 66  
Telefax: +41 44 201 46 15

## UDDEHOLM NORTH AMERICA

### USA

UDDEHOLM  
4902 Tollview Drive  
Rolling Meadows, IL 60008  
Sales Phone: +1 800 638 2520  
Sales Fax: +1 630 350 0880

*Region East Warehouse*  
UDDEHOLM – Shrewsbury, MA

*Region Central Warehouse*  
UDDEHOLM – Wood Dale, IL

*Region West Warehouse*  
UDDEHOLM – Santa Fe Springs, CA

### CANADA

UDDEHOLM  
2595 Meadowvale Blvd.  
Mississauga, ON L5N 7Y3  
Telephone: +1 905 812 9440  
Telefax: +1 905 812 8658

#### Branch Warehouses

UDDEHOLM – St. Laurent, QC  
UDDEHOLM – New Westminster, BC

#### Heat Treating

THERMO-TECH – Mississauga, ON

### MEXICO

ACEROS BOHLER UDDEHOLM,  
S.A. de C.V.  
Calle 8 No 2, Letra "C"  
Fraccionamiento Industrial Alce Blanco  
C.P. 52787 Naulcalpan de Juarez  
Estado de Mexico  
Telephone: +52 55 9172 0242  
Telefax: +52 55 5576 6837

### UDDEHOLM

Letrado de Tejada No.542  
Colonia Las Villas  
66420 San Nicolas de Los Garza, N.L.  
Telephone: +52 8-352 5239  
Telefax: +52 8-352 5356

## UDDEHOLM SOUTH AMERICA

### ARGENTINA

UDDEHOLM S.A  
Mozart 40  
1619-Centro Industrial Garin  
Garin-Prov. Buenos Aires  
Telephone: +54 332 744 4440  
Telefax: +54 332 745 3222

### BRAZIL

UDDEHOLM ACOS ESPECIAIS Ltda.  
Estrada Yae Massumoto, 353  
CEP 09842-160  
Sao Bernardo do Campo - SP Brazil  
Telephone: +55 11 4393 4560, -4554  
Telefax: +55 11 4393 4561

## UDDEHOLM SOUTH AFRICA

UDDEHOLM Africa (Pty) Ltd.  
P.O. Box 539  
ZA-1600 Isando/Johannesburg  
Telephone: +27 11-974 2781  
Telefax: +27 11-392 2486

## UDDEHOLM AUSTRALIA

BOHLER-UDDEHOLM Australia  
129-135 McCredie Road  
Guildford NSW 2161  
Private Bag 14  
Telephone: +61 2 9681 3100  
Telefax: +61 2 9632 6161

#### Branch offices

Sydney, Melbourne, Adelaide,  
Brisbane, Perth, Newcastle,  
Launceston, Albury, Townsville

### ASSAB

### ASSAB INTERNATIONAL

Skytteholmsvägen 2  
P O Box 42  
SE-171 11 Solna  
Sweden  
Telephone: +46 8 564 616 70  
Telefax: +46 8 25 02 37

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Emirates, Saudi Arabia  
*Distributors in*  
Africa, Latin America, Middle East

### ASSAB PACIFIC

ASSAB Pacific Pte. Ltd  
171, Chin Swee Road  
No. 07-02, San Centre  
Singapore 169877  
Telephone: +65 534 56 00  
Telefax: +65 534 06 55

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