

MATERIAL DATA SHEET

STEEL GRADE

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OVAKO

20MnCr5

All

General Information

20MnCr5 is a case-hardening steel with low carbon content but good hardenability reaching good wear resistance due to high surface hardness after hardening. The small grain size benefits in good ductility and fatigue strength. Suitable for gearboxes and axle gears.

Ovako 236F is a standard variant with controlled sulphur content for consistent machining properties.

Ovako 236Q is an IQ (isotropic quality) variant.

Similar designations

20MnCrS5, 1.7147, 20MnCr4, 1.7149

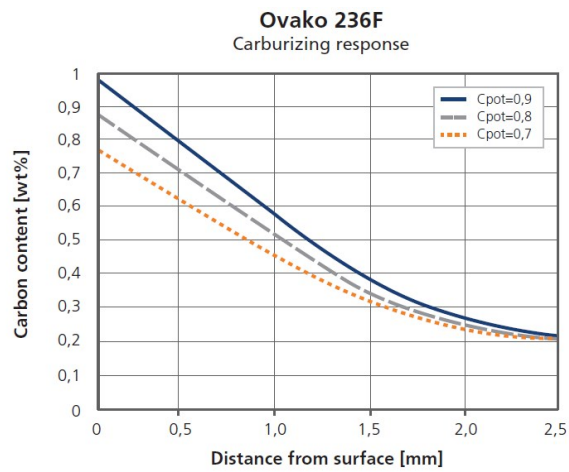
Transformation temperatures

	Temperature °C
MS	385
AC1	731
AC3	831

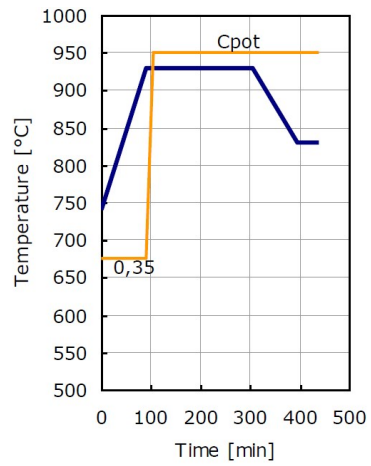
Heat treatment recommendations

Treatment	Condition ⓘ	Temperature cycle	Cooling/quenching
Hot forging		850 - 1 200	Slowly or in air
Annealing	+A	670 - 710	Slowly (15°C/h) until 600°C
	+FP	950 - 1 000	Quickly to following stage
	+FP	630 - 650	Keeping about 3 hours, after that: in air
Normalizing		860 - 890	In air
Stress relieve annealing		650 - 680	In air
Carburizing		860 - 900	In air
Hardening		830 - 870	Quenching in oil or water
Tempering		150 - 200	In air

Carburizing response



Heat treatment



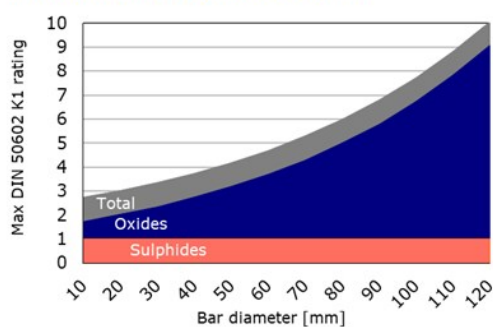
Steel cleanliness

Micro inclusions - steel grade 236F									Macro inclusions - 236F	
Applied standard	ASTM E45								Applied standard	ISO 3763 (Blue fracture)
Sampling	ASTM A295								Sampling	Statistical testing on billets.
Maximum average limits	A		B		C		D		Limits	< 2,5 mm/dm ²
	Th	He	Th	He	Th	He	Th	He		
	2.5	1.5	1.5	0.5	0	0	0.5	0.5		

Micro inclusions - steel grade 236Q									Macro inclusions - 236Q		
Applied standard	DIN 50602 K1								Applied standard	ISO 3763 (Blue fracture)	10 M Hz UST (Ovako internal procedure)
Sampling	Six random samples from final product dimension								Sampling	Statistical testing on billets	
Limits	The limit is dimension dependent. The average rating of six samples should not exceed the limits given in the graph.								Limits	< 1 mm/dm ²	< 10 defects/dm ³ > 0,2 mm FBH

IQ

Inclusion limits IQ-processed steel



SUSTAINABILITY-ENVIRONMENTAL IMPACT DATA

At Ovako sustainability and reduction of our environmental impact is a major focus in everything we do.

Further information is found [here](#).

Steel works	Hofors	Smedjebacken	Imatra
CO ₂ e/kg	120	62	76

To get the full picture of our products environmental impact we have to look at all of our CO₂ emission sources.

Not only the steel work Scope 1-2 itself, but all operations downstream in our production, heating and

heat treatment furnaces etc (full scope 1-2) as well as all the emission from input material, eg. alloys, scope 3.

Steel Grade	Format	Condition	Scope 1-3 (CO ₂ e kg /1000 kg steel)	Climate compensated Net emission = Scope 3 (CO ₂ e kg /1000 kg steel) Scope 1 - 2 = 0 (compensated)
236	Round bar	+AR	608	209
236	Round bar	+FP	612	211
236	Tube,wall	+AR	630	232
236	Tube,wall	+FP	632	235

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Other properties (typical values)

Youngs module (GPa)	Poisson's ratio (-)	Shear module (GPa)	Density (kg/m ³)
210	0.3	80	7800
Average CTE 20-300°C (µm/m°C)	Specific heat capacity 50/100°C (J/kg °K)	Thermal conductivity Ambient temperature (W/m°C)	Electrical resistivity Ambient temperature (µΩm)
12	460 - 480	40 - 45	0.20 - 0.25

Contact us

Would you like to know more about our offers? Don't hesitate to contact us:

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For more detailed information please visit <http://www.ovako.com/en/Contact-Ovako/>

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