Quality	**35NiCrMoV12-5**
According to Standard	**PD 970:2005**
Number	**1.6959**

ALOK INGOTS™
steel re engineered
AN ISO 9001:2008 CERTIFIED COMPANY

Comparable Standards	**GOST**	**AISI**
	38ChN3MFA	-

Chemical Analysis	**C %**	**Mn %**	**Si %**	**Cr %**	**Ni %**	**Mo %**	**S%**
	0.30 - 0.40	0.40 - 0.70	0.15 - 0.35	1.00 - 1.40	2.50 - 3.50	0.35 - 0.60	0.015 max.

P%	**V%**
0.015 max.	0.08 - 0.20

Hot Work and Heat Treatment Temperatures

Stress-relieving (+SR)	**Hot Forming**	**Quenching (+Q)**	**Tempering (+T)**	**Soft Annealing (+A)**	**Flame and Induction hardening**	**Nitriding**
680 furnace cooling to 300, then air. It must be done after machining & before quenching. 50⁰ under the temperature of tempering, furnace cooling max 20⁰ /h to 300, then air	1100 - 900	heating up to 650, pause, then 850 oil, polymer, forced air	immediately after quenching minimum 2 cycles	750 furnace cooling max 20⁰ /h to 600, pause, then air (HB max 240)	850 - 870 water, oil	500 - 540

Pre - Heating Welding		**+SR after Welding**	
300		550 furnace cooling	
Ac1	Ac3	Ms	Mf
710	800	320	100