

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



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. 50° under the temperature of tempering, furnace cooling max 20°/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 20°/h to 600, pause, then air (HB max 240)	850 - 870 water, oil	500 - 530
		Pre - Heating Welding		+SR after Welding		
		300	Ac1	Ac3	Ms	Mf
			710	800	320	100