

## 1.3343 High Speed Steel

**1.3343 high speed steel suppliers and stockholders delivering to the whole of the UK.** West Yorkshire Steel are suppliers of round bar, plate, sheet and block which can be bandsaw cut to your specific requirements. As a tungsten molybdenum high speed steel, it widely used in the production of machine tool bits, cold forming tools and cutting tools. 1.3343 high speed steel offers high toughness combined with good cutting powers and will withstand increases in temperature without losing its temper.

We welcome export enquiries for high speed steel. Contact our sales office and consult our [shipping policy](#) for details.

---

### Form of Supply

West Yorkshire Steel are stockholders and suppliers of 1.3343 high speed steel round bar, flat bar, plate and block. 1.3343 can be sawn to your required lengths as one offs or multiple cut pieces. Rectangular pieces can be sawn from flat bar or block to your specific sizes. Ground high speed steel bar can be supplied, providing a quality precision bar to tight tolerances.

Contact our experienced sales team who will assist you with your high speed steel enquiry.

- Flat
- Diameter

---

### Applications

Typical applications this high speed steel grade are twist drills, reamers, broaching tools, taps, milling tools, metal saws. 1.3343 is suitable for cold forming tools such as extrusion rams and dies, also cutting tools and plastic moulds with elevated wear resistance.

---

### Analysis

Carbon	0.86-0.94%	Chromium	3.80-4.50%
Manganese	0.40% max	Molybdenum	4.70-5.20%
Silicon	0.45% max	Vanadium	1.70-2.10%
Phosphorous	0.03% max	Tungsten	5.90-6.70%
Sulphur	0.03% max		

---

## Ground Flat Stock

Precision ground flat stock / gauge plate can be produced. Subject to size suitability and availability of raw material pieces can be produced in approximately 2 to 3 weeks. Standard and non-standard sizes are available.

---

## Forging

Pre heat slowly and uniformly to 850-900°C. The heat should then be increased more quickly to the forging temperature of 1050-1150°C. If during the forging the temperature of the material drops below 880-900°C, re heating will be necessary. Cool the component very slowly after forging.

---

## Annealing

Annealing is recommended after hot working and before re hardening. Heat to 850°C at a rate of no more than 220°C per hour. Always hold at temperature for one hour per 25mm of thickness (with two hours being minimum). Furnace cool slowly. The annealed hardness achieved should be 248 Brinell or lower.

---

## Stress Relieving

If tools are heavily machined or ground it is recommended to stress relieve after machining and prior to hardening to minimise the possibility of distortion. To stress relieve heat the component to 675-725°C and soak well (approx 2 hours), then cool in air. The 1.3343 tools can be finish machined before heat treatment.

---

## Hardening

Pre heat the component in two steps; 450-500°C then 850-900°C. Continue heating to the final hardening temperature of 1200-1250°C and ensure that the component is heated through. Care must be taken to not allow the component to remain too long at the hardening temperature. Quench in warm oil or salt. If quenching in salt allow the tools to equalize, then complete the quench in air. If quenching in oil remove the component from the oil at about 500°C and then air cool. 1.3343 high speed steel is also suitable for vacuum hardening.

---

## Tempering

Temper the steel immediately after quenching. Heat uniformly and carefully to the selected tempering temperature and hold at for at least two hours (one hour per 25mm of total thickness). Double tempering is essential and for tools cut by wire EDM triple tempering is strongly recommended.

<b>Temperature [°C]</b>	500	550	600	650
<b>Hardness [HRc]</b>	64	65	64	61

---

## Heat Treatment

Heat treatment temperatures, including rate of heating, cooling and soaking times will vary due to factors such as the shape and size of each component. Other considerations during the heat treatment process include the type of furnace, quenching medium and work piece transfer facilities. Please consult your heat treatment provider for full guidance on heat treatment of high speed steels.

---

## Final Grinding

Select the correct grade of wheel in consultation with the grinding wheel manufacturer. Ensure the grinding wheel is in good condition by means of a suitable dressing tool. Wet grinding is a preferable option using a copious supply of coolant. If dry grinding is resorted to then use a very soft wheel.

---

## Quality Assured Supply

1.3343 high speed steel is supplied in accordance with our ISO 9001:2015 registration.