

BS4659 BM2 High Speed Steel

BS4659 BM2 high speed steel stockholders and suppliers, delivering to the whole of the UK. BM2 high speed tool steel is supplied in round bar, sheet and plate. BM2 is tungsten molybdenum high speed grade used in a wide variety of tooling applications. BM2 combines high toughness with good cutting powers.

We welcome export enquiries for BS 4659 BM2 high speed steel. Contact our sales office and consult our [shipping policy](#) for further details.

Related Specifications

ASTM A681 DIN 17350 BS EN ISO 4957

Alternative BS4659 tool steel grades we supply

[BO1](#) | [BD2](#) | [BD3](#) | [BO2](#) | [BA2](#) | [BS1](#) | [BH13](#) | [BP20](#) | [BP30](#) | [BM35](#) | [BM42](#)

Form of Supply

BM2 is supplied in round bar, flat bar and plate. Sawn blanks can be supplied to your required sizes as one offs or multiple cut pieces. Ground BM2 tool steel bar can be supplied, providing a quality precision diameter to close tolerances.

Contact our experienced sales team who will assist you with your BM2 high speed steel enquiry.

- Flat
- Diameter

BM2 Tool Bits

Tool bits are supplied in flats, squares and rounds to grade BM2. Commonly supplied in standards sizes though non standard sizes can be produced within a few weeks, subject to availability of suitable raw material.

Analysis

Carbon	0.80-0.90%	Chromium	3.75-4.50%
Silicon	0.40% max	Molybdenum	4.75-5.50%
Manganese	0.40% max	Tungsten	6.00-6.75%
Cobalt	1.00% max	Vanadium	1.75-2.05%

Forging

Pre heat the steel slowly and uniformly to 850-900°C. Increase the heat more quickly to the forging temperature of 1050-1150°C. Re heat if the forging the temperature of the material drops below 880-900°C. After forging cool slowly.

Annealing

Heat the BM2 to 850-870°C at a rate of no more than 220°C per hour. Hold at temperature for one hour per 25mm of thickness (with two hours being minimum). Cool slowly in the furnace.

Stress Relieving

To stress relieve BM2 fully heat the component to 675-725°C, then cool in air.

Hardening

To harden pre heat the steel in two steps; 450-500°C then 850-900°C. Then continue heating to the final hardening temperature of 1210-1230°C and ensure that the component is heated thoroughly. Do not allow the component to remain too long at the hardening temperature. Quench immediately in warm oil or brine. When quenching in brine allow the steel to equalize, then complete the quench in air. When quenching in oil remove the steel from the oil at about 500°C and then cool in air.

Tempering

The steel should be tempered immediately after quenching. Heat thoroughly to the selected tempering temperature, between 550-570°C and hold at for at least two hours (one hour per 25mm of total thickness). Double tempering is strongly recommended.

Heat Treatment

Heat treatment temperatures for BM2, 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 BS4659 high speed steels.

Quality Assured Supply

BS4659 BM2 high speed steel is supplied in accordance with our ISO 9001:2015 registration.