

DATASHEET

DAMACORE® DC18N



Product information

Damasteel's stainless Damascus patterned steel, Damacore® DC18N is a powder metallurgy-based steel with three different alloys. The center core consists of N11X™, a high nitrogen steel with distinctive properties. Through a process route based on powder metallurgy a high nitrogen steel is produced, most of the carbon is substituted by nitrogen, modifying the traditional chromium carbides into vanadium nitrides. This gives N11X™ unique properties a combination of hardness, wear resistance, ductility, and corrosion resistance. This combination of properties is a reason for its impressive suitability as knife material.

The Damascus patterned outer layers consists of RWL34™ and PMC27™. These three alloys combined in Damasteel's process gives the Damacore® DC18N unique and exceptional properties that combines beauty and function that until now was impossible to produce.

Distinctive Features

- Excellent corrosion resistance
- Good wear resistance
- Good ductility

Mechanical and physical properties

Grade	C	Si	Mn	Cr	Mo	V	N	S	P
N11X™	0,36	0,3	0,3	18,2	1,1	3,5	1,55		
RWL34™	1,05	0,50	0,50	14	4	0,2	0,1	<0,03	<0,05
PMC27™	0,60	0,50	0,50	13			0,1	<0,03	<0,05

Table 1. Nominal chemical compositions in wt-% of the constituent alloys in DC18N.

Hot working

Forging or rolling temperature is in the range 1050-1160 °C (1920-2120 F). Melting starts at 1220°C (2230 F) which means that the material is very sensitive to overheating, so good control of the heating temperature is needed. Compared to low alloyed steels, martensitic stainless steels have higher, almost doubled deformation resistance.

Long soaking times above 850°C (1560 F) leads to decarburization and scale formation. After the hot working process, a slow cooling is recommended due to the risk of cracks when the material phase transforms to martensite at around 200 °C (390 F). Usage of vermiculite or other heat insulating material is recommended. Because of the risk of cracking, no grinding, cutting, machining, should be done after hot working until the material is annealed.

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SWEDEN: STALLGATAN 9, SE-815 76 SÖDERFORS | OFFICE SWEDEN: +46 293 306 00 | SALES@DAMASTEEL.SE | WWW.DAMASTEEL.SE

Cold working

Martensitic stainless steel does not cold work as easily as the conventional austenitic stainless steels but can be formed and fabricated by a full range of cold working operations. The ductility is good, any cold working process will increase the strength and the hardness of the material.

Machining

The martensitic stainless steels are generally easy to machine.

The machining characteristics for our stainless Damascus patterned steel are:

Soft annealed, <25 HRC:

- Use HSS or carbide tools.
- Tendencies for buildup on the tool edge.
- Tough and stringy chips

Hardened and tempered, 56-61 HRC:

- Ceramic or CBN inserts (milling and turning)

Grinding and polishing

Normal grinding and polishing procedures can be used for the martensitic stainless steel.

Grinding wheel recommendation:

Silicon Carbide, 46 grit, soft, open density, ceramic bonded. (C46J6V), Speed: 35 m/sec, Feed: 0.01-0.05 mm/stroke. Speed of the work piece may be 1/60 of the grinding speed.

Welding

When cooling martensitic stainless steel after any hot process the martensitic phase transformation occur at around 200 °C and can lead to cracking. This can be avoided either by preheating the piece or do a post-weld heat treatment.

Our stainless Damascus patterned steel can be welded by a full range of conventional welding methods.

Heat treatment

It is recommended that hardening operations, heating, cooling, cryogenic and tempering operations, should be performed before grinding or machining bevel, to protect core for loss of nitrogen, if operations are not done in a vacuum furnace with partial pressure of nitrogen.

Annealing:

The recommendation is to have the material fully transformation annealed which means two hours at 980 °C (1796 F), then cool in furnace to 850°C (1562F) with a ramp of <15° per hour. Hold for 10 hours at 850°C (1562F) then cool slow, ~10°C/h, to 750°C (1382) then cool to room temperature, see diagram 1. Achieved hardness <280 HV (28HRC).

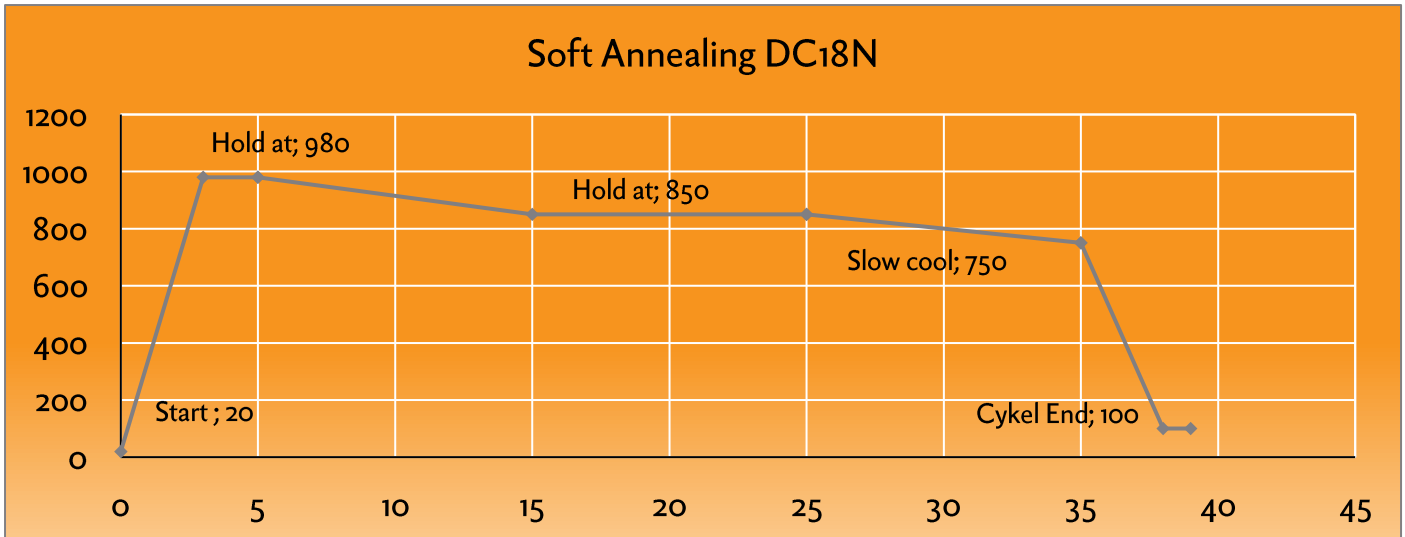


Diagram 1. Soft annealing cycle for DC18N.

Hardening/ Tempering:

Austenitizing:

Temperature 1080°C (1976 F), holding time at austenitizing temperature 30 min. This temperature includes a deep-freezing treatment to fulfill the transform to martensite. An alternative austenitizing temperature is 1010°C (1850 F). Hardening can be performed in normal atmosphere with the use of heat treatment foil wrap, see diagram 2. To counteract the loss of Nitrogen, perform the hardening using a vacuum furnace and with a Nitrogen partial pressure of 150-200 mbar.

Quenching:

We suggest cooling in air and the piece reaches 50°C within two min. Apply some pressure on the piece if cooling in air so it will not bend due to uneven cooling. Followed by deep cooling between -100°C (-148°F) and -196°C (-320°F) to minimize the amount of retained austenite.

Deep Freezing:

Necessary for DC18N and completes the martensite transformation. Without DF the retained austenite will be around 60% with a hardness around 50 HRC. Hold for one and a half hour in a temperature below -100°C (-148 F) or use liquid Nitrogen -198°C (-324 F). If there are no possibilities to deep freeze use an austenitizing temperature of 1010°C (1850 F) Hold for 30 min and then temper at 200° (390F) 2x 2h. Achieved hardness will be around 57-58 HRC. See diagram 3.

Tempering:

For best corrosion properties low temperature tempering at 200°C (390°F)/2 x 2h is recommended. If the product application conditions require a higher tempering temperature Damacore® DC18N can be tempered up to 450°C (840°F) without significant loss of corrosion properties, see diagram 4. The hardenability is adequate to ensure good through hardening properties when quenching in vacuum furnaces.

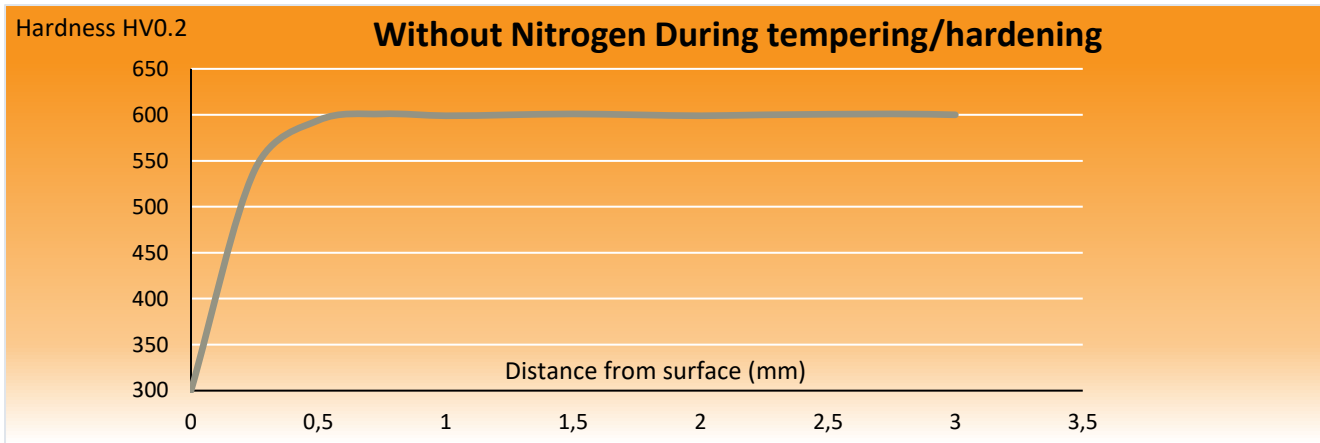


Diagram 2. Hardness profile without Nitrogen during tempering/hardening.

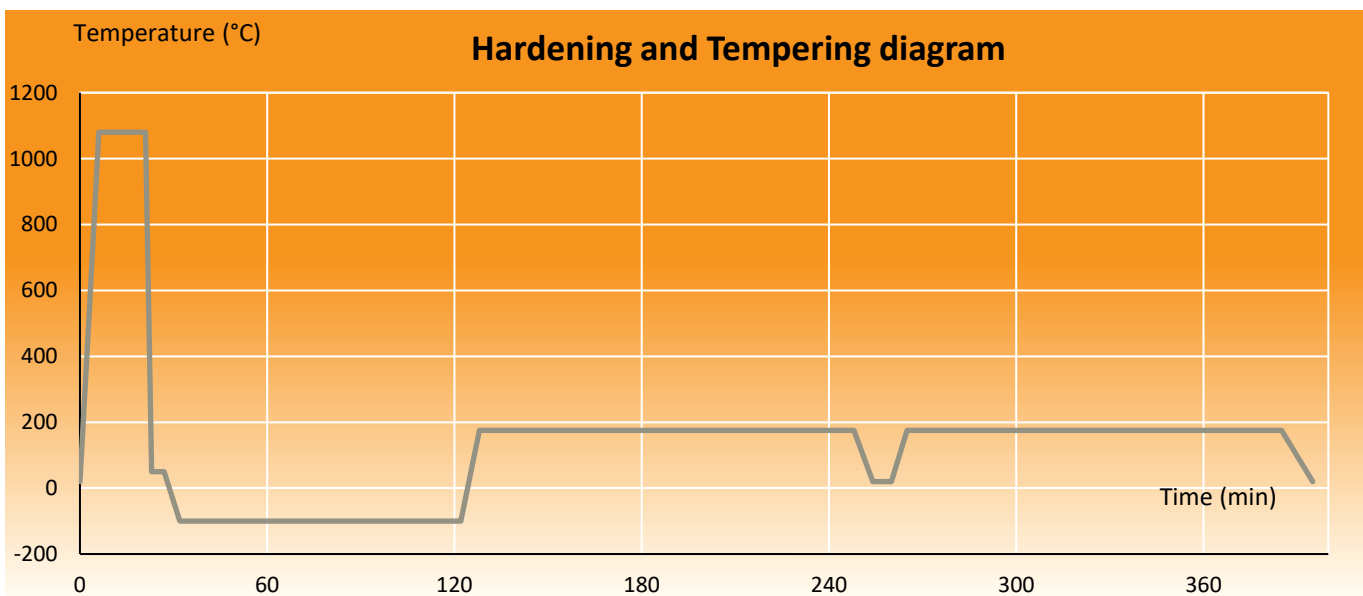


Diagram 3. Schematic hardening and tempering diagram for martensitic material including a deep-freezing treatment with liquified Nitrogen.

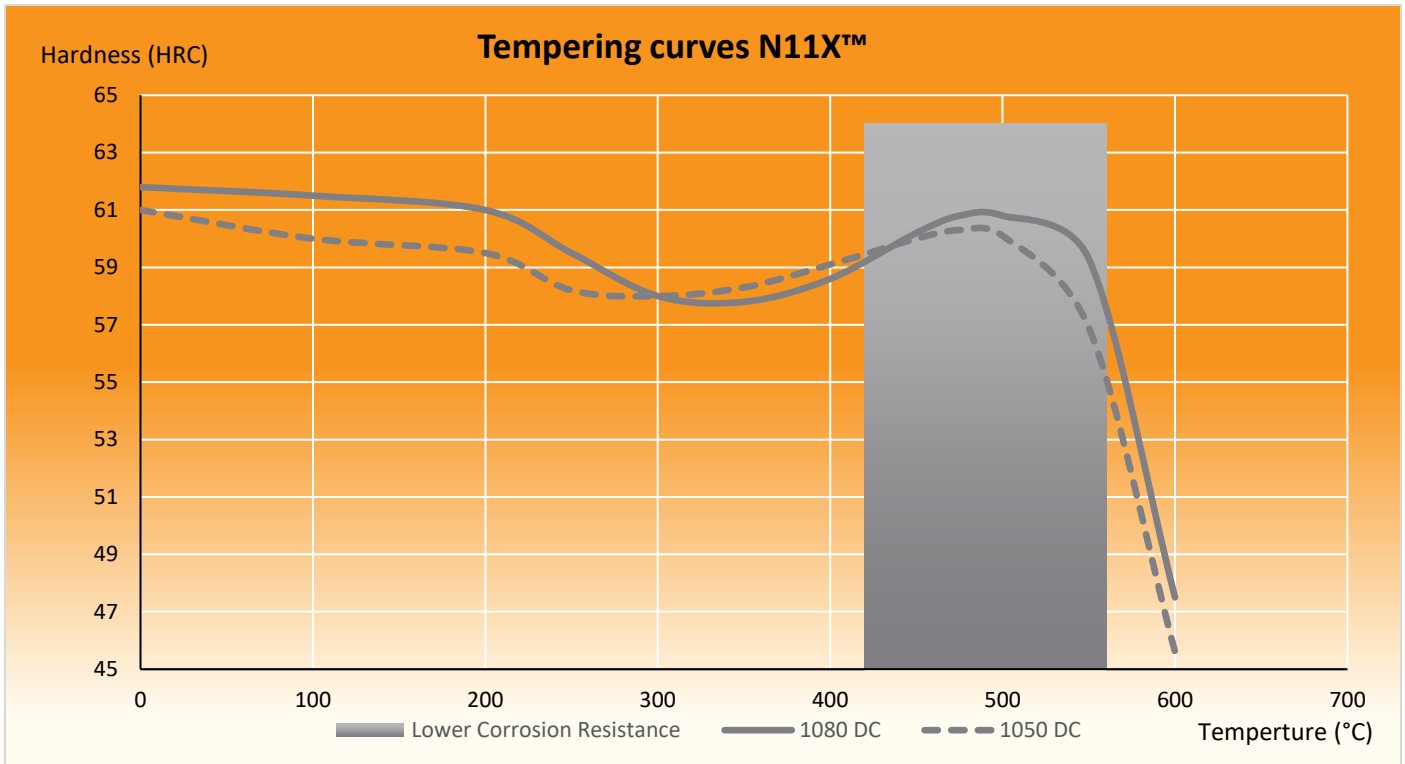


Diagram 4. Tempering and corresponding hardness in HRC for two austenitizing temperatures, material subzero treated before.

Etching

To make the pattern in our steel visible, etching must be made. Depending on desired result, different acids and acids mixtures can be used. The surface finish is also influencing the result. See table 2.

	Etching Solution	Chem. comp.	Blend (%)	Time (min)	Color RWL34™	Color PMC27™	Color N11X™
I	Hydrochloric acid 37 %	HCL	100%	2-3	Bright	Dark grey	Grey
II	Hydrochloric acid 37 % / Ferro Chloride	HCl, FeCl ₃	95% / 5%	2-5	Bright	Dark grey	Grey

Table 2. Etching suggestions with corresponding colors and relief of the different alloys.

Implementation:

- Grind the piece progressively up to desired grit, 600 or higher. Finish off with polishing if desired.
- Clean and degrease the piece carefully.
- Mix the etching acid in the recommended ratios and remember to always pour the acid into the water.
- Immerse the piece in the mix and leave it in for the time you choose. Longer soaking time will give deeper etch.
- Neutralize the piece by dipping it into water with bicarbonate.
- Note: A small amount of FeCl₃ can be mixed within the HCl acid to further darken the etch.

Beware of noxious fumes. Acids must be handled with great care.

Products and dimensions

Available width on Damacore® DC18N is 38, 51 and 63,5 mm (1.5", 2" and 2.5"). Thicknesses ranging between 2,5 mm to 6,3 mm (0.100" to 0.248"), depending on pattern all thicknesses are not available, see table 3. Length between 305-610 mm. For more details visit our website.

Patterns	Thickness available for a specific pattern						
	.100" 2,5mm	.118" 3,0mm	.125" 3,2mm	.138" 3,5mm	.156" 4,0mm	.190" 4,8mm	.248" 6,3mm
Odins Eye™					X	X	X
Grosserosen™					X	X	X
Thor™				X	X	X	
Hugin™	X	X	X	X	X	X	
Rose™	X	X	X	X	X	X	
Hakkapella™	X	X	X	X	X	X	X
Baldur™		X	X	X	X	X	X

Table 3. Available patterns for a specific thickness.

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