

# MOLYBDENUM

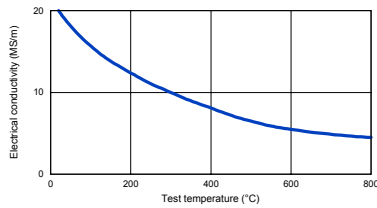
## Technical Datasheet

<b>Code</b>	Mo	<b>Chemical Composition</b>	Mo
<b>Material-No.</b>	-	(Typical analysis in %)	100
<b>Material Properties</b>	High melting point, high endurance strength under elevated temperatures (under vacuum or protective gas up to 2.000 K/1.727 °C), good thermal strength, low thermal expansion.		
<b>Applications</b>	<ul style="list-style-type: none"> <li>• Resistance welding electrodes/discs for copper and brass</li> <li>• Parts of electronic tubes</li> <li>• Construction material in semi-conductors</li> <li>• Heating wire in protective gas furnaces</li> <li>• Radiation sheets in high temperature furnace constructions</li> <li>• Sinter boats</li> </ul>		
<b>Mechanical Properties</b> (Typical)	Hardness	HV	200 - 220
	Tensile strength c. 85 % reduction	N/mm <sup>2</sup>	590 – 690
	Yield strength	N/mm <sup>2</sup>	540 - 640
	Elongation L = 5 D	%	15 - 20
	Modulus of elasticity at 293 K (20 °C)	kN/mm <sup>2</sup>	330
<b>Physical Properties</b> (Typical)	Electrical conductivity 293 K (20 °C)	MS/m	c. 20 (c. 35 % I.A.C.S.)
	Electrical resistance 293 K (20 °C)	$\frac{\Omega \cdot \text{mm}^2}{\text{m}}$	c. 0,05
	Coefficient of electrical resistance	$\frac{1}{\text{K}}$	c. 0,0046
	Coefficient of thermal expansion 273-593 K (0-320°C)	$\frac{1}{\text{K}}$	5,3 – 5,7 · 10 <sup>-6</sup>
	Specific heat	$\frac{\text{J}}{\text{g} \cdot \text{K}}$	0,27
	Thermal conductivity 293 K ( 20 °C)	$\frac{\text{W}}{\text{m} \cdot \text{K}}$	c. 130
	Density	$\frac{\text{g}}{\text{cm}^3}$	10,2
<b>Available Products</b>	Wire, bars, sheets, machined parts		
Tensile strength properties depend on cross-section and design.			

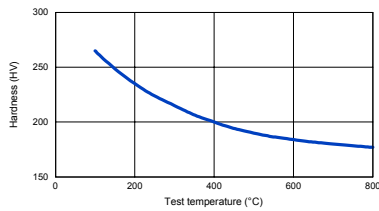
# MOLYBDENUM

## Technical Datasheet

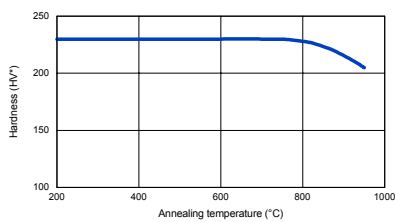
Electrical Conductivity of Molybdenum depending of temperature



Hardness at elevated temperatures of Molybdenum



Softening point of Molybdenum



### Machining Instruction

Machinability of Molybdenum is relatively difficult. In case of necessary machining the following instructions are suitable:

#### Turning

	Tungsten carbide K 05	High Speed Steel THYRAPID 3202
Cutting speed	m/min. 70 – 120	30 – 40
Rake angle	c. 20°	c. 20°
Feed	mm/U 0,05 – 0,40	0,05 – 0,30
Depth of cut	mm 0,5 – 5,0	0,3 - 5,0

#### Milling

	Tungsten carbide ISO K 10 or ISO K 05	High Speed Steel THYRAPID 3202
Cutting speed	m/min. 80 – 120	20 – 25
Rake angle	10°	10°
Feed/tooth	mm 0,05 – 0,10	0,03 – 0,10

#### Drilling

	Tungsten carbide ISO K 05	High Speed Steel THYRAPID 3202
Cutting speed	m/min. 12	10 - 15
Feed	mm 0,05 – 0,10	0,03 – 0,10

All statements as to the properties or utilization of the materials and products mentioned in this data sheet are only for the purpose of description. Guarantees in respect of the existence of certain properties or utilization at the material mentioned are only valid if agreed upon in writing.

\*) Vickers hardness at R.T. after 5 hours at temperature between 50 and 800 °C annealed