

ROD & BAR ALLOY K211

(RoHS compliant 2011)

ALLOY DESCRIPTION

K211-T3 is a RoHS compliant, free machining alloy and temper combination that compares favorably with standard 2011 and free cutting brass. K211 is the alloy of choice when a RoHS compliant 2000 series alloy is needed that offers good strength and high machining rates. K211 can be machined to very close tolerances and produces excellent machined surface finishes. Resistance welding, corrosion resistance and anodizeability are only fair. Other forms of welding are not recommended. Additional strength, without a sacrifice in machinability, can be achieved through the use of the T8 temper.

TYPICAL MECHANICAL PROPERTIES

Temper	Tensile (.500" Dia. Specimen)					Hardness	Shear		Fatigue*		Modulus	
	Ultimate		Yield		Elongation/4D		Ultimate Shearing Strength		Endurance Limit - R.R. Moore Type		Modulus of Elasticity	
	KSI	MPa	KSI	MPa		%		KSI	MPa	KSI	MPa	KSI x 10 ³
T3	55	379	43	296	15	95	32	221	18	124	10.2	70
T8	59	407	45	310	12	100	35	241	18	124	10.2	70

*5 x 10E8 cycles of reversed stress

COMPARATIVE CHARACTERISTICS

Temper	Corrosion Resistance		Cold Workability ³	Machinability ³	Anodize Response ³	Brazeability ⁴	Weldability ⁴		
	General ¹	Stress ²					Gas	Arc	Spot
T3	D	D	C	A	C	D	D	D	D
T451	D	D	B	A	C	D	D	D	D
T8	D	B	D	A	C	D	D	D	D

- Ratings A through E are relative ratings in decreasing order of merit, based on exposures to sodium chloride solution by intermittent spraying or immersion. Alloys with A and B ratings can be used in industrial and seacoast atmospheres without protection. Alloys with C, D and E ratings generally should be protected at least on faying surfaces.
- Stress-corrosion cracking ratings are based on service experience and on laboratory tests of specimens exposed to the 3.5% sodium chloride alternate immersion test.
 A= No known instance of failure in service or in laboratory tests.
 B= No known instance of failure in service; limited failures in laboratory tests of short transverse specimens.
 C= Service failures with sustained tension stress acting in short transverse direction relative to grain structure; limited failures in laboratory tests of long transverse specimens.
 D= Limited service failures with sustained longitudinal or long transverse areas.
- Ratings A through D for Workability (cold), A through E for Machinability and A through C for Anodize Response, are relative ratings in decreasing order of merit.
- Ratings A through D for Weldability and Brazeability are relative ratings defined as follows:
 A= Generally weldable by all commercial procedures and methods.
 B= Weldable with special techniques or for specific applications that justify preliminary trials or testing to develop welding procedure and weld performance.
 C= Limited weldability because of crack sensitivity or loss in resistance to corrosion and mechanical properties.
 D= No commonly used welding methods have been developed.

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APPLICABLE SPECIFICATIONS

Cold Finished	Extruded
ASTM B211	
AMS-QQ-A-225/3	

CHEMICAL COMPOSITION LIMITS

Weight %	Si	Fe	Cu	Pb	Bi	Zn	Others	
							Each	Total
Minimum			5.00	0.20	0.20			
Maximum	0.40	0.70	6.00	0.40	0.60	0.30	0.05	0.15

TYPICAL PHYSICAL PROPERTIES

Characteristic		English	Metric
Nominal Density (68 °F / 20 °C)		0.102 lbs./in. ³	2.82 Mg/m ³
Melting Range		1005 °F - 1180 °F	541 °C - 638 °C
Specific Heat (212 °F / 100 °C)		0.206 BTU/lb. - °F	864 J/kg - °K
Coefficient of Thermal Expansion	Linear 68 °F - 212 °F 20 °C - 100 °C	12.8 micro in./in. - °F	23.1 micro m/m - °K
	Volumetric 68 °F / 20 °C	3.72 x 10 ⁻⁵ in. ³ /in. ³ - °F	67 x 10 ⁻⁶ m ³ /m ³ - °K
Thermal Conductivity (68 °F / 20 °C)	T3, T451	88 BTU/ft. - hr. - °F	152 W/m - °K
	T8	100 BTU/ft. - hr. - °F	173 W/m - °K
Electrical Conductivity (68 °F / 20 °C)	Equal Volume	T8	45% IACS
		T3	39% IACS
	Equal Weight	T8	142% IACS
		T3	123% IACS