



PRODEC® Type 304/304L

A special quality of standard UNS S30400, UNS S30403 with composition and processing for enhanced machinability

General properties

PRODEC 304/304L is an improved machinability version of standard Type 304/304L austenitic stainless steel. With advanced ladle metallurgy techniques during melting, the steel is processed for improved machinability and outstanding uniformity offering the end user with Production Economy (PRODEC).

PRODEC 304/304L offers faster machining speeds, longer tool life, improved part surface quality, and lower total cost of machined parts. The basic austenitic stainless steel, a versatile corrosion resistant material for general purpose applications.

PRODEC 304/304L is the modern evolution of the original "18-8" austenitic stainless steel. It is an economical and versatile corrosion resistant stainless steel suitable for a wide range of general purpose applications.

PRODEC 304/304L is non-magnetic in the annealed condition but may become slightly magnetic as a result of cold working or welding.

Plate Product Sizes

Plate product is available up to 6 inches thick and up to 120 inches wide depending on the thickness.

Dual certification

It is common for PRODEC 304L to be dual certified as 304 and 304L when the material meets both the lower carbon limit of Type 304L and the slightly higher strengths of Type 304. The producer of the steel must certify the material as Type 304 if it is to be used as Type 304 instead of Type 304L.

Specifications

PRODEC 304/304L can be supplied to meet AMS, ASTM, ASME, QQS, and MIL-S specifications as standard Type 304/304L.

Design features

- Good corrosion resistance
- High ductility and formability
- Excellent impact toughness even at cryogenic temperatures
- Good workability and weldability
- Excellent machinability

Applications

- General-purpose applications and environments
- Corrosion resistant machined parts
- Water treatment

Turning

Table 1

Feed (in/rev)	Cutting depth (in)	Cutting speed, sfm			High speed steel
		Cemented carbides C7	C6	C5	
< 0.012	0.08	780	620	—	95
0.012-0.020	0.08-0.20	—	560	460	80
0.020-0.040	0.20-0.40	—	295	260	50

Threading

Table 2

Tool	Speed (sfm)
Cemented Carbide (C6-C5)	295-425
High Speed Steel	50-65

Corrosion Resistance

Type 304/304L is a versatile, general purpose stainless steel with good resistance to atmospheric corrosion, to many organic and inorganic chemicals, and to foods and beverages. It has been used in high vacuum processing equipment and specialized instruments where high integrity is essential.

Although improvements in machinability in the past have been associated with reduced corrosion resistance, PRODEC 304/304L has been shown to have corrosion resistance within the range typically expected of Type 304L stainless steel. Because of its low carbon content, PRODEC 304/304L retains good corrosion resistance in the as-welded condition.

Reaming

Table 3

Ream diameter (in)	Cutting Speed (sfm)		Feed (in/rev)
	Cemented carbide	High speed steel	
< 0.40	165	33-50	0.004-0.008
0.40-0.80	165	33-50	0.012
> 0.80	165	33-50	0.012-0.016

Coolant/lubricant: emulsion or cutting oil

Cut Off

Table 4

Tool	Speed (sfm)	Feed (in/rev)
Cemented Carbide (C5)	330-490	0.004-0.008
High Speed Steel	80	0.002

Drilling — High Speed Steel Twist Drills

Table 5

Drill diameter (in)	Speed		Feed (in/rev)
	rpm	fm	
0.04	3200-3800	33-38	0.002
0.12	1600-1800	50-57	0.004
0.20	1080-1270	57-66	0.008
0.40	540-640	57-66	0.012
0.60	360-430	57-66	0.014
0.80	270-320	57-66	0.016
1.20	180-220	57-66	0.018

Notes:

1. Cutting Fluid: Ample flow of 10% emulsion coolant.
2. With short NC drills, feed can be increased about 40%.
3. When hole depth exceeds 4x diameter, clear chips from hole.
4. With TiN-Coated HSS drills, speed can be increased 10%.
5. For rotating drill and fixed workpiece, as in drilling a hole in a plate, the maximum speed should not exceed 50 sfm.

Drilling — Indexable insert drills, cemented carbides

Table 6

Drill diameter (in)	Speed (sfm)	Feed (in/rev)	Type of carbide	
			Center	Periphery
0.80	655-820	0.004	C6	C7
1.20	655-820	0.005	C6	C7
1.60	655-820	0.006	C6	C7
2.00	655-820	0.008	C6	C7

Notes:

Cutting Fluid—Pressure: >44 psi; Amount: > 6.5 gal/min

Cutting data for indexable insert drills are highly dependent on the make of drill; the manufacturer's recommendations should be considered.

Machinability

PRODEC 304/304L is melted to a closely controlled chemistry and ladle-treated to achieve control of the composition, amount, size, shape, and distribution of the nonmetallic inclusions (sulfides and oxides) normally occurring within a standard stainless steel. These inclusions provide for chip breaking and for reduced wear of carbide tooling at high machining speeds. PRODEC 304/304L permits higher machining speeds, longer tool life, and superior part quality with reduced total cost for finished parts.

The following tables give some speeds and feeds obtained in tests for PRODEC 304/304L, providing guidelines for possible adaptation to particular machining programs. The data provided are based on achieving tool lives of 15 minutes for cemented carbides and 60 minutes for high speed tool steels.

Mechanical Properties at Room Temperature

Table 7

	Typical*	ASTM	
		304	304L
Ultimate Tensile Strength, ksi	99	75 min	70 min
0.2% Offset Yield Strength, ksi	48	30 min	25 min
Elongation in 2 inches, %	52	40 min	40 min
Reduction in Area, %	61	—	—
Hardness, Rockwell B	85	96 max	92 max

*0.375 inch plate

Chemical Composition, wt. pct. Table 8

	PRODEC 304	PRODEC 304L
Carbon	0.030 max	0.030 max
Manganese	2.00 max	2.00 max
Phosphorus	0.045 max	0.045 max
Sulfur	0.030 max	0.030 max
Silicon	0.75 max	0.75 max
Chromium	18.0-20.0	18.0-20.0
Nickel	11.0-15.0	11.0-15.0
Molybdenum	3.0-4.0	3.0-4.0
Nitrogen*	0.10 max	0.10 max

*flat-rolled products only

Physical Properties Table 9

Density, lb/in ³	0.285
Modulus of Elasticity, psi	29 x 10 ⁶
Coefficient of Thermal Expansion, 68-212°F, /°F	8.9 x 10 ⁻⁶
Thermal Conductivity, Btu/ft hr°F	8.7
Heat Capacity, Btu/lb°F	0.12
Electrical Resistivity, Ω-inch	33.5 x 10 ⁻⁶

Heat treatment

Annealing

PRODEC 304/304L should be heated to 1900°F minimum and water quenched or rapidly cooled by other means. PRODEC 304/304L cannot be hardened by heat treatment.

Workability

Cold Working

PRODEC 304/304L is readily formed and fabricated through a full range of cold working operations. It can be used in heading, drawing, bending, and upsetting. Any cold working operations will increase the strength and hardness of the material, and may leave it slightly magnetic.

Hot Working

PRODEC 304/304L can be forged in the 1700-2200°F range. For maximum corrosion resistance, forgings should be annealed at 1900°F minimum and water quenched or rapidly cooled by other means after hot working operations.

Milling

Table 10

Operation	Cemented carbide			High speed steel	
	Speed (sfm)	Feed (in/tooth)	Type of carbide	Speed (sfm)	Feed (in/tooth)
Face Milling	490-820	0.006-0.012	C7-C6	80-100	0.005-0.008
Side Milling	590-790	0.010-0.012	C7-C6	80-100	0.005-0.008
End Milling	490-720	0.004-0.008	C7-C6	80-100	0.001-0.006
End Milling (Solid cemented carbide)	165-330	0.002-0.008	C5	—	—

Corrosion performance of stainless steels

Table 11 compares Type 304 with other stainless steels in a variety of common corrosive environments. The table shows the lowest temperature at which the corrosion rate exceeds 5 mpy. All testing was done in accordance with the requirements of the Materials Technology Institute of the Chemical Process Industries (MTI).

Welding

PRODEC 304/304L is readily welded by a full range of conventional welding procedures (except oxyacetylene). AWS E308L/ER308L filler metals should be used with PRODEC 304/304L steel, but the molybdenum-containing austenitic stainless steel filler metals may also be considered.

Lowest Temperature (°F) at Which the Corrosion Rate Exceeds 5 mpy

Table 11

Corrosion Environment	654 SMO®	254 SMO®	904L	Type 316L (2.7 Mo)	Type 304	Outokumpu 2507	2205 Code Plus Two®	Outokumpu 2304
0.2% Hydrochloric Acid	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling
1% Hydrochloric Acid	203	158	122	86	86p	>Boiling	185	131
10% Sulfuric Acid	158	140	140	122	—	167	140	149
60% Sulfuric Acid	104	104	185	<54	—	<57	<59	<<55
96% Sulfuric Acid	86	68	95	113	—	86	77	59
85% Phosphoric Acid	194	230	248	203	176	203	194	203
10% Nitric Acid	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling
65% Nitric Acid	221	212	212	212	212	230	221	203
80% Acetic Acid	>Boiling	>Boiling	>Boiling	>Boiling	212p	>Boiling	>Boiling	>Boiling
50% Formic Acid	158	212	212p	104	≤50	194	194	59
50% Sodium Hydroxide	275	239	Boiling	194	185	230	194	203
83% Phosphoric Acid + 2% Hydrofluoric Acid	185	194	248	149	113	140	122	95
60% Nitric Acid + 2% Hydrochloric Acid	>140	140	>140	>140	>140	>140	>140	>140
50% Acetic Acid + 50% Acetic Anhydride	>Boiling	>Boiling	>Boiling	248	>Boiling	230	212	194
1% Hydrochloric Acid + 0.3% Ferric Chloride	>Boiling, p	203ps	140ps	77p	68p	203ps	113ps	68p
10% Sulfuric Acid + 2000ppm Cl ⁻ + N ₂	149	104	131	77	—	122	95	<55
10% Sulfuric Acid + 2000ppm Cl ⁻ + SO ₂	167	140	122	<<59p	—	104	<59	<<50
WPA1, High Cl ⁻ Content	203	176	122	≤50	<<50	203	113	86
WPA2, High F ⁻ Content	176	140	95	≤50	<<50	167	140	95

ps = pitting can occur
ps = pitting/crevice corrosion can occur

WPA	P ₂ O ₅	Cl ⁻	F ⁻	H ₂ SO ₄	Fe ₂ O ₃	Al ₂ O ₃	SiO ₂	CaO	MgO
1	54	0.20	0.50	4.0	0.30	0.20	0.10	0.20	0.70
2	54	0.02	2.0	4.0	0.30	0.20	0.10	0.20	0.70

Technical support

New Castle assists users and fabricators in the selection, qualification, installation, operation, and maintenance of PRODEC 304/304L stainless steel. Technical personnel can draw on years of field experience with PRODEC 304/304L to help you make the technically and economically correct materials decision. New Castle is prepared to discuss individual applications and to provide data and experience as a basis for selection and application of PRODEC 304/304L.

New Castle works closely with its distributors to ensure timely availability of PRODEC 304/304L in the sizes, and quantities required by the end user. For assistance with technical questions and to obtain top quality PRODEC 304/304L, please call New Castle at 1-800-349-0023.



New Castle

Stainless Plate, LLC