Cold Heading Wire

Cold heading wire is processed to combine formability and ductility with enduring strength. This makes it ideal for manufacturing fasteners and fixings such as bolts, screws, pins, rivets, studs and tie rods.

Quality

BS Stainless cold heading wire features a blend of characteristics that are vital in the production of fasteners and fixings. They have excellent corrosion resistance, high formability, a good surface finish and low magnetism after heading and threading. We incorporate a high level of inspection and quality control to ensure consistency throughout the wire, resulting in a high-quality product with a longer lasting die life and increased machinability. We also work within the scope of ISO 9001:2015 management system.

Coatings

To ensure maximum performance and efficiency when machining, our cold heading wire can be supplied with a consistent soap coating that enables the forming machines to run efficiently at high speeds.

Other coatings are available depending on our customers' specifications such as metallic coated, copper coated and various others.

Grades

Our cold heading wire is available in a variety of 300 and 400 series. Each grade has its own characteristics. The most common are, 302HQ, a specialised wire grade, largely used for the manufacture of stainless steel fasteners, includes 3% copper to reduce the cold work hardening rate, it is the standard metal for the manufacture of self-tapping screws and light machine screws.

Chemical composition % by mass MAX unless otherwise stated

Type	Name	Number	C	Si	Mn	P	S	N	Cr	Mo	Ni	Others
302HQ	X3CrNiCu18-9-4	1.4567	0.04	1.0	2.0	0.045	0.03	0.11	17.00/19.00	-	8.50/10.50	Cu 3-4
304Cu	X3CrNiCu18-9-4	1.4567	0.04	1.0	2.0	0.045	0.03	0.11	17.00/19.00	-	8.50/10.50	Cu 3-4
304L	X2CrNi18-9	1.4307	0.030	1.0	2.0	0.045	0.015	0.11	17.50/19.50	-	8.00/10.50	-
304J3S	-	-	0.08	1.0	2.0	0.045	0.03	-	17.00/19.00	-	8.50/10.50	Cu 1-3
XM-7	-	-	0.08	1.0	2.0	0.045	0.03		17.00/19.00	-	8.50/10.50	Cu 3-4
305J1	-	-	0.08	1.0	2.0	0.045	0.03	11.0-13.5	16.50/19.00	-	11.00/13.50	Al 0.75-1.50
310	X8CrNi25-21	1.4845	0.1	1.5	2.0	0.045	0.015	0.11	24.00/26.00	-	19.00/22.00	
316	X5CrNiMo17-12-2	1.4401	0.07	1.0	2.0	0.045	0.015	0.11	16.50/18.50	2.00/2.50	10.00/13.00	-
316L	X2CrNiMo17-12-2	1.4404	0.030	1.0	2.0	0.045	0.015	0.11	16.50/18.50	2.00/2.50	10.00/13.00	-
316LCu	-	-	0.03	0.65	1.0	0.03	0.03		18.00-20.00	2.00-3.00	11.00-14.00	-
316Ti	-	-	0.08	0.75	2.0	0.45	0.03	0.1	16.00-18.00	2.00-3.00	10.00-14.00	Ti 5x% (C+N)
321	X6CrNiTi18-10	1.4541	0.08	1.00	2.00	0.045	0.015	-	17.0/19.0	-	9.0/12.0	Ti: 5C/ 0.70
410	X12Cr13	1.4006	0.08/ 0.15	1.00	1.50	0.040	0.015	-	11.5/13.5	-	0.75	-
430	X6Cr17	1.4016	0.08	1.00	1.00	0.040	0.015	-	16.0/18.0	-	-	-

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