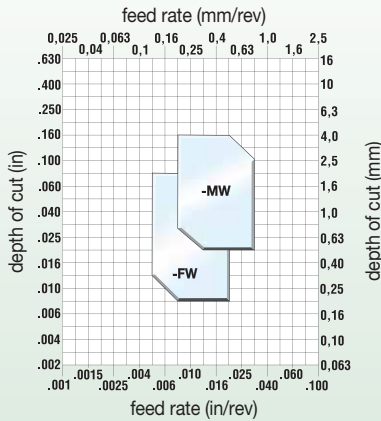# WIDIA™ Victory™ • High-Performance Inserts
Steel • Carbon, Alloy, and Tool Steels up to 450 HB (48 HRC)
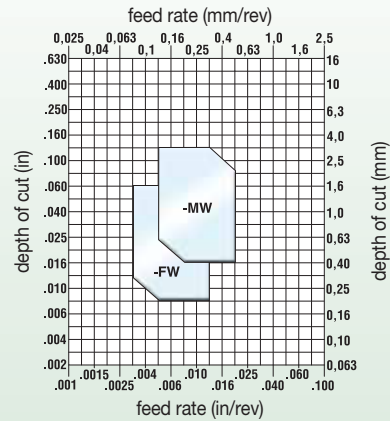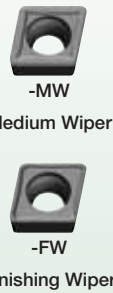
WIDIA

■ Step 1 • Select the insert geometry

WIDIA VICTORY

Negative Wiper Inserts

-MW

Medium Wiper

-FW

Finishing Wiper

Positive Wiper Inserts

-MW

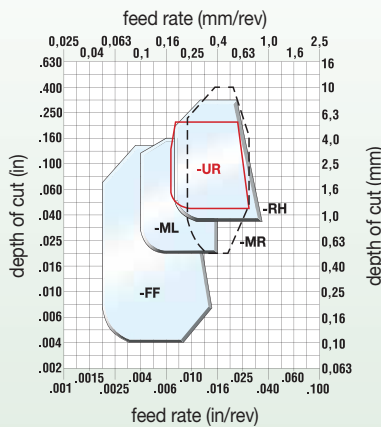Medium Wiper

-FW

Finishing Wiper

■ Step 2 • Select the grade

cutting condition	Negative Insert Geometry		Positive Insert Geometry	
	-FW	-MW	-FW	-MW
heavily interrupted cut	WP15CT	WP25CT	–	WP25CT
lightly interrupted cut	WP15CT	WP25CT	WP15CT	WP25CT
varying depth of cut, casting, or forging skin	WP15CT	WP15CT	WP15CT	WP15CT
smooth cut, pre-turned surface	WP15CT	WP15CT	WP15CT	WP15CT

■ Step 1 • Select the insert geometry

Negative Inserts
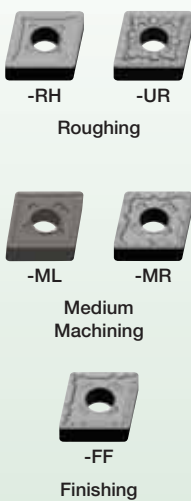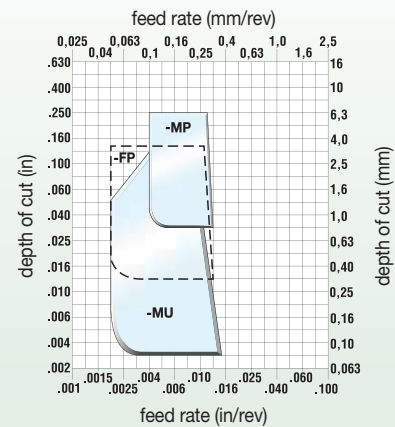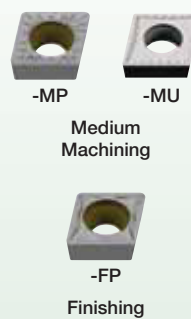
-RH   -UR

Roughing

-ML   -MR

Medium Machining

-FF

Finishing

Positive Inserts

-MP   -MU

Medium Machining

-FP

Finishing

■ Step 2 • Select the grade

cutting condition	Negative Insert Geometry					Positive Insert Geometry		
	-FF	-ML	-MR	-UR	-RH	-FP	-MU	-MP
heavily interrupted cut	WP15CT	WP25CT	WP35CT/ WP25CT	WP35CT	WP35CT	WP25CT/ WS25PT	WP35CT	WM35CT
lightly interrupted cut	WP15CT	WP25CT	WP25CT	WP35CT	WP35CT	WP25CT	WP25CT	WP25CT
varying depth of cut, casting, or forging skin	WP15CT	WP15CT	WP15CT	WP25CT/ WP10CT	WP25CT	WP15CT	WP25CT/ WP10CT	WP15CT
smooth cut, pre-turned surface	WP15CT	WP15CT	WP15CT	WP25CT/ WP10CT	WP25CT	WP15CT	WP25CT/ WP10CT	WP15CT

(continued)

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