

## Classifications

DIN 8555

MF 3-GF-55-T

## Characteristics

Special tool steel iron base alloy designed to resist metal-to-metal wear at medium temperature.

Microstructure: Martensite

Machinability: Good with cubic Nitride Boron tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98 % + Oxygen 2%

## Field of use

Cutting tools, punching tools, forming tools, dies, rebuilding of AISI H-12 tool steel.

## Typical analysis in %

C	Mn	Si	Cr	Mo	W	V	Ti	Fe
0,3	1,2	0,6	5,3	1,9	1,6	0,4	0,05	balance

## Typical mechanical properties

Hardness as welded: 56 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	200-300	25-31	20 max.	12-15