

## Classifications

DIN 8555

MF 3-GF-60-T

## Characteristics

Metal cored wire designed to repair and hardface tool steel parts working at high temperature. The high tungsten content allows the hardness to be maintained up to 600°C.

Microstructure: Martensite

Machinability: Good with cubic Boron Nitride 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

Hot forging tools and dies.

## Typical analysis in %

C	Mn	Si	Cr	Mo	Co	W	V	Fe
0,4	0,5	0,4	1,4	0,5	3,0	9,0	0,4	balance

## Typical mechanical properties

Hardness as welded: 60 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
1,6	250-450	25-31	20 max.	15-18