

Classifications								
DIN 8555								
MF 3-GF-50-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.								
Typical analysis in %								
C	Mn	Si	Cr	Ni	Mo	W	V	Fe
0,28	0,5	0,4	8,5	2,2	2,4	0,3	0,3	balance
Typical mechanical properties								
Hardness as welded: 51 HRC								
Recommended welding parameters								
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]				
1,6	250-450	25-31	20 max.	15-18				