

Classifications							
DIN 8555							
MF 3-GF-45-T							
Characteristics							
Special tool steel Iron base alloy designed to refurbish dies in the automobile industry.							
Microstructure:	Martensite						
Machinability:	Good						
Oxy-acetylene cutting:	Cannot be flame cut						
Deposit thickness:	Depends upon application and procedure used						
Shielding gas:	Argon 98 % + Oxygen 2% or Argon 82% + CO ₂ 18%						
Field of use							
Punching tools, forming tools, dies.							
Typical analysis in %							
C	Mn	Si	Cr	Ni	Mo	V	Fe
0,2	0,7	0,5	10,5	3,0	2,2	0,1	balance
Typical mechanical properties							
Hardness as welded: 45 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			