

Classifications						
DIN 8555						
MF 3-GF-50-T						
Characteristics						
Special tool steel Iron base alloy designed to refurbish forging dies in the automotive industry.						
Microstructure:	Martensite					
Machinability:	Good					
Oxy-acetylene cutting:	Cannot be flame cut					
Deposit thickness:	Depends upon application and procedure used					
Shielding gas:	Argon 82% + CO ₂ 18%					
Field of use						
Punching tools, forming tools, dies.						
Typical analysis in %						
C	Mn	Si	Cr	Ni	Mo	Fe
0,20	0,7	0,5	10,5	3,0	2,2	balance
Typical mechanical properties						
Hardness as welded: 49 HRC						
Recommended welding parameters						
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]		
2,0	250-400	27-32	20 max.	15-18		