

Classifications							
DIN 8555							
MF 3-GF-50-T							
Characteristics							
Special tool steel Iron base alloy designed to refurbish dies in the automobile industry.							
Microstructure:	Martensite						
Machinability:	Good with metallic carbide tipped tools						
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	Mo	W	V	Fe
0,25	0,9	0,6	5,6	2,5	2,4	0,6	balance
Typical mechanical properties							
Hardness as welded: 42 HRC							
Recommended welding parameters							
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]			
1,6	250-400	25-31	20 max.	15-18			
2,0	275-450	25-31	20 max.	18-20			
2,4	300-500	25-31	20 max.	20-22			