

Classifications

DIN 8555

MF 3-GF-40-T

Characteristics

Special tool steel Iron base alloy designed to overlay and repair forging and hot-working die steels.

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% + CO₂ 18 %

Field of use

Die shanks, sow blocks, rams and forging hammer bases.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Fe
0,13	1,6	0,6	2,0	2,7	0,9	balance

Typical mechanical properties

Hardness as welded: 40 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	250-400	26-31	20 max.	18-20