

Classifications

DIN 8555

MF 3-GF-55-T

Characteristics

Metal cored wire designed for hardsurfacing of tool steel parts.

Microstructure: Martensite

Machinability: Good with cubic Boron Nitride 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

Hot shear blades, hot punches, hot extrusion dies, cutting dies, stamping dies, mill guides, moulds, sheet punching tools, ingot points plier, plastic injection screws, etc.

Typical analysis in %

C	Mn	Si	Cr	Mo	Ti	Fe
0,35	1,2	0,3	7,5	1,7	0,3	balance

Typical mechanical properties

Hardness as welded: 55 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