

Classifications

DIN 8555

MF 3-GF-45-T

Characteristics

Special tool steel Iron base alloy designed to refurbish dies in 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% + CO₂ 18%

Field of use

Punching tools, forming tools, dies.

Typical analysis in %

C	Mn	Si	Cr	Mo	W	V	Fe
0,21	0,6	0,5	5,4	2,5	2,2	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]
1,2	200-300	25-31	20 max.	12-15