

<b>SK D11-G</b>		tool steels						
<b>Classifications</b>		gas-shielded metal-cored wire						
DIN 8555								
MF 3-GF-55-T								
<b>Characteristics</b>								
Special tool steel iron base alloy designed to resist metal-to-metal wear at medium temperature.								
Microstructure:	Martensite							
Machinability:	Good with cubic Nitride Boron tipped tools							
Oxy-acetylene cutting:	Cannot be flame cut							
Deposit thickness:	Depends upon application and procedure used							
Shielding gas:	Argon 98 % + Oxygen 2 %							
<b>Field of use</b>								
Cutting tools, punshing tools, forming tools, dies, rebuilding of AISI H-12 tool steel.								
<b>Typical analysis in %</b>								
C	Mn	Si	Cr	Mo	W	V	Ti	Fe
0.3	1.2	0.6	5.3	1.9	1.6	0.4	0.05	balance
<b>Typical mechanical properties</b>								
Hardness as welded: 56 HRC								
<b>Form of delivery and recommended welding parameters</b>								
<i>Wire diameter [mm]</i>	<i>Amperage [A]</i>	<i>Voltage [V]</i>	<i>Stick-out [mm]</i>	<i>Gas flow [L/min]</i>				
1.2	200 – 300	25 – 31	20 max.	12 – 15				