

## SK D12S-G

tool steels

### Classifications

Gas-shielded flux-cored wire

DIN 8555

MF 3-GF-55-T

### Characteristics

Flux-cored wire designed for hard-surfacing 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 % or Argon 82 % + CO<sub>2</sub> 18 %

### 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.

### Typical analysis in %

C	Mn	Si	Cr	Mo	Ti	Fe
0.38	1.2	0.5	7.5	1.7	0.25	balance

### Typical mechanical properties

Hardness as welded: 56 HRC

### Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
2.4	275 – 500	25 – 31	20 max.	18 – 20