

SK D15-G

tool steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 3-GF-60-T

Characteristics

Metal-cored wire designed to repair and hardface tool steel parts working at high temperature. The high tungsten content allows the hardness to be maintained up to 600 °C.

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 forging tools and dies.

Typical analysis in %

C	Mn	Si	Cr	Mo	Co	W	V	Fe
0.4	0.5	0.4	1.4	0.5	3.0	9.0	0.4	balance

Typical mechanical properties

Hardness as welded: 60 HRC

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
1.2	200 – 300	25 – 31	20 max.	12 – 15
1.6	250 – 450	25 – 31	20 max.	15 – 18

FCAW-G – gas-shielded cored wires

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