

SK D16-G		tool steels						
Classifications		gas-shielded metal-cored wire						
DIN 8555								
MF 3-GF-50-T								
Characteristics								
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 %							
Field of use								
Cutting tools, punching tools, forming tools, dies.								
Typical analysis in %								
C	Mn	Si	Cr	Ni	Mo	W	V	Fe
0.28	0.5	0.4	8.5	2.2	2.4	0.3	0.3	balance
Typical mechanical properties								
Hardness as welded: 51 HRC								
Form of delivery and recommended welding parameters								
<i>Wire diameter [mm]</i>	<i>Amperage [A]</i>	<i>Voltage [V]</i>	<i>Stick-out [mm]</i>	<i>Gas flow [L/min]</i>				
1.6	250 – 450	25 – 31	20 max.	15 – 18				