

SK D20-G

tool steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 4-GF-60-S

Characteristics

Special alloy designed to deposit a molybdenum-alloyed high-speed steel. To avoid cracking, a minimum interpass temperature of 300 °C should be applied.

Microstructure: Precipitated fine carbides in a martensitic matrix

Machinability: Grinding only

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 edges of carbon steel tools, cold shear blades, lathe tools, guides, milling cutter, punching, drilling and stamping tools.

Typical analysis in %

C	Mn	Si	Cr	Mo	W	V	Fe
1.2	0.4	0.4	4.5	8.0	1.8	1.7	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	26 – 30	20 max.	12 – 15
1.6	250 – 450	26 – 30	20 max.	15 – 18

FCAW-G – gas-shielded cored wires

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