

SK D250-G

tool steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 1-GF-350

Characteristics

Special alloy suitable for repair of tool steel parts working at high temperatures. The deposit is particularly resistant against cracks propagation.

Microstructure: Bainite + Martensite

Machinability: Good

Oxy-acetylene cutting: Possible

Deposit thickness: No restriction

Shielding gas: Argon 82% + Oxygen 18%

Field of use

Large casting parts, forging matrix, etc.

Typical analysis in %

C	Mn	Si	Cr	Ni	Fe
0.09	0.8	0.3	2.9	2.4	balance

Typical mechanical properties

Hardness as welded: 330 HB

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
1.6	200 – 280	26 – 31	20 max.	15 – 20

FCAW-G – gas-shielded cored wires

267