

SK D33-G

tool steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 6-GF-50-C

Characteristics

Special alloy designed for the repair and the hard-surfacing of extrusion tools.

Microstructure: Martensite

Machinability: By grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98 % + Oxygen 2 % or Argon 100 %

Field of use

Gum mixer shell.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Co	W	V	Fe
0.25	1.0	0.6	11.0	0.3	1.1	1.7	0.8	0.9	balance

Typical mechanical properties

Hardness as welded: 50 HRC

Form of delivery and recommended welding parameters

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