

SK D37-G

tool steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 3-GF-45-T

Characteristics

Special tool steel Iron base alloy designed to refurbish dies in the automobile industry.

Microstructure: Martensite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98 % + Oxygen 2 % or Argon 82 % + CO₂ 18 %

Field of use

Punching tools, forming tools, dies.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	V	Fe
0.2	0.7	0.5	10.5	3.0	2.2	0.1	balance

Typical mechanical properties

Hardness as welded: 45 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