

SK D37S-G

tool steels

Classifications

Gas-shielded flux-cored wire

DIN 8555

MF 3-GF-50-T

Characteristics

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

Microstructure: Martensite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon + CO₂ 18%

Field of use

Punching tools, forming tools, dies.

Typical analysis in %

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

Typical mechanical properties

Hardness as welded: 49 HRC

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
2.0	250 – 400	27 – 32	20 max.	15 – 18

FCAW-G – gas-shielded cored wires

263