

SK D40-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 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 or Argon 82 % + CO ₂ 18 %						
Field of use							
Punching tools, forming tools, dies.							
Typical analysis in %							
C	Mn	Si	Cr	Mo	W	V	Fe
0.21	0.6	0.5	5.4	2.5	2.2	0.6	balance
Typical mechanical properties							
Hardness as welded: 42 HRC							
Form of delivery and recommended welding parameters							
<i>Wire diameter [mm]</i>	<i>Amperage [A]</i>	<i>Voltage [V]</i>	<i>Stick-out [mm]</i>	<i>Gas flow [L/min]</i>			
1.2	200 – 300	25 – 31	20 max.	12 – 15			