

SK D40S-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 dies in the automobile industry.

Microstructure: Martensite

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82%+ CO₂ 18%

Field of use

Punching tools, forming tools, dies.

Typical analysis in %

C	Mn	Si	Cr	Mo	W	V	Fe
0.25	0.9	0.6	5.6	2.5	2.4	0.6	balance

Typical mechanical properties

Hardness as welded: 42 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 – 400	25 – 31	20 max.	15 – 18
2.0	275 – 450	25 – 31	20 max.	18 – 20
2.4	300 – 500	25 – 31	20 max.	20 – 22

FCAW-G – gas-shielded cored wires

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