

SK D52-G		tool steels				
Classifications		gas-shielded metal-cored wire				
DIN 8555						
MF 3-GF-40-T						
Characteristics						
Special tool steel Iron base alloy designed to overlay and repair forging and hot-working die steels.						
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 % + CO ₂ 18 %					
Field of use						
Die shanks, sow blocks, rams and forging hammer bases.						
Typical analysis in %						
C	Mn	Si	Cr	Ni	Mo	Fe
0.13	1.6	0.6	2.0	2.7	0.9	balance
Typical mechanical properties						
Hardness as welded: 40 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>		
1.6	250 – 400	26 – 31	20 max.	18 – 20		