

SK D8-G

tool steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 3-GF-40-T

Characteristics

Special alloy designed for the repair and the hard-surfacing of tools working at low and high temperatures. The resistance to thermal shocks, mechanical stresses and adhesive wear is maintained up to 500 – 550 °C.

Microstructure: Martensite

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Can be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98 % + Oxygen 2 %

Field of use

Cold shear blades, hot punches, hot extrusion dies, mill guides, moulds, camshafts.

Typical analysis in %

C	Mn	Si	Cr	W	V	Fe
0.1	1.1	0.4	2.4	3.8	0.6	balance

Typical mechanical properties

Hardness as welded: 38 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