

**Classifications**

Gas-shielded flux-cored wire

DIN 8555

MF 3-GF-45-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: Cannot 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	0.5	2.4	3.5	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]
1.6	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