SK D12S-G

gas shielded flux cored wire

Classifications

DIN 8555

MF 3-GF-55-T

Characteristics

Flux cored wire designed for hardsurfacing of tool steel parts.

Microstructure:	Martensite
Machinability:	Good with cubic Boron Nitride tipped tools
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

Hot shear blades, hot punches, hot extrusion dies, cutting dies, stamping dies, mill guides, moulds, sheet punching tools, ingot points plier, plastic injection screws.

Typical analysis in %

C	Mn	Si	Cr	Mo	Ti	Fe
0,38	1,2	0,5	7,5	1,7	0,25	balance

Typical mechanical properties

Hardness as welded: 56 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
2,4	275-500	25-31	20 max.	18-20

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.