

Standards	Material No.	≈ 1.2662
	DIN 8555	MF3-GF-50-ST

Characteristics This C-, Cr-, V-, W- alloyed cored wire electrode is suitable for repair and build - up applications on hot working steels of similar or lower alloyed hot working tools. The weld deposit is machinable, heat treatment is possible and has a retention of hardness up to 550°C.

Typical applications Forging dies, hot shear blades

Recommendations for welding and heat treatment Preheating- and interpass temperature should be held between 300 and 450°C, depending on the base metal and its heat abduction. The upper temperature limit should be chosen for thick work pieces. Low-tension welding and low heat input are essential for a good welding result.. Slowly cool down in sand or oven.

Hardness (typical values)	as welded	heat treated 2 h at 530° C cooling down by air	soft annealed 2 h at 800-850°C cooling down by furnace
	55 HRc	. 58 HRc	250 HB

Weld metal analysis (typical, wt. %)	C	Cr	W	Co	V
	0,3	2,5	7,0	2,0	0,3

Gas types EN 439 M13: 99% Argon for 1% Oxygen

Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form		
	1,2	3/64	19 - 22	120 - 220		G	
	1,6	1/16	20 - 26	160 - 260	O	G	
	2,0	5/64	22 - 27	220 - 280	O	G	
	2,4	3/32	24 - 28	260 - 340	O	G	S
	2,8	7/64	25 - 29	300 - 400	O		S
	3,2	1 / 8	26 - 30	320 - 460			S

Delivering form
O = Flux cored wire self shielding
G = Flux cored wire for shielded arc welding
S = Flux cored wire for submerged arc welding

Coils, weight B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150 / 300 kg

Rev. 000