

Classifications								
DIN 8555				EN 14700				
MF 3-GF-55-T				TZ Fe8				
Characteristics								
Special tool steel iron base alloy designed to refurbish dies in automobile industry.								
Microstructure:		Martensite						
Machinability:		Good						
Oxy-acetylene cutting:		Cannot be flame cut						
Deposit thickness:		Depends on application and procedure used						
Shielding gas:		Argon 98% + Oxygen 2% or Argon 82% + CO ₂ 18%						
Field of use								
Punching tools, forming tools, dies.								
Typical analysis in %								
C	Mn	Si	Cr	Mo	W	V	Ti	Fe
0,27	0,6	0,5	6,0	2,8	2,4	0,6	0,1	balance
Typical mechanical properties								
Hardness as welded: 53 HRC								
Recommended welding parameters								
Wire diameter [mm]	Amperage [A]	Voltage [V]		Stick-Out [mm]	Gas-Rate [l/min]			
1,6	250-450	25-31		20 max.	15-18			