

<b>Standards</b>	Material No.	1.2567
	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

<b>Base materials</b>	1.2365	G-X 32 CrMoV 3 3	1.2713	G 55 NiCrMoV 6
	1.2567	30 WCrV 17-2	1.2714	GS 56 NiCrMoV 7
	1.2581	X 30 WCrV 9-3		

**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.

<b>Hardness</b> ( typical values)	as welded	heat treated at 560° C	heat treated at 450° C	heat treated at 350° C	soft annealed 2 h at 800-840°C
	47 HRc	. 52 HRc	49 HRc	48 HRc	250 HB

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Cr</b>	<b>W</b>	<b>V</b>
	0,3	2,5	4,2	0,6

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

**Current** = +

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

**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

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