

PRODUCT DATA SHEET

Tube Alloy 258-G

Tube Alloy 258-G is a metal cored, gas shielded wire depositing a martensitic alloy steel of the H-12 tool steel type. It has excellent resistance to adhesive metal-to-metal wear as well as good resistance to impact and abrasion. It will maintain its hardness up to 500°C.

Applications

Tube Alloy 258-G is suitable for use on clean out rings, die holders, dummy blocks, extrusion dies, forming dies, forging dies, header dies, hot forming dies, gripper dies, guide rolls, mandrels and swaging dies. It can also be used in submerged arc welding with a neutral flux.

Classifications

DIN	8555	MF6-GF-55-G
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Typical Chemical Analysis (All weld metal)

% Carbon	0,4	% Molybdenum	1,45
% Manganese	1,0	% Tungsten	1,25
% Silicon	0,55	% Vanadium	0,4
% Chromium	5,0		

Typical Mechanical Properties

Abrasion Resistance	Good
Impact Resistance	Good
Machinability	Grind only
Flame Cutting	Difficult
Microstructure	Martensitic
Magnetic	
Heat treatable and forgeable	

Typical Hardness

Layer	As Deposited on A36 Plate	Tempered 10 hr @ 500°C
1	52 HRc	-
2	53 HRc	-
3	57 HRc	54

Welding Data

(DC+)

Diameter (mm)	Current		Electrode Stick Out	Deposition Rate (kg/hr)
	Amps (A)	Volts (V)		
1,2	160 - 190	24 - 25	13 - 25	3,2
1,6	275 - 350	24 - 27	25 - 38	4,5

Packing Data

Diameter (mm)	Spool Mass (kg)	Spool Type	Item Number
1,2	11,3	Spool	W077071
1,6	11,3	Spool	W077078

Recommended shielding gas: Stainshield®

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