

TECHNICAL DATA

Standards

DIN Material Nr. 1.2343

EN ISO 14700 :	S Fe3
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General Properties / Field of Applications

DSI M 55Plus is a Laser Welding Wire for high temperature hard face welding on cold and hot work tools which heavily stressed of pressure, friction and moderate impact stress especially Thixomolding. Operating temperatures up to 550°C. Application e.g. for continuous casting rollers, hot shear blades, die casting molds etc. Applicable for nitride coating.

Mechanical Properties

Hardness untreated	[HRC]	55 - 60
Hardness soft annealed	[HB]	230
Tensile strength R _m	[MPa] / [N/mm ²]	≈1,300

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Mo	V
0.38	1.0	0.4	5.0	1.1	0.45

Compatible Materials (Selection)

S55C / SKD61 / KP4M / Z38CDV5 / S50C / DAC10 / M310 / DH3-15 / DHA1
Toolox44 / 1.2343 / 1.2344 / 1.2479 / 1.2767

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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