



Molds & Dies

LASER WELDING WIRES

DSI LASER SERVICE (THAILAND) CO.,LTD.



dsilaser.com





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DSI Laser Wires Catalog
Molds & Dies

Edition 05/2025

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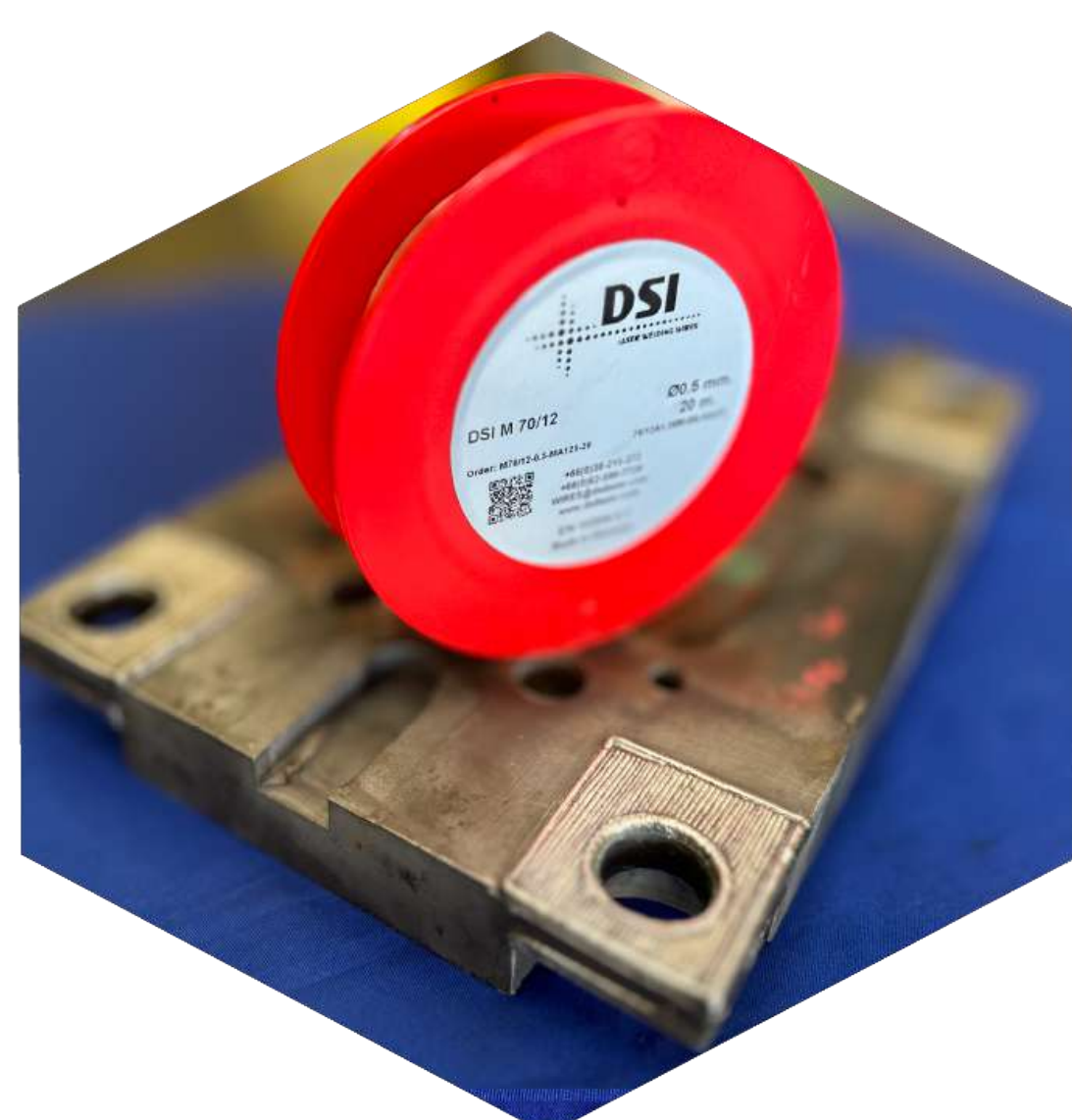
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Committed to Quality

DSI Laser Wires are ...



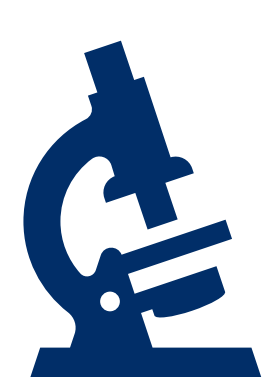
Made in Germany



Drawn-down by DSI-Thailand



Incoming inspection by XRF (X-ray fluorescence) for to determine and confirm the elemental composition



Randomly checks of Hardness Vickers (HV 0.3) by third party



Available in different diameters on spools and as rods



Vacuum packed and corrosion protected



EN 10204 / 3.1 Quality Certified



Obtainable for customers in whole Southeast Asia and beyond

“The selection of the appropriate Laser Wire is a major factor to provide premium weld quality”

25 years experience in Pulse Laser Welding



MADE IN GERMANY



GERMAN WELDING
SOCIETY

EN 10204 / 3.1 Quality Certified

Molds & Dies Laser Wires - Material Groups



DSI Laser Wires

Molds & Dies

Applications



DSI M 10



DSI M 20Plus



DSI M 70/12



DSI M AluCF

TECHNICAL DATA

Standards

DIN Material Nr. 1.5424

EN ISO 21952-A :	G Mo Si
AWS A5.28 :	ER80S-G

General Properties / Field of Applications

DSI M 90 is a martensitic Laser Welding Wire made of low-alloy steel containing molybdenum for welding of 16Mo3 and similar high-temperature steels. Operating temperatures up to 500°C (short-term up to 550°C). The weld is carburisable, resistant to ageing and alkali cracking and applicable for nitride coating. High performance in etching surfacing process, mirror surface finishing.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	530
Tensile strength R_m	[MPa] / [N/mm ²]	640
Elongation A ($L_0 = 5d_0$)	[%]	27

Chemical Composition (Standard Values in %)

C	Si	Mn	Mo
0.1	0.6	1.1	0.5

Compatible Materials (Selection)

16Mo3 / 20MnMoNi4-5 / 15NiCuMoNb5 / S235JR-S355JR / S450JO / S355J2
NAK55 / NAK 80 / HPM50 / 40CMD8S / 40CMD8 / SP300 / M238 / MAS1C / P20
PX-5 / EM38 / SPM-20 / FC25 / N238 / MP20 / KD20 / S50C/ Toolox33 / M300
S136 / DH2FP20 / M300 / S136 / DH2F / 1.2311 / 1.2312 / 1.2738 / 1.2767

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

wires@dsilaser.com



TECHNICAL DATA

Standards

DIN Material Nr. 1.5424

EN ISO 21952-A	G Mo Si
AWS A5.28	ER80S-G

General Properties / Field of Applications

DSI M 90PK is a martensitic Laser Welding Wire wire which has developed from DSI M 90 Laser Welding wire. Its provide a higher proof and tensile strength. Its carburisable, aging resistant and its perform up to 550°C heat resistant. Beside its provide high performance in etching surfacing process and mirror surface finishing. The wire is applicable for carburising and nitride coating.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	570
Tensile strength R_m	[MPa] / [N/mm ²]	680
Elongation A ($L_0 = 5d_0$)	[%]	28

Chemical Composition (Standard Values in %)

C	Si	Mn	Mo	Fe
0.1	0.6	1.4	0.5	Rest

Compatible Materials (Selection)

NAK55 / HPM50 / 40CMD8S / 40CMD8 / SP300 / M238 / MAS1C / P20 / M300
PX-5 / EM38 / SPM-20 / FC25 / N238 / MP20 / KD20 / S50C/ Toolox33
S136 / DH2FP20 / M300 / S136 / DH2F / 1.2311 / 1.2312 / 1.2738

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

wires@dsilaser.com

TECHNICAL DATA

Standards

DIN Material Nr. 1.4115

EN ISO 14343-A :	G Z17Mo
DIN 8555 :	MSG 6-GZ-45-ZR
AWS A5.9 :	ER430 mod.

General Properties / Field of Applications

DSI M 20 is a martensitic Laser Welding Wire for corrosion and scale resistant chromium steel. Heat and scale resistant up to 900°C, temperature resistant up to 550°C. High resistance against abrasion, adhesion, cavitation and combined wear mechanism. Corrosion resistance against many saline solution, particularly sea water.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	490
Tensile strength R_m	[MPa] / [N/mm ²]	690
Elongation A ($L_0 = 5d_0$)	[%]	15
Hardness	[HRC]	35 - 45

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Ni	Mo
0.21	0.4	0.3	17.5	0.5	1.1

Compatible Materials (Selection)

STAVAX / MIRRAX / HPM38 / Z35CD17S / Cobalt68 / M310 / X50CrMoV15
1.2083 / 1.2316 / 1.2082 / 1.2085 / 1.4057 / 1.4125 / AISI 440A / AISI 420

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

wires@dsilaser.com



TECHNICAL DATA

Standards

DIN Material Nr. 1.4122

EN ISO 14343-A :	G Z17MoH/G
DIN 8555 :	MSG 6-GZ-50-ZR
AWS A5.9 :	ER430 mod.

General Properties / Field of Applications

DSI M 20Plus is a Laser Welding Wire with 17.5% Cr-Alloy, corrosion resistance. For joining and deposit welding on homogeneous or similar alloyed. For depositing stainless sealing surfaces on gas, water and steam fittings made of unalloyed or low-alloy steels and cast steels for operating temperatures up to 500°C. High heat resistance, wear resistant, seawater and scale resistant up to 900°C.

Mechanical Properties

Yield strength R _{p0.2}	[MPa] / [N/mm²]	550 (after HT 760°C/2hrs)
Tensile strength R _m	[MPa] / [N/mm²]	900 (after HT 760°C/2hrs)
Elongation A (L ₀ = 5d ₀)	[%]	12 (after HT 760°C/2hrs)
Hardness untreated	[HRC]	47 - 52

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Mo	Ni
0.4	0.5	0.5	17.5	1.0	0.5

Compatible Materials (Selection)

STAVAX / KSP1 / HPM38 / KTSM60 / SUS420J2 / STAVAX (Edge and hard areas)
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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

wires@dsilaser.com



TECHNICAL DATA

Standards

DIN Material Nr. 1.4542

EN ISO :	-
AWS A5.9 :	ER630

General Properties / Field of Applications

DSI M Connect 2 is a Chromium-Nickel steel Laser Welding Wire. Suitable for precipitation hardening. Use for medical industry, space and aerospace (MRO) industry, power generation, turbine components and pumps industry.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	≥725
Tensile strength R_m	[MPa] / [N/mm ²]	≥930
Elongation A ($L_0 = 5d_0$)	[%]	≥5
Hardness	[HRC]	35 - 40

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb
0.03	0.4	0.6	16.3	4.8	0.2	3.5	0.2

Compatible Materials (Selection)

SUS630 (medical grade) / Stainless steel / 1.0204 / 1.4542 / S17400 Type 630
17-4PH / 15-5PH / 410 / 420 / 400C / 904L / 304 / 316 / 347 / D2 / H13 / A2
1.4525 (GX5CrNiCu16-4) / 1.4542 (X5CrNiCuNb16-4) / 1.4548 (X5CrNiCuNb17-4-4)
J92180 Gr. CB Cu-1 / SAE J467 / Precipitation-hardenable forged and cast steels

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

wires@dsilaser.com



TECHNICAL DATA

Standards

DIN Material Nr. 1.4718

DIN EN 14700 :	S Fe8
DIN 8555 :	MSG 6-GZ-60-S

General Properties / Field of Applications

DSI M 10 is a ferritic stainless steel Laser Welding Wire with heat strength up to 500°C, scale resistant up to 800°C. High wear resistance against adhesive and abrasive. Highly wear resistant on cutting, bending, forming tools. Used for crack-, cut-, and abrasion-resistant. Deposit welding on wear parts which are exposed to heavy impact and medium abrasion stress, e.g. rock processing plants, mining-, cement- and steelworks. The weld metal can only be machined by grinding.

Mechanical Properties

Hardness untreated	[HRC]	58-60
Soft annealed (780°C - 820°C, 2-4 hr)	[HRC]	27
Hardened (compressed air 1,180°C - 1,220°C)	[HRC]	63
Tempered twice (540°C - 560°C, 1hr, air)	[HRC]	65

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr
0.5	3.0	0.4	9.2

Compatible Materials (Selection)

SKD11 / HPM31 / GGG70L / DC53 / SKH51 / Z160CDV12 / 1.4724 / 1.4841

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

wires@dsilaser.com



TECHNICAL DATA

Standards

DIN Material Nr. 1.3348

DIN EN 14700 :	S Fe4
AWS A5.21 :	ERFe-6 mod.

General Properties / Field of Applications

DSI M 10Plus is a martensitic Chrome steel Laser Welding Wire with good heat strength up to 500°C. Scale resistant up to 800°C. High resistance against adhesive and abrasive wear. Resists impact stress and hardenable. For highly wear resistant welding on cutting and bending tools. Weld can be machined after soft annealing, otherwise only machinable by grinding.

Mechanical Properties

Hardness untreated	[HRC]	55 - 63
Soft annealed (780°C - 820°C, 2-4 H)	[HRC]	27
Hardened (compressed air 1,180°C - 1,220°C)	[HRC]	63
Tempered twice (540°C-560°C, 1H, air)	[HRC]	65

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Mo	V	W
1.0	0.4	0.3	3.9	8.4	1.9	1.8

Compatible Materials (Selection)

SKD11 / HPM31 / GGG70L / DC53 / SKH51 / Z160CDV12 / Vanadis23 / Vanadis30
ASP23 / ASP30 / Toolox33 / High speed cutting tools / 1.2379 / 1.2363 / 1.2080

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

wires@dsilaser.com



TECHNICAL DATA

Standards

DIN Material Nr. 1.2567

EN 14700 :	S Fe3
JIS :	SKD5 (similar but not identical)

General Properties / Field of Applications

DSI M 55 is a Laser Welding Wire for wear resistant and crack repairing on hot work tools which has stressed of friction, impact and pressure e.g. die casting and plastic molds, press sleeves, press disks, press or impact dies, punches, upsetting tools. For welding on both hot and cold tools with universal applicable using. Best compromising between hardness and crack resistance in even hot work.

Mechanical Properties

Hardness untreated	[HRC]	42 - 46
Hardness soft annealed	[HB]	230
Hardened 1,080°C/Oil	[HRC]	52
Tempered 600°C	[HRC]	48

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	V	W
0.2	0.2	0.3	2.4	0.6	4.5

Compatible Materials (Selection)

S55C / SKD61 / KP4M / Z38CDV5 / S50C / DAC10 / M310 / DH3-15 / DHA1 / 8407
Toolox44 / 1.2343 / 1.2344 / 1.2479 / 1.2767 / AISI H13 / X40CrMoV5-1 / BH13

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

wires@dsilaser.com

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

wires@dsilaser.com



TECHNICAL DATA

Standards

DIN Material Nr. 1.6356

EN 14700 :	S ZFe5
DIN 8556 :	W/MSG 3-GZ-350-T

General Properties / Field of Applications

DSI M 70/12 is a high-alloy, maraging steel Laser Welding Wire used for Aluminium die-casting molds and trimming tools. Good capable of being machine. Applicable for Nitride coating. For high stressed cold and hot work tools. Best for high pressure hot wear resistance, crack repairing, good machinability after welded and wear resistance upgrading is available after artificial aging.

Mechanical Properties

Hardness of filler material at 20°C	[HRC]	32-35
Hardness after artificial aged 3-4 H	[HRC]	50-54
Yield strength R _{p0.2}	[MPa] / [N/mm ²]	885
Tensile strength R _m	[MPa] / [N/mm ²]	980

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Mo	Ni	Co	Ti
0.01	0.4	0.1	0.2	4.0	18.0	12.0	1.6

Compatible Materials (Selection)

Maraging steel / SKD61 / MAS1C / 1.2343 / 1.2344 / AISI H13 / BH13 / 8407 DHA1
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Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 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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EN 10204 / 3.1 Quality Certified



e-version

Steel High Alloyed
Hardfacing

EN 10204 / 3.1

TECHNICAL DATA

Standards

DIN Material Nr. 2.4831 / Brand Name : Inconel 625

EN ISO 18274	S Ni 6625 (NiCr22Mo9Nb)
AWS A5.14	ERiCrMo-3

General Properties / Field of Applications

DSI M NiCr625 is a Nickel-based Laser Welding Wire, corrosion and oxidation resistant. For welding of same and similar nickel-based alloys. Suitable for operating temperatures from -196°C up to +1000°C. Due to the risk of embrittlement between 600°C and 850°C, use in this temperature range should be avoided. For welding on heat shields, seawater applications, gas turbine engine ducting and other heat and corrosion affected applications.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	500
Tensile strength R_m	[MPa] / [N/mm ²]	760
Hardness	[HRC]	26-30
Elongation A ($L_0 = 5d_0$)	[%]	35

Chemical Composition (Standard Values in %)

Ni	C	Cr	Mo	Mn	Si	Nb + Ta	Fe
Base	0.02	22.0	9.0	0.2	0.2	3.3	1.5

Compatible Materials (Selection)

Inconel 625 / Cast iron / NiCrMo-alloys like NiCr22Mo9Nb (2.4856) / X8Ni9 (1.5662)
NiCrofer 4221hMo / Hastelloy G / Hastelloy G3 / Incoloy 800 / UNS N06625

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

wires@dsilaser.com

TECHNICAL DATA

Standards

DIN Material Nr. 2.1461

EN ISO 24373 :	S Cu 6560 (CuSi3Mn1)
AWS A5.7 :	ERCuSi-A

General Properties / Field of Applications

DSI M 100 is a BeCu-Alloy (bronze) Laser Welding Wire based on copper-silicon alloy, often with alloying elements of iron, nickel and manganese. Mainly used in molds and dies industry and the chemical industry, wherever a wear-resistant, low friction weld surface is required.

Mechanical Properties

Yield strength R _{p0.2}	[MPa] / [N/mm ²]	120
Tensile strength R _m	[MPa] / [N/mm ²]	350
Elongation A (L ₀ = 5d ₀)	[%]	40
Hardness	[HB]	80

Chemical Composition (Standard Values in %)

Cu	Si	Sn	Fe	Mn
Base	2.9	0.01	0.06	0.9

Compatible Materials (Selection)

Beryllium copper / galvanized steel sheets and copper-silicon and copper-manganese alloys of the same type. CuSi2Mn / CuSi3Mn / CuZn5 , CuZn10

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

TECHNICAL DATA

Standards

DIN Material Nr. 3.3548

EN ISO 18273 :	S Al 5183 / AlMg4,5Mn0,7 (A)
AWS A5.10 :	ER5183

General Properties / Field of Applications

DSI M AluCA is a Laser Welding Wire for Magnesium and Manganese alloyed Aluminium with a max. Magnesium content of 5%. It shows an excellent weldability and mechanical strength combined with good corrosion resistance against seawater. For joint and deposition welding of Al-Mg alloys and for Al-casting alloys.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	130
Tensile strength R_m	[MPa] / [N/mm ²]	280
Elongation A ($L_0 = 5d_0$)	[%]	18
Hardness	[HB]	85

Chemical Composition (Standard Values in %)

Al	Mg	Mn	Cr	Ti
Basic	4.9	0.6	0.1	0.08

Compatible Materials (Selection)

EN AW-5083 (AlMg4.5Mn0,7) / EN AW-5019 (AlMg5) / EN AW-6005A (AlSiMg(A))
EN AW-6061(AlMg1SiCu) / EN AW-6082 (AlSi1MgMn) / EN AW-7020 (AlZn4,5Mg1)

Packaging and available Sizes*

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

* Other dimensions available on request

wires@dsilaser.com



TECHNICAL DATA

Standards

DIN Material Nr. 3.2585

EN ISO 18273 :	S Al 4047 (AlSi12)
AWS A5.10 :	ER4047

General Properties / Field of Applications

DSI M AluCF is a Laser Welding Wire for Aluminum alloy, cast alloy up to 12% Si, strong prevention of cracking after welding. The weld area must be metallicly bright.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	60
Tensile strength R_m	[MPa] / [N/mm ²]	130
Elongation A ($L_0 = 5d_0$)	[%]	6
Hardness	[HB]	110

Chemical Composition (Standard Values in %)

AL	Si
Base	11.7

Compatible Materials (Selection)

G-AlSi10Mg / G-AlSi12 / G-AlSi8Cu3

Packaging and available Sizes*

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

* Other dimensions available on request

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DSI Total Solution for Pulse Laser Welding with DSI Laser Wires

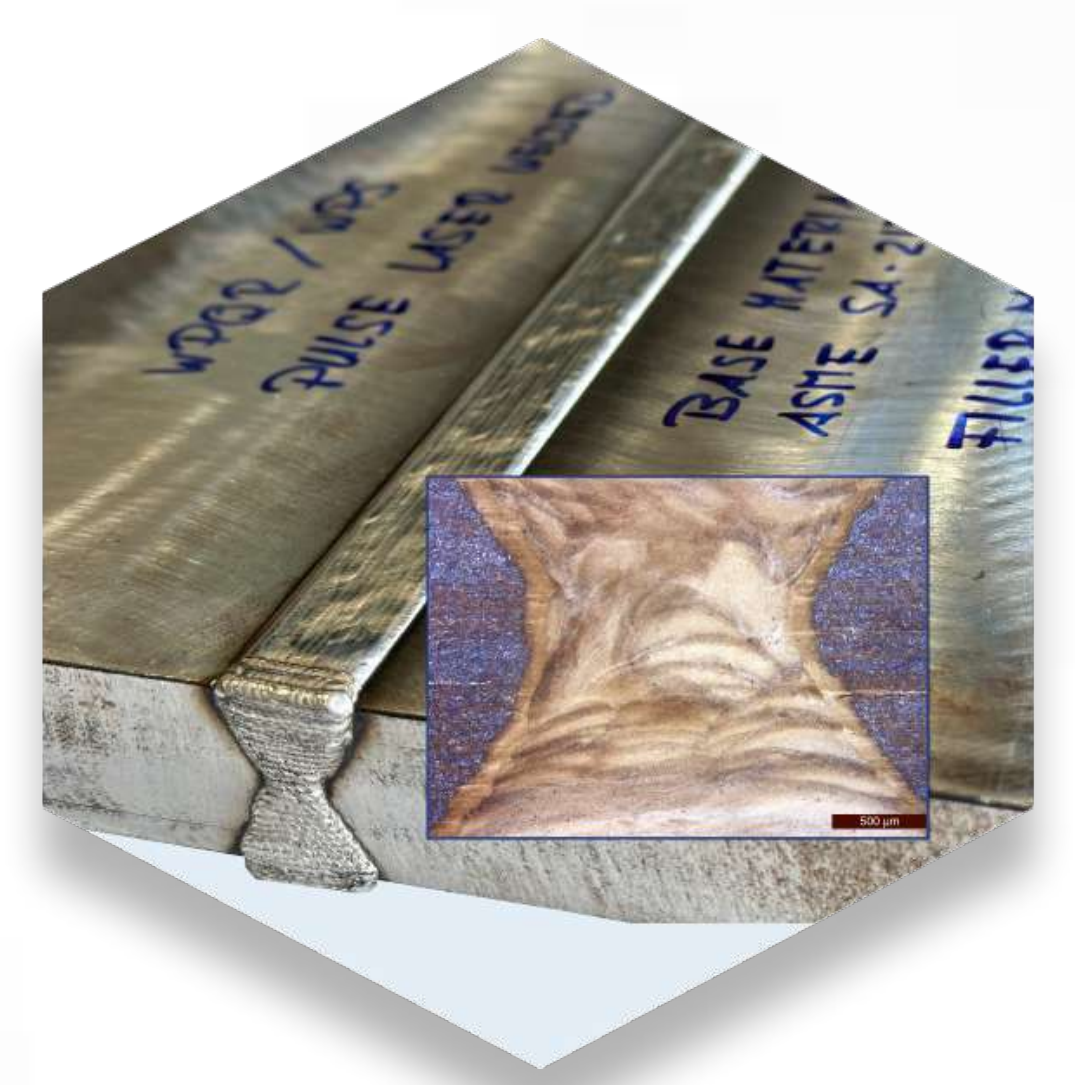
Pulse Laser Welding Service

DSI Laser Wires

Authorised dealer of ALPHA LASER

AL-Machines Service & Maintenance

DSI Thailand Laser-Welding-Academy





LASER WELDING MACHINE

SERVICE & MAINTENANCE

DSI Total Solution for  Pulse Laser Welding with  DSI Laser Wires



Scan DSI
Service & Maintenance

LASER WELDING MACHINE

SERVICE & MAINTENANCE



Installation and Commissioning



Preventive Maintenance Program



Repair and Overhaul



ALPHA LASER spare parts on stock

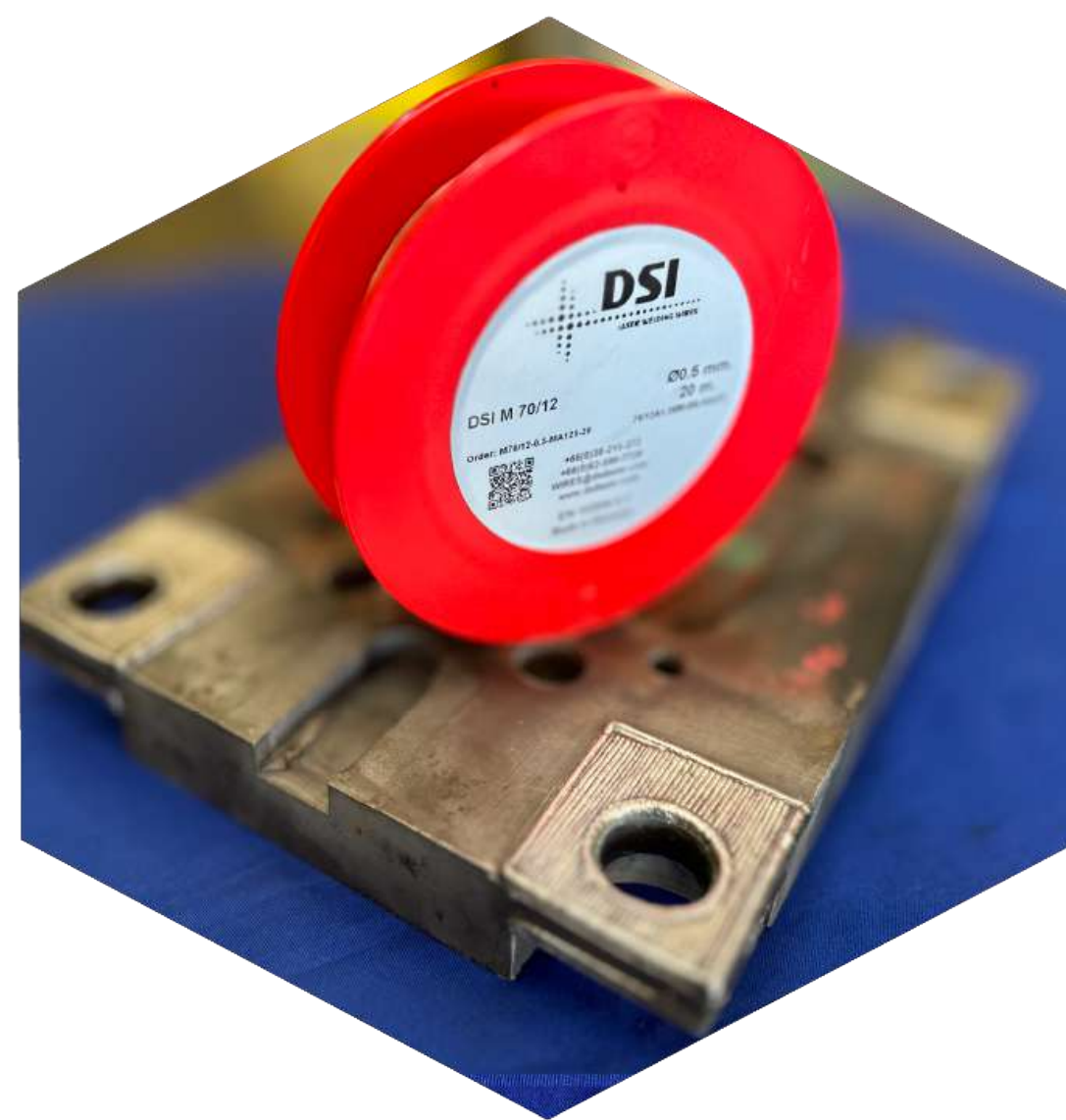


Machine operation training

Our team is ready to service customers
in Thailand, and whole Southeast Asia.

○ DSI Total Solution for  Pulse Laser Welding with  DSI Laser Wires





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DSI Laser Wires Catalog
Molds & Dies

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