



MIG MARVAL 18S*

Classification

EN 14700 : S Fe5

Material N° : 1.6359

Description & Applications

X2NiCoMoTi18-8 solid wire type for MIG hardfacing of similar chemical composition steels like Maraging steels.

The deposit can be machined with standard tools as welded. Also used to weld Maraging steels like X2NiCoMo18-9-5; 1.6356 and others (Maraging 200-250).

Product of high purity for welding without microporosity.

Main applications: For building up dies for extrusion of Al-castings and plastics, for hot working tools, for moulds, etc...

Typical Chemical Composition (%)

	C	Si	Mn	Ni	Mo	Co	Al	Ti	Zr	P	S	B	Fe
Min				17.00	4.60	7.50	0.05	0.30					
Max	0.02	0.05	0.05	19.00	5.20	9.50	0.15	0.70	0.02	0.010	0.010	0.003	Rem.
Type	0.01	0.03	0.02	18.0	5.0	8.5	0.10	0.50	0.005	0.008	0.002	0.002	Rem.

All Weld Metal Mechanical Properties

Hardness (As welded)
~36 HRC

Hardness (after PWHT at 480°C/4h)
~50 HRC

Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	60 - 100	18 - 21	ISO 14175: I1 (Ar) / I3 (Ar+He) 12-15 l/min
	1.0	150 - 170	25 - 28	
	1.2	150 - 220	26 - 28	
	1.6	180 - 270	26 - 32	

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