



TIG MARVAL 18S*

Classification

AIR 9117 : Z2NKD18

EN 14700 : S Z Fe5

Description & Applications

Solid rod for TIG hardfacing of steels with similar chemical composition like X2NiCoMoTi18-8 steel (Maraging steels). Also used to weld Maraging steels like X2NiCoMo18-9-5 and others (Maraging 200-250). Product of high purity for welding without microporosity. The deposit, as welded, can be machined with standard tools.

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

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

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 L/min

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FT En-TR05-200408

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