



MIG MARVAL 18S

Classification

EN 14700 : S Fe5

Material N° : 1.6359

Description & Applications

Solid wire for GMAW for welding steels of similar chemical composition and for hardfacing by the GMAW process. Product of high purity for welding without micro porosity. The deposit can be machined with standard tools after welding and then age hardened by a subsequent heat treatment.

Main applications: For building up dies for extrusion of Al-castings and plastics, for hot working tools, for moulds, etc. Also used to weld Maraging steels like X2NiCoMo18-9-5, 1.6358 and others (Maraging 200-250).

Typical Chemical Composition (%)

C	Si	Mn	Ni	Co	Mo	Ti	Al	Fe
<0.01	<0.1	<0.1	18.0	8.5	5.0	0.5	0.1	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)

~36 HRC

Hardness after PWHT; 4h at 480°C

~50 HRC

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	60-100	18-21	EN 439: I1 (Ar+He) 15-18 l/min
	1.0	150-170	25-28	
	1.2	150-220	26-28	
	1.6	180-270	26-32	

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