



TIG MARVAL 18S

Classification

EN 14700 : S Fe5

Material N° : 1.6359

Description & Applications

Solid rod for TIG welding of similar chemical composition steels. Product of high purity for welding without microporosity. The deposit can be machined with standard tools after welding and then age hardened by a subsequent heat treatment. Also used to weld Maraging steels like X2NiCoMo18-9-5; 1.6356 and others (Maraging 200-250).

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	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 age hardening
4h at 480°C: ~50 HRC

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min

*Trademark of Aubert&Duval

ind.10



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.