

IABCO MAR 250

TIG/GTAW wire for maraging steels

Product name	IABCO MAR 250
Classification EN ISO	14700: SFe5
Material No.	1.6359
Classification AWS	-
Approvals	-
Applications	TIG/GTAW welding wire for welding Maraging steels. The wire is commonly used to weld dies and tools because in the as-welded condition it can be readily machined before being subjected to a low temperature age-hardening heat treatment. The wire can be used for welding matching Maraging alloys and is also used for building up aluminium and plastic extrusion dies, and also moulds.
Base materials	Used for welding matching Maraging alloys Maraging 200 & 250. X2NiCoMo 18-9-5. 1.6356.
Typical analysis of wire, weight %	C: < 0.01 Si: < 0.1 Mn: < 0.1 Ni: 18.0 Mo: 5.0 Co: 8.5 Ti: 0.5 Al: 0.1 Fe: Balance
Typical heat treatment ⁽¹⁾	To achieve full strength and hardness the weld deposit needs to be heat treated. Typical heat treatment would be 480°C for 4 hours.
Mechanical properties of weld deposit ⁽²⁾	Hardness, as-welded: ~36HRC Hardness, 480°C/4hrs: ~50HRC.
Other products	-

- Notes** (1) Application codes and project specifications should always be referred to for specific requirements.
(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.