

MG 701 TIG

MARAGING TOOL STEEL TIG WIRE DC STRAIGHT POLARITY (DC-)

GENERAL CHARACTERISTICS:

MG 701T is a nickel, cobalt, molybdenum wire designed to weld maraging tool steels. The as welded hardness of RC 30-33 allows deposits to be machined prior to maraging (age hardening). Maraging at 450°C for 2 hours produces a hardness of RC 48-52. Maraging steels do not require preheat; other steels should be preheated to their recommended preheat temperature prior to welding.

APPLICATIONS:

Build-up and repair of hot working dies and tools made from maraging steels used in aluminum and zinc die casting industry. Use for build-up on H-11 and H-13 tool steels when machining in the as welded condition is desirable. When used in aluminum and zinc die casting dies, deposits will harden in service.

TECHNICAL DATA:

Typical Deposit Chemistry	C 0.02	Mn 0.10	Si 0.50	S 0.02
	P 0.01	Ni 19.25	Co 7.5	Mo 4.60
Hardness as welded	RC 30-33			
age hardened 2 hours @ 450°C	RC 48-52			
Machinability as welded	Good			
Current	DC- straight polarity			

PROCEDURE:

When the process is gas tungsten arc welding (TIG) use direct current straight polarity, one hundred percent argon gas is recommended. Adjust the amperage according to the base metal thickness and the amount of deposit required. Do not preheat maraging steels. Other steels use recommended preheat temperatures.