

Maraging 250 DATA SHEET

AWS Class Maraging 250

AISI Maraging 250/300

DEPOSIT COMPOSITION (TYPICAL)

C	Mn	Si	P	S	Ni	Al	Ti	Co	Fe	Mo
<0.03	<0.10	<0.10	<0.01	<0.01	18.00	0.01	0.40	7.75	Bal	4.75

Maraging 250 is a premium nickel/cobalt/moly age hardening alloy that produces a 30-32 Rc as welded that allows machining before maraging or age hardening. It is used for the repair and build-up on hot working dies and tools from all grades of the maraging steels used in the aluminum and zinc die casting industries, the forging industry, as well as the rubber and plastic injection industries. Maraging 250 is also excellent as an overlay on lower alloy steels to develop the maraging properties and characteristics

Forms

TiG GTAW 100% Ar	MiG GMAW 92% Ar 8% CO ₂	Arc SMAW DC+
--------------------------------	---	----------------------------

Maximum Tensile Strength: 33,000 psi
Percent Elongation in 2": 10%

Hardness: 30-32 as welded
48-52 age hardened

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210. SDS' may be obtained at the website below.