



AMTEC UH 72 MARAGING TOOL STEEL BARE TIG WIRE

General Characteristics

Amtec UH 72 is a premium nickel-cobalt- molybdenum precision drawn tig welding wire for repair welds on analogous or similar precipitation hardening steels. The as welded hardness allows for complete machining prior to maraging, or age hardening. Preheating is not necessary when welding maraging steels, however, other steels should be pre-heated according to their recommended pre-heat.

Procedure

Clean the welding zone free from oil, rust and other contaminants. Grind out cracks and other defects, making sure that there are no sharp radii. Use DC current with straight polarity. Weld in small steps, and keep the base metal as cool as possible during the welding operation. Preheating is **NOT RECOMMENDED** on Maraging Steel. Preheating is recommended on other steels, according to their recommended preheats. After welding, heat to 930°F for 3 hours to attain a hardness of 53-54 RC. Cool in still air.

Application

This tig wire is primarily used for the welding of analogous or similar precipitation hardening steels, and all grades of maraging steels used in the aluminum and zinc die casting industries, forging industry, and the plastic and rubber injection industries.

Hardness (RC)		(as deposited)	34-38
Hardness (RC)		(after precipitation hardening)	53-54
Alloy Type		Carbon-Silicon-Manganese-Molybdenum-Nickel-Cobalt-Titanium-Aluminum Type	

Diameter (Inch)	1/16	3/32
(mm)	1.5	2.5

*Available only in tig wire 1/16 and 3/32 by 36" lengths

CONFIDENTIAL INFORMATION
Subject to change without notice

Tip Color – Plain
Bare Tig Wire