

de Havilland Inc.

Material Specification

TITLE:	WELDING WIRE, 18% NI MARAGING STEEL
SPECIFICATION NUMBER:	DHMS M2.14
ISSUE:	Original
AMENDMENT:	-
DATE:	April 27, 1965
PAGE:	1 of 3

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Prepared by:

SIGNED ORIGINAL ON FILE

J.C. Bellersen for P.D. Hedgecock
Materials Technology

Approved by:

D.S. Binnington

Dr. A.W. Bethune

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1 SCOPE

- 1.1 This specification covers the requirements for 18% Ni maraging steel welding wire to be used in the Metal Inert Gas or Tungsten Inert Gas welding of 200 or 250 maraging steel, sheet, strip, plate, rod, bar or forging material.

2 INTRODUCTION

- 2.1 The clauses of this specification are written under the following headings:

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3 FORM

- 3.1 Welding wire will be supplied as round drawn wire. The diameter of wire and spool size is to be specified on ordering.

4 REQUIREMENTS

- 4.1 Vacuum arc remelted stock only is to be used.

4.2 Composition

Wire material shall be composed of the following elements in percentage (%) by weight:

Nickel	17.5 - 18.5
Molybdenum	4.2 - 4.8
Cobalt	7.5 - 8.5
Titanium	.45 - .55
Aluminum	.05 - .15
Boron	0.003 added
Zirconium	0.02 added
Carbon	0.03 max.
Manganese	0.10 max.
Phosphorous	0.008 max.
Sulphur	0.008 max.
Silicon	0.10 max.
Hydrogen	5 ppm max.

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4.3 Condition

The wire shall have been vacuum annealed prior to packaging.

4.4 Packaging

The wire shall be level wound on a plastic spool and each spool packed into a metal container which is hermetically sealed.

5 REPORTS

5.1 A minimum of three certified copies of the chemical analysis of each heat number shall be supplied with each order.

6 IDENTIFICATION

6.1 Each container of welding wire shall be identified with this specification number DHMS M2.14, the purchase order number, wire diameter, heat number and net weight.

7 ORDERING DATA

7.1 Procurement documents should specify the following:
- Title, number and issue of this specification
- Wire size and net weight per container

8 REJECTIONS

8.1 Material not conforming to this specification or to authorized modifications will be subject to rejection.