HAYNES® 242® alloy

Machining

HAYNES® 242® alloy may be machined in either the solution-annealed or aged conditions. Carbide tools are recommended. In the annealed condition (R_B 95-100 typical hardness) the alloy is somewhat "gummy". Better results may be achieved by performing machining operations on material in the age-hardened condition (R_C 35-39 typical hardness). Finish turning has been successfully done employing carbide tools with a depth of cut in the range of 0.010-0.020 inch (0.25-0.50 mm), rotation speeds of 200-400 rpm, 40-80 sfm, and a water-base lubricant.