

Machinability Rating

Machinability Ratings – Stainless

Grade	Approximate Surf. Ft. Per Min.	% Relative Speed Based on B-1112 as 100%
302	70	40
302/304 "B"	55	28
303	150	75
303 High Tensile	80	43
304	70	40
304 L	70	40
309	60	36
310	60	36
316	60	36
316 "B"	50	22
316 L	60	36
317-317 L	60	36
321	60	36
330	45	20
347	60	36
403	95	54
410	95	54
416 Ann	150	75
416 H.T.	85	50
418 (Greek Ascoloy)	96	50

Grade	Approximate Surf. Ft. Per Min.	% Relative Speed Based on B-1112 as 100% (165 SFM)
420	85	50
420 F	125	68
430	110	66
430 F	150	75
431	80	48
440 A	65	40
440 C	65	40
440 F Se	80	48
446	60	36
Custom 455	55	28
PH-13-8 MO	60	36
15-5 PH	75	45
17-4 PH	75	45
17-4 PH "H1150"	85	50
17-7 PH	75	45
AM 355	72	42
Nitronic 40	50	22
Nitronic 50	50	22
Nitronic 60	50	22
Carp. 20	70	40

Super Alloys - Electrical Steels

Grade	Approximate Surf. Ft. Per Min.	% Relative Speed Based on B-1112 as 100%
Maraging "300"	60	36
A-286	54	28
4750	60	36
L-605	15	9
Nickel "200"	110	66
Nickel "400"	80	48
Nickel "405"	80	48
Nickel "K-500"	60	36
Nickel "600"	50	22

Grade	Approximate Surf. Ft. Per Min.	% Relative Speed Based on B-1112 as 100% (165 SFM)
Nickel "625"	20	12
718	20	12
X-750	20	12
INVAR 36 "FM"	92	55
Waspaloy	45	20
Alloy C (C-276)	40	18
Alloy X	45	20
Kovar	60	22
Alloy R41	15	9