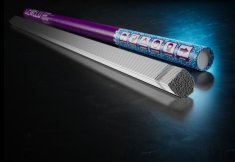


CEWELD ER 630 Tig (17-4 PH)

TYPE	Precipitation hardening stainless steel filler metal used for welding materials of similar chemical composition such as 17-4 and 17-7.																					
APPLICATIONS	To be used in the as welded condition or in the heat treated condition to obtain higher strength. Mechanical properties of this alloy are greatly influenced by the heat treatment.																					
PROPERTIES	Mechanical properties listed below reflect utilization of a post-weld heat treatment between 1020°C (1875°F) and 1050°C (1925°F) for one hour, followed by precipitation hardening between 612°C (1135°F) UTS ~ 1170 MPa and YS ~ 950 MPa																					
CLASSIFICATION	AWS	A 5.9: ER630																				
	EN ISO	14343-B: W 630																				
	W.Nr.	1.4542																				
	F-nr	6																				
	FM	5																				
SUITABLE FOR	For Martensitic stainless steel 17-4 and other similar precipitation- hardening stainless steel 1.4542, 1.4548 X5CrNiCuNb16-4 ASTM A564 Type 630 (17-4PH) 17-4PH, FE-PM61 , Z6CNU 17-4, Z7CNU17-04, UNS S17400,																					
APPROVALS	CE																					
WELDING POSITIONS																						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Nb</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.04</td> <td>0.45</td> <td>0.55</td> <td>0.01</td> <td>0.01</td> <td>16.5</td> <td>4.8</td> <td>0.2</td> <td>0.25</td> <td>3.5</td> </tr> </tbody> </table>		C	Si	Mn	P	S	Cr	Ni	Mo	Nb	Cu	0.04	0.45	0.55	0.01	0.01	16.5	4.8	0.2	0.25	3.5
C	Si	Mn	P	S	Cr	Ni	Mo	Nb	Cu													
0.04	0.45	0.55	0.01	0.01	16.5	4.8	0.2	0.25	3.5													
MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} (MPa)</th> <th>R_m (MPa)</th> <th>A₅ (%)</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>750</td> <td>980</td> <td>8</td> <td>HRc</td> </tr> </tbody> </table>		Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded	750	980	8	HRc										
Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness																		
As Welded	750	980	8	HRc																		
REDRYING	Not required																					
GAS ACC. EN ISO 14175	I1																					



CEWELD ER 630 Tig (17-4 PH)

ER 630 TIG (17-4 PH) 1,6 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415523

ER 630 TIG (17-4 PH) 2,0 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415530

ER 630 TIG (17-4 PH) 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415547