



# CEWELD ER 630 (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.                                                                                                                                                                                                                                                                                                                                                                                  |                |                         |                      |        |          |     |     |
| TOEPASSINGEN                                      | 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.                                                                                                                                                                                                                                                                                                                                     |                |                         |                      |        |          |     |     |
| EIGENSCHAPPEN                                     | Mechanical properties listed below reflect utilization of a post-weld heat treatment between 1024°C (1875°F) and 1052°C (1925°F) for one hour, followed by precipitation hardening between 623°C (1135°F)                                                                                                                                                                                                                                                                                                               |                |                         |                      |        |          |     |     |
| CLASSIFICATIE                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | A 5.9: ER630   |                         |                      |        |          |     |     |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 14343-B: G 630 |                         |                      |        |          |     |     |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 1.4542         |                         |                      |        |          |     |     |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 6              |                         |                      |        |          |     |     |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 5              |                         |                      |        |          |     |     |
| GESCHIKT VOOR                                     | For Martensitic stainless steel 17-4 and other similar precipitation- hardening stainless steel<br>1.4542, 1.4548<br>X5CrNiCuNb16-4<br>ASTM A564 Type 630 (17-4PH), A705, A693, 17-4PH, FE-PM61 , Z6CNU 17-4, Z7CNU17-04, UNS S17400,<br>ASM 5643, 5622, 5398, 5342-44, 5604, 5529. 5528, 5568.                                                                                                                                                                                                                         |                |                         |                      |        |          |     |     |
| GOEDKEURINGEN                                     | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                |                         |                      |        |          |     |     |
| LASPOSITIES                                       |       |                |                         |                      |        |          |     |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Si             | Mn                      | Cr                   | Ni     | Mo       | Nb  | Cu  |
|                                                   | 0.03                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 0.45           | 0.55                    | 16.7                 | 4.8    | 0.2      | 0.2 | 3.5 |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |     |     |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                | 750                     | 980                  | 10     | 38 HRc   |     |     |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                |                         |                      |        |          |     |     |
| GAS ACC. EN ISO 14175                             | M11, M13, M12                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                |                         |                      |        |          |     |     |



# CEWELD ER 630 (17-4 PH)

ER 630 (17-4 PH) 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415486 |

ER 630 (17-4 PH) 1,14MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415493 |

ER 630 (17-4 PH) 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415516 |