



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), A705, A693, 17-4PH, FE-PM61 , Z6CNU 17-4, Z7CNU17-04, UNS S17400, ASM 5643, 5622, 5398, 5342-44, 5604, 5529. 5528, 5568.									
APPROVALS	CE									
WELDING POSITIONS										
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	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	Heat Treatment			R _{p0,2} (MPa)		R _m (MPa)		A5 (%)	Hardness	
	As Welded			750		980		8	36 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