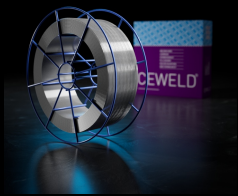


CEWELD ER 630 (17-4 PH)



TYPE	Precipitation hardening stainless steel filler metal used for welding materials of similar chemical composition such as 17-4 and 17-7.							
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 ~ 1130 MPa and YS ~ 900 MPa							
CLASSIFICATION	AWS	A 5.9: ER630						
	EN ISO	14343-B: G 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	Cr	Ni	Mo	Nb	Cu
	0.03	0.45	0.55	16.7	4.8	0.2	0.2	3.5
MECHANICAL PROPERTIES	Heat Treatment		R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness		
	As Welded		750	980	10	38 HRc		
REDRYING	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