CEWELD ER 630 Tig (17-4 PH)

certilas® THE FILLER METAL SPECIALIST

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 1020°C (1875°F) and 1050°C (1925°F) for one hour, followed by precipitation hardening between 612°C (1135°F)

CLASSIFICATIE

AWS	A 5.9: ER630
EN ISO	14343-B: W 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
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.

GOEDKEURINGEN

CE

LASPOSITIES

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

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	750	980	8	36 HRc

HERDROGEN

Not required

GAS ACC. EN ISO 14175

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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