






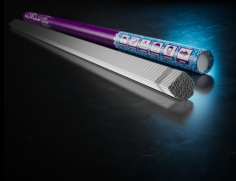




CEWELD ER 630 Tig (17-4 PH)

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)									
CLASSIFICATION	AWS	A 5.9: ER630								
	EN ISO	14343-B: W 630								
	F-nr	6								
	FM	5								
	W.Nr.	1.4542								
SUITABLE FOR	Suitable for precipitation hardening stainless steel used for welding materials of similar chemical composition such as 17-4 (PH) and 17-7 as applied for valves, fasteners, gears, propeller shafts, and roller chain pins. W.Nr: 1.4542									
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
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)						
	As Welded /	750	980	8						
REDRYING TEMPERATURE	Not required									
GAS ACCORDING EN 14175	I1									



CEWELD ER 630 Tig (17-4 PH)

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

Type	KG/unit	EANCode
Tube	5	8720663415523

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

Type	KG/unit	EANCode
Tube	5	8720663415530

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

Type	KG/unit	EANCode
Tube	5	8720663415547