



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																												
	F-nr	6																												
	FM	5																												
	W.Nr.	1.4542																												
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) 17-4PH, FE-PM61 , Z6CNU 17-4, Z7CNU17-04, UNS S17400,																													
APPROVALS	CE																													
WELDING POSITIONS																														
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Nb</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.04</td> <td>0.45</td> <td>0.55</td> <td>0.01</td> <td>0.01</td> <td>16.5</td> <td>4.8</td> <td>0.2</td> <td>0.25</td> <td>3.5</td> </tr> </tbody> </table>										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
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A5 (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>750</td> <td>980</td> <td>8</td> </tr> </tbody> </table>										Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	As Welded /	750	980	8												
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