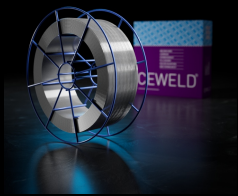


# CEWELD ER 630 (17-4 PH)

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 1024°C (1875°F) and 1052°C (1925°F) for one hour, followed by precipitation hardening between 623°C (1135°F)							
CLASSIFICATION	AWS	A 5.9: ER630						
	EN ISO	14343-B: G 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	Cr	Ni	Mo	Nb	Cu
	0.03	0.45	0.55	16.7	4.8	0.2	0.2	3.5
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)				
	As Welded /	750	980	10				
REDRYING TEMPERATURE	Not required							
GAS ACCORDING EN 14175	M11, M13, M12							



# CEWELD ER 630 (17-4 PH)

ER 630 (17-4 PH) 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663415486

ER 630 (17-4 PH) 1,14MM

Type	KG/unit	EANCode
BS-300	15	8720663415493

ER 630 (17-4 PH) 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663415516

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

Type	KG/unit	EANCode
K-415	25	8720663415509