
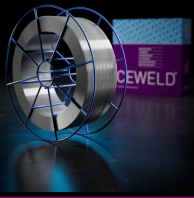


CEWELD ER 630 (17-4 PH)

| TYPE | Precipitation hardening stainless steel filler metal used for welding materials of similar chemical composition such as 17-4 and 17-7. | | | | | | | | | | | | | | | | | |
|---|--|--|--------------------|-------------------------|----------------------|--------------------|----------|-----------|-----|-----|------|------|------|------|-----|-----|-----|-----|
| ANWENDUNGEN | 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. | | | | | | | | | | | | | | | | | |
| EIGENSCHAFTEN | 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) | | | | | | | | | | | | | | | | | |
| KLASSIFIKATION | AWS EN ISO W.Nr. F-nr FM | A 5.9: ER630 14343-B: G 630 1.4542 6 5 | | | | | | | | | | | | | | | | |
| GEEIGNET FÜR | 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, | | | | | | | | | | | | | | | | | |
| ZULASSUNGEN | CE | | | | | | | | | | | | | | | | | |
| SCHWEISSPOSITIONEN |  | | | | | | | | | | | | | | | | | |
| 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>Cr</th> <th>Ni</th> <th>Mo</th> <th>Nb</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>0.45</td> <td>0.55</td> <td>16.7</td> <td>4.8</td> <td>0.2</td> <td>0.2</td> <td>3.5</td> </tr> </tbody> </table> | | C | Si | Mn | Cr | Ni | Mo | Nb | Cu | 0.03 | 0.45 | 0.55 | 16.7 | 4.8 | 0.2 | 0.2 | 3.5 |
| C | Si | Mn | Cr | Ni | Mo | Nb | Cu | | | | | | | | | | | |
| 0.03 | 0.45 | 0.55 | 16.7 | 4.8 | 0.2 | 0.2 | 3.5 | | | | | | | | | | | |
| MECHANISCHE GÜTEWERTE | <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> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>750</td> <td>980</td> <td>10</td> <td>HRc</td> </tr> </tbody> </table> | | Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness | As Welded | 750 | 980 | 10 | HRc | | | | | | |
| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness | | | | | | | | | | | | | | |
| As Welded | 750 | 980 | 10 | HRc | | | | | | | | | | | | | | |
| RÜCKTROCKNUNG | 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 |
| ER 630 (17-4 PH) 1,6MM | Packaging | KG/unit | EanCode |
| | K-415 | 25 | 8720663415509 |