
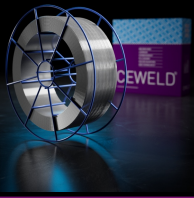




CEWELD ER 630 (17-4 PH)

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
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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						
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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