
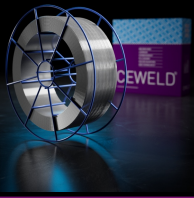




# CEWELD ER 630 (17-4 PH)

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 1020°C (1875°F) and 1050°C (1925°F) for one hour, followed by precipitation hardening between 612°C (1135°F) <b>UTS ~ 1130 MPa and YS ~ 900 MPa</b>																	
CLASSIFICATION	AWS	A 5.9: ER630																
	EN ISO	14343-B: G 630																
	W.Nr.	1.4542																
	F-nr	6																
	FM	5																
SUITABLE FOR	<b>For Martensitic stainless steel 17-4 and other similar precipitation- hardening stainless steel</b> 1.4542, 1.4548 X5CrNiCuNb16-4 <b>ASTM A564 Type 630 (17-4PH)</b> 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>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											
MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Heat Treatment</th> <th>R<sub>p0,2</sub> (MPa)</th> <th>R<sub>m</sub> (MPa)</th> <th>A<sub>5</sub> (%)</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 <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness	As Welded	750	980	10	HRc						
Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness														
As Welded	750	980	10	HRc														
REDRYING	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