


CATEGORY	GMAW Solid wires																												
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																												
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WELDING POSITIONS:																													
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <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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REDRYING TEMPERATURE	Not required																												
GAS ACCORDING EN 14175	M11, M13, M12																												