

**CATEGORY** GTAW Solid wires

**TYPE** Precipitation hardening stainless steel filler metal used for welding materials of similar chemical composition such as 17-4 and 17-7.

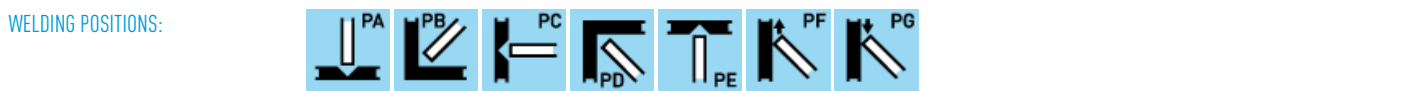
**APPLICATIONS** To be used in the as welded condition or in the heat treated condition to obtain higher strength. Mechanical properties of this alloy are greatly influenced by the heat treatment.

**PROPERTIES** Mechanical properties listed below reflect utilization of a post-weld heat treatment between 1020°C (1875°F) and 1050°C (1925°F) for one hour, followed by precipitation hardening between 612°C (1135°F)

CLASSIFICATION	AWS	A 5.9: ER630
	EN ISO	14343-B: W 630
	F-nr	6
	FM	5

**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



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Cr	Ni	Mo	Nb	Cu
0.04	0.45	0.55	0.01	0.01	16.5	4.8	0.2	0.25	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	8

**WELDING PARAMETERS / PACKING**

D (MM)	WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING (KG)	
				LENGTH (MM)	CURRENT (A) DC-
1.6		1000	50-110	5	25
2.4		1000	110-180	5	25
3.2		1000	160-260	5	25

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** 11