

TIGWELD 630

TIG Rods [GTAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:				
EN ISO 14343-A : X5CrNiCuNb16 4 DIN 8556 : X5 CrniCuNb16 4 AWS A-5.9 : ER 630 W.Nr. : 1.4542		Power generation industry Petrochemical and chemical industry				
<ul style="list-style-type: none"> Precipitation hardening stainless steel filler metal used for welding materials of similar chemical composition, e.g. 17-4 and 17-7. The mechanical properties of this alloy are greatly affected by heat treatment. 						
Application						
Valves, fasteners, gears, propeller pins and roller chain pins						
Base material						
DIN	W.Nr.					
X4 CrNiCuNb16 4	1.4540					
GX4 CrNiCuNb16 4	1.4540					
X5CrNiCuNb16 4	1.4542					
X5 CrNiCuNb17 4 4	1.4548					
Typical chemical composition %						
C 0,02	Si 0,46	Mn 0,64	Cr 16,40	Ni 4,78	Nb 0,20	Cu 3,60
Typical mechanical properties						
Yield strength Re [N/mm²]	920					
Tensile strength Rm [N/mm²]	1020					
Elongation A5 [%]	11					
Additional description	Note - the above mechanical parameters can be achieved after post-welding heat treatment for 1h at a temperature between 1020°C and 1050°C following by precipitation hardening at a temperature of about 610°C.					
Shielding gases acc. to EN ISO 14175	I1 - Ar /					
Welding parameters and packing						
Ø 2,4	Length [mm] 1000 /	Welding current [A] 110-180	Weight of packet [kg] 5,0			
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