

E 630-16

An Electrode specially designed for producing 17Cr-4.5Ni and 3.5 Cu weld deposit precipitation-hardening stainless steels

CLASSIFICATION : AWS/SFA-5.4: E 630-16
UNS W37410

APPROVAL :

CHARACTERISTICS : An electrode specially designed for weld metal is modified to prevent the formation of ferrite networks in the martensite microstructure which could have a deleterious effect on mechanical properties. This electrode offers the combined characteristics of a strong, corrosion resistant, electrode gives machinable weld metal.

APPLICATION :

- 1) Suitable for joining ASTM A-564 hardenable steels
- 2) Dependent on the application and weld size, the weld metal may be used either as-welded, welded and precipitation hardened , or welded, solution treated and precipitation hardened.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Cu	Mo	Cb+Ta
0.05 max	0.25-0.75	0.75 Max	0.030 Max	0.040 Max	16.00- 16.75	4.50- 5.00	3.25- 4.00	0.75 Max.	0.15- 0.30

ALL WELD MECHANICAL PROPERTIES(PWHT 630°C/4 Hrs):

YS (0.2%) (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)
730 Min.	930 Min.	10 Min.

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC-/AC) Amps	kg/packet.	kg/case.
2.50/ 2.40 X 350	3/ 32" X 14"	50-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	75-100	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	150-180	2	20

Customer packing on request.