



630 XT

(17-4-PH)

AWS A 5.9: ER630

DESCRIPTION

Consumables used to weld similar composition such as 17-4 and 17-7 steels. Can be used in welded condition or may be heat treated to obtain higher strength. The mechanical properties are largely affected by the treatment of the steel post welding. Typical applications: Pump shafts, impellers, hydraulic components

WELDING POSITIONS



CURRENT

DC-

GAS

Ar (I1)

BASE MATERIALS

17-4PH, 17-4, 17-7

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_p 0,2</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
420	275	26	

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Ni	Nb
0,03	0,54	0,43	16,5	4,8	0,22
Mo	P	S	Cu		
0,2	0,02	0,02	3,6		

PACKAGING

Dimension(mm)	1,6	2,0	2,4	
Box(kg)	5	5	5	

EQUIVALENT FILLER METALS

MIG	Meltolit 630 XM
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