

# *selectarc* Inox 630B

Basic type Stainless  
Steel Electrode



## Classification

AWS A5.4 : E630-15  
ISO 3581-B : ES 630-25

EN 1600 : E Z17 4 Cu B43 H5

## Description & Applications

Basic coated high strength stainless electrode for welding similar precipitation hardening Cr-Ni-Cu alloys. These alloys, rolled, forged and cast, are used to produce components as rotors of compressors, fan blades, press dies used in the plastic processing, paper and aerospace industry.

### Base materials

Precipitation hardening Stainless steels:

UNS	Alloy	EN 10088	Mat. N°
J92180	CB Cu-1	X5CrNiCuNb16-4	1.4542
S17400	630	X5CrNiCuNb17-4-4	1.4548
	SAE J467		
	17-4PH		

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S
0.04	0.4	0.4	16.5	4.7	0.3	3.5	0.2	0.02	0.01

## All Weld Metal Mechanical Properties

Rp0.2 ( MPa )	Rm ( MPa )	A5 ( % )
900	1000	16

Mechanical properties after solution annealing 1040°C / 2h / air + 620°C / 4H / air

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x450
Current	( A )	70 – 80	90 – 110	120 - 140

Rebaking at 250°C during 1 hour if necessary.

Keep the Interpass temperature very low : < 80°C and use an adapted PWHT (solution annealing plus precipitation hardening).



1G/PA



2F/PB



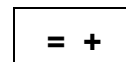
2G/PC



3G/PF



4G/PE



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