



A₅ 17/4CU

Classification

ISO 14343-A : G Z 17 4 Cu
 AWS A5.9 : ER 630

AMS : 5825

Description & Applications

Solid wire for joining similar steels in aeronautical industry as 17-4PH, 1.4548, X5CrNiCuNb17-4-4; 1.4540, X4CrNiCuNb16-4.

Main applications: Repairing of turbine discs, turbine blades.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Cu	Nb	P	S	Fe
0.03	0.5	0.6	16.0	5.0	3.5	0.2	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
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Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0	120-200	24-28	EN 439 : M1 Ar + 2%CO ₂ 18-20 l/min
	1.2	140-220	24-28	
	1.6	180-260	24-30	

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