



TIG 17/4CU

Old reference: TIG 17-4 Cu

Classification

ISO 14343-A : W Z 17 4 Cu
 AWS A5.9 : ER630

AMS : 5825

Description & Applications

Solid rod for TIG welding similar steels in aeronautical industry.

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 (%) | KV (J) |
|--------------------|---------------|-------------|----------|
| | | | |

Welding Current & Instructions

| Welding mode | Shielding Gas |
|--------------|--|
| TIG = - | Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min |

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