

GETIG 630

IDENTIFICATION

Getig 630, ER 630

CLASSIFICATION

AWS/SFA-5.9 : ER 630

DESCRIPTION

The tig wire is designed for welding ASTM A564 type 630 and other precipitation hardening stainless steel. The composition is modified to prevent the formation of ferrite networks in the martensitic microstructure which have deleterious effect on mechanical properties. Depending on application and weld size, the weld metal may be used as-welded and precipitation hardened or welded, solution treated and precipitation, hardened.

CHEMICAL ANALYSIS (RANGE) %

C	Cr	Ni	Mo	Mn	Si	Cu	Nb	S	P
0.05 Max	16.0 - 16.75	4.5 - 5.0	0.75 max	0.25 - 0.75	0.75 max	3.25 - 4.0	0.15-0.30	0.03 max	0.03 max

AFTER PWHT :

Heat to 1020 - 1050°C / 1 hr and air cool to ambient temperature then precipitate harden at 610 - 630°C / 4 hr and cool to ambient temp.

SHIELDING GAS : Pure Argon

PACKING PARAMETERS

Length (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20