



SUPERINOX 630

STAINLESS STEEL (Dissimilar Steel Welding)

AWS A/SFA 5.4 **E630-16**

CLASSIFICATION:

ISO 3581-B
ES630-16

APPROVALS: CE

KEY FEATURES:

- Rutile type coating
- Typical 16/5/4Cu type weld deposit
- Offers combined characteristics of a strong, corrosion resistant, easily machinable weld metal
- This alloy prevent the formation of ferrite networks in the martensitic microstructure that would inhibit the mechanical properties
- Depending on application and weld size, may be used in the as welded, welded and precipitation hardened, or welded and solution treated and precipitation hardened condition
- Excellent welding characteristics
- Suitable for all position
- Radiographic quality weld

TYPICAL APPLICATIONS:

- Welding of ASTM A-564, Type 630 and some other precipitation hardenable steels
- For welding of 17-4PH and 17-7PH steel



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Nb+Ta	Cu
0.04	0.6	0.7	16.6	4.7	0.2	3.7

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	PWHT:1025-1050°C for 1 hr and air cooled 2 ambient Followed by precipitation hardening: 610-630°C for 4 hrs+15 min. Air cooled to ambient temp	930 min	7 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-75	 AC (70 OCV) /DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 350	80-100		
4.0 x 350	110-140		

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.