



S. R. Industries

STAR ARC ER630

ER630 is a precipitation hardening grade of stainless steel used for joining materials of similar chemical composition. Mechanical properties of this alloy are greatly influenced by the heat treatment.

AWS Specification : AWS A5.9/A5.9M:2006

AWS Classification	ER630
Welding Current	DCEP
Typical Wire Chemistry	
C	0.05
Cr	16.00 - 16.75
Ni	4.5 - 5.0
Mo	0.75
Mn	0.25 - 0.75
Si	0.75
P	0.03
S	0.03
Cu	3.25 - 4.00
Nb	0.15 - 0.30
Typical Mechanical Properties (As Welded post heat treatment between 1875° and 1625°F for one hour, followed by precipitation hardening between 1135°F and 1165°F for four hours)	
Yield Strength, ksi	135
Tensile Strength, ksi	150
Elongation%, min	10
Welding Positions	F,V,OH,H

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E.Mail : srindus@yahoo.com

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<i>Available Diameters MIG with Operating Range in Amps</i>	
<i>.030"</i>	<i>50 - 100</i>
<i>.035"</i>	<i>160 - 210</i>
<i>.045"</i>	<i>180 - 250</i>
<i>Available Diameters TIG with Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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