PRODUCT DATA SHEET

DURAMAX E630-16 premium electrode is specially designed for producing 17Cr - 4.5Ni and 3.5Cu weld deposit precipitation-hardening stainless steels.

Classification: AWS A5.4 / ASME SFA 5.4 E630-16

Typical Application

Specially designed for weld metal is modified to prevent the formation of ferrite networks in the martensite microstructure which could have a deleterious effect on mechanical properties. This electrode offers the combined characteristics of a strong, corrosion resistant, electrode gives machinable weld metal.

Characteristics on Usage

1) Suitable for joining ASTM A-564 hardenable steels.
2) Dependent on the application and weld size, the weld metal may be used either as-welded, welded and precipition hardened, or welded, solution treated and precipitation hardened.
3) Redry the electrode at 250°C for 60 minutes prior to use.

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Cr	Ni	Cu	Mo	Nb+Ta
0.05 max	0.25 - 0.75	0.75 max	0.030 max	0.040 max	16.00 - 16.75	4.50 - 5.00	3.25 - 4.00	0.75 max	0.15 - 0.30

All Weld Mechanical Properties (PWHT 630°C/4hrs):

YS 0.2% N/mm²	UTS N/mm²	El (%) (1=5d)
730 min	930 min	10 min

Sizes available and recommended currents (DC -) or (AC)

Dia.	**inch (mm)**	**3/32 (2.4mm)**	**1/8 (3.2mm)**	**5/32 (4.0mm)**	**3/16 (5.0mm)**
Amps		50~80	75~100	110~140	150~180

POLARITY: DCEN or AC
DCEN: DC, Electrode Negative (straight polarity) has the least weld penetration
AC: medium weld penetration (can be more spatter)
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please visit our website www.duramaxwelding.com