

## MIDALLOY CHROMAX E630-16 COATED ELECTRODE

### CLASSIFICATION

- AWS 5.4 Class E630-16 / ASME SFA 5.4 Class E630-16
- UNS# W37410
- ASME Sec. IX F#4 A# None

### DESCRIPTION

- MIDALLOY CHROMAX E630-16 is an AC-DC titania coated electrode.
- Chemical composition is controlled in order to meet higher strength levels obtained by secondary precipitation heat treatment.

### APPLICATION

- For welding or repairing martensitic precipitation hardening stainless steels material 17-4 PH (UNS 17400). In some case Midalloy E630-16 electrodes can also be used to join 15-5 PH(S15500) or 13-8Mo(S13800)
- Dissimilar metal combinations of carbon and low alloy steels to precipitation stainless steels.

### TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
.06	16.5	4.8	.20	0.50	.60	.020	.010	3.51	.

### TYPICAL MECHANICAL PROPERTIES (as welded)      PWHT (see below)

TENSILE STRENGTH	87,500 PSI	145,000 PSI
YIELD STRENGTH	59,500 PSI	130,000 PSI
ELONGATION IN 2"	35%	7%

PWHT: Anneal at 1900°F for one half to one hour, air cool to room temperature,  
Precipitation harden at 1100°F for 1 to 4 hours and air cool to room temperature

NOTE 1: Other secondary heat treatment temperatures will result in different mechanical values.

NOTE 2: For best weldability it is recommended that the base metal is supplied in the annealed, solution treated or overaged condition.

### RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32"	60-85	65-75
1/8"	85-120	80-90
5/32"	110-160	100-120
3/16"	120-190	110-130

### STANDARD PACKAGING

- 3/32" - 8 lb. can, 48 lb. Carton
- 1/8", 5/32", 3/16" - 10 lb. Can, 60 lb. Carton

6/30/16

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