TIG 17/4CU

Old reference: TIG 17-4Cu

Classification

AWS A5.9 : ER630 ISO 14343-A : W Z 17 4 Cu

Description & Applications

Solid rod for GTAW of stainless steels with similar chemical compositions like 17-4PH, X5CrNiCuNb17-4-4, XAS.

Main applications: Aerospace, marine pump and turbine, Repairing of turbine discs, turbine blades.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S
Min			0.25	16.00	4.5		3.25	0.15		
Max	0.05	0.75	0.75	16.75	5.0	0.75	4.00	0.30	0.025	0.025
Type	0.02	0.40	0.50	16.1	4.7	0.10	3.5	0.20	0.02	0.005

All Weld Metal Mechanical Properties*

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min		930	7	-	-
Max				-	-
Type	930	1030	10	-	-

* After PWHT at 1020-1050°C/1h, followed by a precipitation hardening at 610-630°C/4h

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 l/min Back shielding: I1 (Ar) / N1 (Nitrogen) : 3-6 l/min

FT En-TN36-200406