

AS 630

TOP FEATURES

- Extremely clean weld metal deposit
- Excellent Impact toughness and CTOD properties
- Highly resistant to moisture pick-up

CLASSIFICATION

Flux	EN ISO 14174: SA FB 1 55 AC H5	
Flux/wire	AWS A5.17	AWS A5.23
AS 35	F7A6/F6P8-EM12K	
AS 37LN	F7A8/F7P8-EH12K	
AS 40A		F8A4/F8P4-EA2-A2
AS 66		F9A8/F9P8-EF3-F3
AS 67		F8A10/F8P10-ENi6-Ni6
AS Cr1Mo	F8P4-EB2R-B2	
AS Cr2Mo	F8P2-EB3R-B3	

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Wire grade	C	Mn	Si	Cr	Ni	Mo
AS 35	0.07	0.9	0.2	-	-	-
AS 37LN	0.07	1.6	0.3	-	-	-
AS 40A	0.07	0.9	0.2	-	-	0.5
AS 66	0.07	1.5	0.3	-	0.95	0.5
AS 67	0.07	1.3	0.3	-	0.9	0.2
AS Cr1Mo	0.07	0.9	0.3	1.0	-	0.5
AS Cr2Mo	0.08	0.6	0.3	2.2	-	1.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)			
					0°C	-20°C	-40°C	-60°C
AS 35	AW	≥360	450-550	≥25	≥160	≥100		
AS 37LN	AW	≥450	530-630	≥25	≥180	≥140	≥100	≥70
AS 40A	AW	≥470	550-680	≥24	≥120	≥100	≥50	
AS 66	AW	≥550	650-750	≥20	≥120	≥90	≥70	≥47
	PWHT 600°Cx2h	≥540	630-730	≥22	≥140	≥120	≥90	≥70
AS 67	AW	≥500	560-680	≥22			≥145	≥70
	PWHT 600°Cx2h	≥470	550-660	≥24			≥160	≥70
AS Cr1Mo	PWHT 680°Cx2h	≥380	530-630	≥24		≥160		
	PWHT 920°C/air+710°C	≥310	430-530	≥30		≥160		
AS Cr2Mo	PWHT 720°Cx8h	≥450	550-650	≥22		≥80		
	PWHT 940°C/air+740°C	≥400	520-620	≥22		≥80		

*AW = As welded; PWHT = Post weld heat treatment

FLUX CHARACTERISTICS

Current type	AC, DC+
Basicity (Boniszewski)	3.1
Grain size (EN ISO 14174)	2-20

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
BAG	25.0	W000280317

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.