Tech-Rod® 630

AWS E630-16

CONFORMANCES

AWS A5.4 E630-16

ASME SFA-A5.4 E630-16

Tech-Rod® 630 is a precipitation hardening stainless steel covered electrode used for welding materials of similar chemical composition such as 17-4 and 17-7. Can be used in the as welded condition or may be heat treated to obtain higher strength. Mechanical properties of the alloy are greatly influenced by the heat treatment.

Applications: Hydralic equipment components, Impellars, Pump shafts

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	8 lb (3.6 kg) Tube 24 lb (10.9 kg) Master Carton	10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton
3/32 (2.4)	12 (305)	EL63016093632	
1/8 (3.2)	14 (355)		EL63016125634
5/32 (4.0)	14 (355)		EL63016156634
3/16 (4.8)	14 (355)		EL63016187634

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THE LINCOLN ELECTRIC COMPANY
22801 St. Clair Avenue • Cleveland, OH • 44117-1199 • U.S.A.
Phone: +1.216.481.8100 • www.lincolnelectric.com

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DEPOSIT COMPOSITION

	%C	%Cr	%Ni	%Mo	%Nb+Ta
Requirements AWS E630-16	0.05 max.	16.00 - 16.75	4.5 - 5.0	0.75 max.	0.15 - 0.30
Typical Results Tech-Rod® 630	0.03	16.30	4.8	0.11	0.16
	%Mn	**%Si**	**%P**	**%S**	**%Cu**
Requirements AWS E630-16	0.25 - 0.75	0.75 max.	0.04 max.	0.03 max.	3.25 - 4.00
Typical Results Tech-Rod® 630	0.62	0.36	0.02	0.01	3.43

* Nitrogen in these weld deposits is usually between 0.04% and 0.08%

TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Length in (mm)	Amperage Flat	Amperage Vertical & Overhead
3/32 (2.4)	12 (305)	70-85	65-75
1/8 (3.2)	14 (355)	85-110	80-90
5/32 (4.0)	14 (355)	110-140	100-120
3/16 (4.8)	14 (355)	120-160	110-130

Material Safety Data Sheets (MSDS) are available on our website at www.techalloy.com

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