

EXCALIBUR® 630-16

Stainless • AWS E630-16



KEY FEATURES

- A precipitation hardening stainless steel covered electrode used for welding materials 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

CONFORMANCES

AWS A5.4/A5.4M: 2006:	E630-16
ASME SFA A5.4:	E630-16

TYPICAL APPLICATIONS

- Hydraulic Equipment
- Impellers
- Pump Shafts
- Welding 17-4 and 17-7 Stainless Steels

WELDING POSITIONS

All, except vertical down

DIAMETERS / PACKAGING

Diameter		Length		8 lb (3.63kg) Easy Open Can	10 lb (4.5 kg) Easy Open Can
in	(mm)	in	(mm)	24 lb (10.89kg) Master Carton	30 lb (13.6 kg) Master Carton
3/32	(2.4)	12	(305)	ED035019 □	
1/8	(3.2)	14	(355)		ED035020
5/32	(4.0)	14	(355)		ED035021
3/16	(4.8)	14	(355)		ED035022

DEPOSIT COMPOSITION(1)

	%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(2)					
	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(2)					
	0.62	0.36	0.02	0.01	3.43

TYPICAL OPERATING PROCEDURES

	Current (Amps)			
Polarity	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
E385-16				
DC+/AC	40 - 80	75-110	95 - 150	130 - 200