

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY630

● Applicable Specification

JIS Z 3221 ES630-16
AWS A5.4 E630-16

● Identification Color

End Face: Orange
Side Face: —

● Applications and Characteristics

TASETO RNY630 is the electrode for use in welding of 17-4PH (Type 630) stainless steel that precipitation hardens by one-cycle heat treatment. Hardening is achieved precipitation treatment for one hour at 476°C. The hardness after the treatment is at least Hv350 at 300°C.

As its corrosion resistibility and hardness are comparable to 18%Cr-8%Ni stainless steel, excellent performance is obtained when used in overlay welding of valve seats where resistance to corrosion and wear is required.

● Notes on Usage

- * Dry the electrode at 150°C to 200°C for 60 minutes before use.
- * When overlay on mild steel, it is necessary to overlay more than three layers to obtain prescribed performance.
- * Keep preheating and interpass temperature at 100°C to 300°C.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Nb
Typical	0.039	0.33	0.34	0.018	0.007	4.61	16.20	0.08	3.56	0.20

● Mechanical Properties of All Weld Metal (PWHT : ST+620°C × 4h, AC)

	Tensile Strength (MPa)	5D Elongation (%)
Typical	968	11.8

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—