

CEWELD NiCrCo 617 Tig

TYPE Nickel based alloy with high heat resistance combined with excellent mechanical strength

APPLICATIONS CEWELD NiCrCo 617 is a high temperature alloy which is used for welding of nickel-chromium-cobalt-molybdenum alloys (UNS Number N06617). This filler metal can also be used for overlay cladding where similar alloy is required such as gas turbines and ethylene equipment.

PROPERTIES Weld metal provides optimum strength and oxidation resistance above 816°C (1500°) up to 1149°F (2100°F), especially when welding on base metals of nickel-iron-chromium alloys.

CLASSIFICATION

AWS	A 5.14: ERNiCrCoMo-1
EN ISO	18274: S Ni 6617(NiCr22Co12Mo9)
W.Nr.	2.4627
F-nr	43
FM	6

SUITABLE FOR **E Ni 6617(NiCr22Co12Mo), ENiCrCoMo-1, 2.4628**
 2.4663, 2.4851, 1.4876, 1.4859, 1.4952, 1.4958, 1.4959,
 NiCr21Co12Mo, NiCr23Co12Mo, NiCr23Fe, X6CrNiNbN 25 20, X5NiCrAlTi 31 20, X8NiCrAlTi 32 21,
 X10 NiCrAlTi 32 21, GX10 NiCrSiNb 32 20,
UNS: N06601, N06617, N08810, N08811
 Inconel Alloys 600 and 601, Incoloy Alloys 800 HT and 802 and cast Alloys such as HK-40, HP and HP-45 Modified, Alloy 617,

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

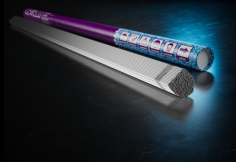
C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Co	Al
0.1	0.8	0.8	22	55	9	0.2	2.5	13	1

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	480	760	32	120		HRc

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD NiCrCo 617 Tig

NICRCo 617 TIG 1,6 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663419682

NICRCo 617 TIG 1,6 X
914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663419675

NICRCo 617 TIG 2,0 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663419705

NICRCo 617 TIG 2,0 X
914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663419699

NICRCo 617 TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663419729

NICRCo 617 TIG 2,4 X
914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663419712

NICRCo 617 TIG 3,2 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663419743

NICRCo 617 TIG 3,2 X
914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663419736