

CEWELD NiCrCo 617

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 815 °C (1500°F) up to 1149 °C (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 (%)

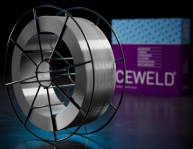
C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Co	Al
0.1	0.8	0.8	22	50	9	0.4	2.5	13	1

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	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

NICRCo 617 0,8MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663419569
NICRCo 617 0,9MM	Packaging	KG/unit	EanCode
	BS-300	13,6	8720663419576
NICRCo 617 1,14MM	Packaging	KG/unit	EanCode
	BS-300	13,60	8720663419583
NICRCo 617 1,2MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663419590
NICRCo 617 1,6MM	Packaging	KG/unit	EanCode
	BS-300	13,6	8720663419651