

NiCrCo 617

CATEGORY	GMAW-GTAW Solid wires																																				
TYPE	Nickel based alloy with high heat resistance combined with excellent mechanical strength																																				
APPLICATIONS	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 1500° up to 2100°F, especially when welding on base metals of nickel-iron-chromium alloys.																																				
CLASSIFICATION	AWS	A 5.14: ER NiCrCoMo-1 (UNS N06617)																																			
	EN ISO	18274: S Ni 6617 (NiCr22Co12Mo9)																																			
	DIN: W.Nr.	2.4627																																			
	DIN	1736: SG-NiCr22Co12Mo																																			
SUITABLE FOR	Inconel alloys 600 and 601, Incoloy alloys 800 HT and 802 and cast alloys such as HK-40, HP and HP-45 Modified. UNS Number N06617, 2.4663, 1.4952, 1.4958, 1.4959, NiCr21Co12Mo, X6CrNiNbN 25 20, X5NiCrAlTi 31 20, X8NiCrAlTi 32 21, Alloy 617, N08810, N08811																																				
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WELDING POSITIONS:																																					
ALL WELD METAL DEPOSIT (WEIGHT %)	<table border="1"> <thead> <tr> <th>C</th> <th>Fe</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Co</th> <th>Mo</th> <th>Ti</th> </tr> </thead> <tbody> <tr> <td><0.15</td> <td><3.0</td> <td><1.0</td> <td>20-24</td> <td>Rem</td> <td>10-15</td> <td>8-10</td> <td><0.6</td> </tr> </tbody> </table>							C	Fe	Si	Cr	Ni	Co	Mo	Ti	<0.15	<3.0	<1.0	20-24	Rem	10-15	8-10	<0.6														
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GAS ACC. EN ISO 14175:	I1, I3 (Ar-He)																																				