

E NiCrCo 617

CATEGORY SMAW Stick Electrodes

TYPE Nickel based electrode with high heat resistance combined with high strength

APPLICATIONS NiCrCo 617 is a covered electrode which is used for welding of nickel-chromium-cobalt-molybdenum alloys (UNS Number N06617). This electrode can also be used for overlay cladding where similar alloy is required. 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.

PROPERTIES High mechanical properties combined with excellent high temperature properties with excellent weldability on DC+.

CLASSIFICATION

AWS	A 5.11: E NiCrCoMo-1
EN ISO	14172: E Ni 6617
DIN: W.Nr.	2.4628
DIN	1736: EL-NiMo15Cr

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

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Fe	S	Ni	Si	Cu	Cr	Nb+Ta	Mo	Co	P	Other
0.05-0.15	0.30-2.50	< 5.0	< 0.015	bal	< 0.75	< 0.50	21.0-26.0	< 1.0	8.0-10.0	9.0-15.0	< 0.03	< 0.50

MECHANICAL PROPERTIES

Heat Treatment	Tensile strength		Yield strength		Elongation (%)	Impact strength (ft.lbs)
	(PSI)	(MPA)	(PSI)	(MPA)		
AW	110	760	87	600	26	60

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.4	229	40-60			
3.2	356	75-100			
4.0	356	90-130			