



NICALLOY 617

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 ENiCrCoMo-1

CLASSIFICATION:

ISO 14172

E Ni 6117 (NiCr22Co12Mo)

KEY FEATURES:

- Basic coated non synthetic electrode
- Ni-Cr-Co-Mo-Fe type weld
- Resistant to hot cracking
- Optimum strength, creep and oxidation resistance above 820°C upto 1150°C in wide variety of corrosive media

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of Ni-Cr-Co-Mo type and similar grade alloys to themselves and to steel
- Incoloy 800HT, 803 and cast alloys such as HK-40, HP and HP-45 modified
- Welding of Inconel 617 alloy
- For surfacing steel with Ni-Cr-Co-Mo weld metal
- Suitable for application in ethylene production plants, gas turbines etc.
- Suitable for material 1.4958, 1.4959, 2.4663
- Aerospace industry for engine components, after burners, turbine seals, heat treating equipment and high temperature service applications


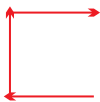
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni	Co	Cr	Mo	Fe
0.09	1.9	0.6	57	11.5	23.5	9.5	3.0

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	620 min	25 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	50-70	 AC (70 OCV)/DCEP All Positions, except vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 350	70-95	
4.0 x 350	90-120	

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.