



TIGFIL 617

GTAW NICKEL ALLOYS

AWS A/SFA 5.14 ERNiCrCoMo-1

CLASSIFICATION:

EN ISO 18274

SNi 6617 (Ni Cr22 Co12 Mo9)

KEY FEATURES:

- Nickel alloy bare solid wire
- 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

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


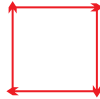
CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Fe	Si	Cu	Ni	Co	Al	Ti	Cr	Mo
0.05-0.15	1.0 max	3.0 max	1.0 max	0.50 max	Bal.	10.0-15.0	0.8-1.5	0.60 max	20.0-24.0	8.0-10.0

MECHANICAL PROPERTIES OF ALL WELD METAL:

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

PARAMETERS - PACKING DATA:

Ø, mm	Net Wt, Kg		
1.6 x 1000	20	 DCEN STORAGE / HANDLING : Keep dry during storage and handling	All Positions 
2.0 x 1000	20		
2.4 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.