TIG NI617

Classification

AWS A5.14 : ERNiCrCoMo-1 ISO 18274 : S Ni6617 (NiCr22Co12Mo9)

Description & Applications

Solid rod for GTAW and repairing of high temperature alloys used at service temperatures up to 1100°C.

Main applications: Construction of gas turbines, combustion chambers, ovens, thermal equipment for heat treatment, petrochemical installation.

Base materials:

UNS	Alloy	DIN	Material N°
N08810	800H	X5NiCrAlTi3120	1.4958
	DS	X8NiCrSi3818	1.4862
N06601	601	NiCr23Fe	2.4851
N06617	617	NiCr23Co12Mo	2.4663

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	Cu	P
Min	0.05			20.0	8.0		
Max	0.15	1.0	1.0	24.0	10.0	0.50	0.03
Type	0.07	0.20	0.50	22.0	8.5	0.03	0.01

	S	Fe	W	Co	Al	Ti	Ni
Min				10.0	0.8		44.0
Max	0.015	3.0	0.5	15.0	1.5	0.60	
Type	0.005	0.90	0.01	11.2	1.0	0.40	>44.0

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	-	-	-	-	-
Max					
Type	450	750	30	+20°C	110

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175: I1 (Ar) : 6-12 l/min Back shielding : I1 (Ar) : 3-6 l/min

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