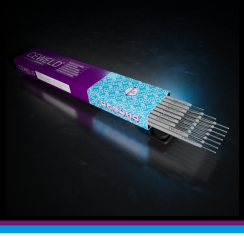


CEWELD E NiCrCo 617

certilas® THE FILLER METAL SPECIALIST

TYPE

Nickel based electrode with high heat resistance combined with high strength

APPLICATIONS

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

PROPERTIES

CEWELD® E NiCrCo 617 provides optimum strength and oxidation resistance above 1150 °C (2100 °F), especially when welding on base metals of nickel-iron-chromium alloys. 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 6117 (NiCr22Co12Mo)
W.Nr.	2.4628
F-nr	43
FM	6

SUITABLE FOR

E Ni 6617(NiCr22Co12Mo), ENiCrCoMo-1, 2.4628
2.4663, 2.4851, 1.4876, 1.4859, 1.4952, 1.4958, 1.4959,
NiCr21Co12Mo, NiCr23Co12Mo, NiCr23Fe, X6CrNiNbN 25 20, X5NiCrAlTi 31 20, X8NiCrAlTi 32 21, X10 NiCrAlTi 32 21, GX10 NiCrSiNb 32 20,
UNS: N06601, N06617, N08810, N08811
Inconel Alloys 600 and 601, Incoloy Alloys 800 HT and 802 and cast Alloys such as HK-40, HP and HP-45 Modified, Alloy 617,

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Co	Cu	Nb+Ta
0.1	0.7	2	24	55	9	3.5	12	0.3	0.8

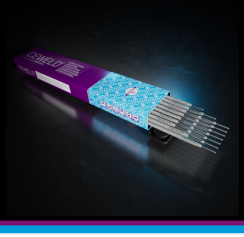
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	430	660	29	120	HRc

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCrCo 617

certilas® THE FILLER METAL SPECIALIST

E NICRCO 617 2,4 X 229MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419385

E NICRCO 617 3,2 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419392

E NICRCO 617 4,0 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419408