



# CEWELD E NiCrCo 617

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. Weld metal provides optimum strength and oxidation resistance above 1150 °C ( 2100 °F), especially when welding on base metals of nickel-iron-chromium alloys.										
PROPRIÉTÉS	High mechanical properties combined with excellent high temperature properties with excellent weldability on DC+.										
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.11: E NiCrCoMo-1</td> </tr> <tr> <td>EN ISO</td> <td>14172: E Ni 6117 (NiCr22Co12Mo)</td> </tr> <tr> <td>W.Nr.</td> <td>2.4628</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.11: E NiCrCoMo-1	EN ISO	14172: E Ni 6117 (NiCr22Co12Mo)	W.Nr.	2.4628	F-nr	43	FM	6
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CONVIENT POUR	<p><b>E Ni 6617(NiCr22Co12Mo), ENiCrCoMo-1, 2.4628</b>            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,  <b>UNS: N06601, N06617, N08810, N08811</b>            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,</p>										

## AGRÉMENTS

## POSITIONS DE SOUDAGE



## 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

## PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R <sub>p0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	430	660	29	120		HRc

ETUVAGE 300°C / 2 hr

GAS ACC. EN ISO 14175



# CEWELD E NiCrCo 617

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