



# SELECTARC MIG NI617

Old reference : MIG Ni617

## Classification

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

Material.N° : 2.4627

## Characteristics

Solid GMAW Wire for joining and repairing of high temperature alloys used at operation temperatures upto 1100° C.

## Applications

Construction of Gas turbines, Combustion chambers, Ovens, Thermal equipment for heat treatment, Petrochemical installation.

## Base Materials

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

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Mo	Co	Fe	Al	P	S	Ti	Ni
0.07	0.20	0.50	22.00	8.50	11.20	0.90	1.00	0.020	0.010	0.40	base

## All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R <sub>m</sub> (MP <sub>a</sub> )	YS R <sub>p0.2</sub> (MP <sub>a</sub> )	%Elg A <sub>5</sub>	Impact (KV) Temp.°C	J
AW	>750	>450	>30	+20	>110

## Welding current & Instructions

Welding Mode	Ø of Wire (mm)	Welding Parameter		Shielding Gas
		Current (A)	Voltage (V)	
MIG = +	0.8	80-140	23-27	Ar Ar+He Ar/He + 0.05% CO <sub>2</sub> 18-20 l/min
	1.0	90-160	24-28	
	1.2	160-200	24-28	
	1.6	180-260	24-28	

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