SELECTARC MIG NI617

Old reference : MIG Ni617

Classification

AWS A5.14 : ERNiCrCoMo-1 Material.N° : 2.4627
ISO 18274 : S-NiCr22Co12Mo9

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_m (MP_a)	YS $R_{p0.2}$(MP_a)	%Elg A_5	Impact (KV) Temp.^{0}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 1.0 1.2 1.6	80-140 90-160 160-200 180-260	23-27 24-28 24-28 24-28	Ar Ar+He Ar/He + 0.05% CO_2 18-20 l/min