



NICALLOY 617

NON FERROUS (Ni Alloys)



Ni-Cr-Co-Mo-Fe type welding electrode

CLASSIFICATION : ISO 14172

AWS A/SFA 5.11

E Ni 6117

E NiCrCoMo-1

KEY FEATURES :

- Basic coated non synthetic electrode
- Ni-Cr-Co-Mo-Fe type weld
- Resistant to hot cracking
- Optimum strength, creep and oxidation resistance above 820°C upto 1150°C in wide variety of corrosive media

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Welding of Ni-Cr-Co-Mo type and similar grade alloys to themselves and to steel
- Incoloy 800HT, 803 and cast alloys such as HK-40, HP and HP-45 modified
- Welding of Inconel 617 alloy
- For surfacing steel with Ni-Cr-Co-Mo weld metal
- Suitable for application in ethylene production plants, gas turbines etc.
- Suitable for material 1.4958, 1.4959, 2.4663
- Aerospace industry for engine components, after burners, turbine seals, heat treating equipment and high temperature service applications

REDRYING CONDITION : 250-300°C for minimum 1 hr

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Fe	P	S	Si
Specification	0.05-0.15	0.3-2.5	5.0 max	0.03 max	0.015 max	0.75 max
	Cu	Ni	Co	Cr	Nb+Ta	Mo
Specification	0.50 max	Rem.	9.0-15.0	21.0-26.0	1.0 max	8.0-10.0

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	620 min	25 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	50-70	1	10	10
3.15 x 350	70-95	1	10	10
4.0 x 350	90-120	1	10	10