TIG NI617

Old reference: TIG Ni617

Classification

ISO 18274 : S-Ni6617 (NiCr22Co12Mo9)
AWS A5.14 : ERNiCrCoMo-1
Material N° : 2.4627
DIN 1736 : SG-NiCr22Co12Mo

Description & Applications

Solid GTAW rod for joining and repairing of high temperature alloys used at operation temperatures up to 1100°C.

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

Base materials

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

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Co	Fe	Al	Ti	Ni
0.07	0.2	0.5	22.0	8.5	11.2	0.9	1.0	0.4	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>450	>750	>30	+20°C >110

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon : 3-6 l/min

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