



# CEWELD NiCrCo 617 Tig

|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                 |                      |        |                         |    |     |     |          |    |
|------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------|----------------------|--------|-------------------------|----|-----|-----|----------|----|
| TYPE                                           | Nickel based alloy with high heat resistance combined with excelent mechanical strength                                                                                                                                                                                                                                                                                                                                                                           |                                 |                      |        |                         |    |     |     |          |    |
| ANWENDUNGEN                                    | CEWELD NiCrCo 617 is a high temperature alloy which is used for welding of nickel-chromium-cobalt-molybdenum alloys (UNS Number N06617). This filler metal can also be used for overlay cladding where similar alloy is required such as gas turbines and ethylene equipment.                                                                                                                                                                                     |                                 |                      |        |                         |    |     |     |          |    |
| EIGENSCHAFTEN                                  | Weld metal provides optimum strength and oxidation resistance above 816°C (1500°) up to 1149°F (2100°F), especially when welding on base metals of nickel-iron-chromium alloys.                                                                                                                                                                                                                                                                                   |                                 |                      |        |                         |    |     |     |          |    |
| KLASSIFIKATION                                 | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                               | A 5.14: ERNiCrCoMo-1            |                      |        |                         |    |     |     |          |    |
|                                                | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 18274: S Ni 6617(NiCr22Co12Mo9) |                      |        |                         |    |     |     |          |    |
|                                                | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 2.4627                          |                      |        |                         |    |     |     |          |    |
|                                                | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 43                              |                      |        |                         |    |     |     |          |    |
|                                                | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 6                               |                      |        |                         |    |     |     |          |    |
| GEEIGNET FÜR                                   | <b>E Ni 6617(NiCr22Co12Mo), ENiCrCoMo-1, 2.4628</b><br>2.4608, 2.4663, 2.4851, 1.4876, 1.4859, 1.4952, 1.4958, 1.4959,<br>NiCr26MoW, NiCr21Co12Mo, NiCr23Co12Mo, NiCr23Fe, X6CrNiNbN 25 20, X5NiCrAlTi 31 20,<br>X8NiCrAlTi 32 21, X10 NiCrAlTi 32 21, GX10 NiCrSiNb 32 20,<br><b>UNS: N06601, N06617, N08810, N08811</b><br>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, Alloy 333 |                                 |                      |        |                         |    |     |     |          |    |
| ZULASSUNGEN                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                 |                      |        |                         |    |     |     |          |    |
| SCHWEISSPOSITIONEN                             |                                                                                                                                                                                                                                                                                                                                                                                |                                 |                      |        |                         |    |     |     |          |    |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Si                              | Mn                   | Cr     | Ni                      | Mo | Ti  | Fe  | Co       | Al |
|                                                | 0.1                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 0.8                             | 0.8                  | 22     | 55                      | 9  | 0.2 | 2.5 | 13       | 1  |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                    | R <sub>P0,2</sub> (MPa)         | R <sub>m</sub> (MPa) | A5 (%) | Impact Energy (J) ISO-V |    |     |     | Hardness |    |
|                                                | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 480                             | 760                  | 32     | RT                      |    |     |     | HRc      |    |
| RÜCKTROCKNUNG                                  | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                 |                      |        |                         |    |     |     |          |    |
| GAS ACC. EN ISO 14175                          | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                 |                      |        |                         |    |     |     |          |    |



# CEWELD NiCrCo 617 Tig

NICRCo 617 TIG 1,6 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663419682 |

NICRCo 617 TIG 1,6 X  
914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663419675 |

NICRCo 617 TIG 2,0 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663419705 |

NICRCo 617 TIG 2,0 X  
914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663419699 |

NICRCo 617 TIG 2,4 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663419729 |

NICRCo 617 TIG 2,4 X  
914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663419712 |

NICRCo 617 TIG 3,2 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663419743 |

NICRCo 617 TIG 3,2 X  
914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663419736 |