



CEWELD E NiCrCo 617

TYPE Nickel based electrode with high heat resistance combined with high strength

APPLICATIONS **CEWELD® E NiCrCo 617** is a covered electrode which is used for welding of nickel-chromium-cobalt-molybdenum alloys (UNS Number N06617). This electrode can also be used for overlay cladding where similar alloy is required.
Main applications: Construction of gas turbines, combustion chambers, ovens, thermal equipment for heat treatment, petrochemical installation..

PROPERTIES **CEWELD® E NiCrCo 617** provides optimum strength and oxidation resistance above 1150 °C (2100 °F), especially when welding on base metals of nickel-iron-chromium alloys. High mechanical properties combined with excellent high temperature properties with excellent weldability on DC+.

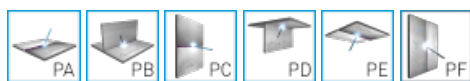
CLASSIFICATION

AWS	A 5.11: E NiCrCoMo-1
EN ISO	14172: E Ni 6117 (NiCr22Co12Mo)
W.Nr.	2.4628
F-nr	43
FM	6

SUITABLE FOR **E Ni 6617(NiCr22Co12Mo), ENiCrCoMo-1, 2.4628**
 2.4663, 2.4851, 1.4876, 1.4859, 1.4952, 1.4958, 1.4959,
 NiCr21Co12Mo, NiCr23Co12Mo, NiCr23Fe, X6CrNiNbN 25 20, X5NiCrAlTi 31 20, X8NiCrAlTi 32 21,
 X10 NiCrAlTi 32 21, GX10 NiCrSiNb 32 20,
UNS: N06601, N06617, N08810, N08811
 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,

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Co	Cu	Nb+Ta
0.1	0.7	2	24	55	9	3.5	12	0.3	0.8

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	430	660	29	120		HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCrCo 617

E NICRCo 617 2,4 X 229MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663419385
E NICRCo 617 3,2 X 356MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663419392
E NICRCo 617 4,0 X 356MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663419408