



# CEWELD NiCrCo 617

**TYPE** Nickel based alloy with high heat resistance combined with excellent mechanical strength

**APPLICATIONS** 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.

**PROPERTIES** Weld metal provides optimum strength and oxidation resistance above 815 °C (1500°F) up to 1149 °C (2100°F), especially when welding on base metals of nickel-iron-chromium alloys.

**CLASSIFICATION**

AWS	A 5.14: ERNiCrCoMo-1
EN ISO	18274: S Ni 6617(NiCr22Co12Mo9)
W.Nr.	2.4627
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 THE FILLER METAL (%)**

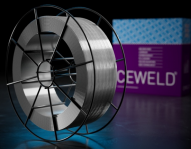
C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Co	Al
0.1	0.8	0.8	22	50	9	0.4	2.5	13	1

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	480	760	32	120		HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD NiCrCo 617

NICRCo 617 0,8MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663419569
NICRCo 617 0,9MM	Packaging	KG/unit	EanCode
	BS-300	13,6	8720663419576
NICRCo 617 1,14MM	Packaging	KG/unit	EanCode
	BS-300	13,60	8720663419583
NICRCo 617 1,2MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663419590
NICRCo 617 1,6MM	Packaging	KG/unit	EanCode
	BS-300	13,6	8720663419651