



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 2.4608, 2.4663, 2.4851, 1.4876, 1.4859, 1.4952, 1.4958, 1.4959, NiCr26MoW, 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, Alloy 333		

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

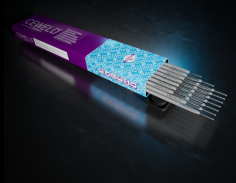
C	Si	Mn	Cr	Ni	Mo	Fe	Co	Cu	Nb+Ta
0.1	0.7	2	24	55	9	3.5	12	0.3	0.8

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	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