

NICROWELD 617

Electrodes MMA [SMAW]

Nickel alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14172-A : E Ni 6617 (NiCr22Co12Mo9) DIN 1736 : EL NiCr21Co12Mo AWS A-5.11 : E NiCrCoMo-1 W.Nr. : 2.4628		Power generation industry Constructions & Engineering Petrochemical and chemical industry

- Basic electrode with a nickel-based alloy core.
- Suitable for welding NiCrCoMo alloys and for plating similar alloys.
- The deposit is resistant to oxidation and is resistant to temperatures from 900 to 1250°C, especially when welding NiFeCr alloys.

Application

Welds on dedicated materials
 Dissimilar welds.
 Welds with high-carbon, heat-resistant materials, casting alloys.
 Elements of furnaces, pyrolysis, parts for gas ducts and turbines.
 Trays, baskets and equipment for heat treatment plants, i.e. for carburizing purposes.
 Combustion chambers in solid waste incineration plants.
 Components in exhaust systems.
 Pipe supports and ash handling elements.

Base material



W.Nr	DIN	Alloy
1.4876	X10NiCrAlTi32-20	800
2.4851	NiCr23Fe15Al	601H
1.4859	GX10NiCrNb32-20, GX10NiCrSiNb32-20	
2.4663	NiCr23Co12Mo	617
		Nicrofer 5520Co
		800HT
		Nicrofer 3220H
		Nicrofer 6023
		RA333
		Cast HK40
		HP40Nb
1.4958	X5NiCrAlTi31-20	800H

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	Fe	Co	Al
0,06	0,35	0,45	21,5	base	9,0	1,5	12,0	0,65

Typical mechanical properties

Yield strength Re [N/mm²]	>600
Tensile strength Rm [N/mm²]	>760
Elongation A5 [%]	>26
Hardness	225-235HB /
Coating type	basic

Welding current	
Welding positions	
Redrying	300 - 350°C / 2 h
Additional description	Microstructure of high-nickel austenite with carbides. Interstitch temperature not higher than 150[°C].

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
2,5	350 /	65-75	1,0	6,0
3,2	350 /	90-105	1,0	6,0
4,0	350 /	120-135	1,0	6,0
5,0	450 /	135-155	1,0	6,0

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