



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)								
	F-nr	43								
	FM	6								
	W.Nr.	2.4628								
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	No Approvals Found									
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
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT					
	As Welded /	430	660	29	120					
REDRYING TEMPERATURE	300°C / 2 hr									
GAS ACCORDING EN 14175										



CEWELD E NiCrCo 617

E NIRCOC 617 2,4 X 229MM

Type	KG/unit	EANCode
Can	2,27	8720663419385

E NIRCOC 617 3,2 X 356MM

Type	KG/unit	EANCode
Can	2,27	8720663419392

E NIRCOC 617 4,0 X 356MM

Type	KG/unit	EANCode
Can	2,27	8720663419408