

SMT-617

Type : MIG/TIG

Conformances

AWS A5.14/ ASME SFA5.14 ERNiCrCoMo-1
 JIS Z3334 SNI6617 (NiCr22Co12Mo19)
 EN ISO 18274 SNI 6617 (NiCr22Co12Mo9)

Applications

- Incoloy 800HT, 803, cast alloys such as HK-40, HP, HP-45 modified

Features

- Used for joining various dissimilar high temperature alloys the weld metal's high temperature strength, oxidation resistance and metallurgical stability from 815°C up to 1150°C

Welding Position

Current

GMAW: DC+(Pulse)
 GTAW: DC-

Shielding Gas

Ar, Ar+He

Diameter / Packaging

Diameter	MIG	TIG
mm (in)	12.5kg (27.6lbs)	5kg (11lbs)
1.0 (0.039)	✓	
1.2 (0.045)	✓	
1.6 (1/16)	✓	✓
2.0 (5/64)		✓
2.4 (3/32)		✓
3.2 (1/8)		✓

Typical Chemical Composition of the Wire (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Al	Co
0.07	0.30	0.30	0.003	0.010	54.6	22.3	8.8	1.2	11.2

Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in ²)	TS Mpa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
-	765 (111,000)	20	-196 (-321)	92 (66)

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX