



Characteristics and scope of application

- Filler metal for Alloy 617, high temperature / corrosion resistant steels and Ni-alloys
- Recommended for matching and dissimilar welds of the above mentioned alloys and mild steels

Standard designations

| | | |
|---------------------------|--------------|--------------|
| DIN EN ISO 18274 | AWS A5.14 | DIN Mat.-No. |
| S Ni 6617 (NiCr22Co12Mo9) | ERNiCrCoMo-1 | 2.4627 |

Typical chemical composition of filler metal

| | C | Co | Cr | Ni | Mo | Al | Ti | Fe |
|--------|------|------|------|------|-----|-----|-----|-------|
| Mass % | 0.05 | 11.0 | 22.0 | Bal. | 9.0 | 1.2 | 0.8 | < 1.0 |

All weld metal properties (min. values at rt)

| Heat treatment | Yield strength | Tensile strength | Elongation | Impact toughness | |
|----------------|----------------|------------------|----------------|------------------|--|
| | Rp0.2 | R _m | A ₅ | ISO-V | |
| as welded | 58 ksi | 94 ksi | 35% | 100 J | |

Welding instructions

| Polarity | Shielding gas acc. to AWS A5.32 |
|---|---|
| DC / + | G-A, SG-AHe, SG-A-G (He 30% - H 2% - C ~0.1) |
| DC / - | SG-A, SG-AHe, SG-AH (max. 5% H ₂ DC / -) |
| Low heat input and interpass temperature < 302°F. Stringer bead technique recommended. | |
| Base materials | |
| 2.4663 – NiCr23Co12Mo – Alloy 617 – UNS06617 | |
| 1.4876 – X10NiCrAlTi32-31 – Alloy 800 H – UNS 08811 | |

Packaging (tolerances acc. to AWS A5.02)

| Diameter (in) | | lbs/PU |
|---------------|---------------------|---------|
| 1/16 - 1/8 | X 36 in | 11 / 22 |
| 0.035 – 0.045 | BS 300 spool | 33 |
| 0.06 – 1/8 | K 415 / K 435 spool | 55 |

Approvals on request