

Ni-Cr-Co-Mo Filler Metal

INCONEL® Filler Metal 617



37

INCONEL® Filler Metal 617

INCONEL Filler Metal 617 is used for gas-tungsten-arc and gas-metal-arc welding of INCONEL alloy 617. Because of the weld metal's high temperature strength, oxidation resistance, and metallurgical stability, the filler metal is also used for joining various dissimilar high-temperature alloys. Examples are INCOLOY alloys 800HT and 803 and cast alloys such as HK-40, HP, and HP-45 Modified.

Specifications

AWS A5.14 ERNiCrCoMo-1 (UNS N06617)

ASME II, Part C, SFA-5.14, ERNiCrCoMo-1 (UNS N06617)

*BS 2901 NA 50

*DIN 1736 SG-NiCr22Co12Mo (2.4627)

*(EN) ISO 18274 – SNi 6617 (NiCr22Co12Mo9)

*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), Rolls Royce, AMS and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition

Ni	Remainder	Mn	1.0 max.
Cr	20.0-24.0	Si	1.0 max.
Co	10.0-15.0	S	0.015 max.
Mo	8.0-10.0	Ti	0.60 max.
Al	0.80-1.50	Cu	0.50 max.
C	0.05-0.15	P	0.03 max.
Fe	3.0 max.	Others	0.50 max.

Minimum Mechanical Properties

Tensile Strength, psi	90,000
MPa	620
Elongation, (4d) %	25

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
----------	--------------	--------------	--------------	---------------	--------------	--------------	--------------	--------------

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)