

NCrCoM1

Comparable specifications

ASME SFA A 5.14: ERNiCrCoMo-1
EN ISO 18274: Ni 6617 - NiCr22Co12Mo9
BS 2901: Pt 5 NA 50
Werkstoff Nr.: 2.4627

Description and applications*

* *Illustrative, not-exhaustive list*

This grade may be used for:

- welding of low-carbon nickel-chromium-cobalt-molybdenum alloys to itself and to steel;
- surfacing of steel;
- joining of dissimilar high-temperature alloys where high-temperature strength and oxidation resistance are required up to about 1150°C;
- casting of high-nickel alloys.

Weldable base materials*

* *Illustrative, not-exhaustive list*

UNS N06617, UNS N08800, UNS N08811

All-weld metal mech. properties*

* *For reference only values*

Tensile strength (Rm): ≥ 620 N/mm²

Chemical composition*

* *For reference only values*

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Al	Ti	Cr	Mo
0.05	max	max	max	max	max	max	44.00	10.00	0.80	max	20.00	8.00
0.10	1.00	1.00	0.020	0.015	0.50	0.50	min	14.00	1.50	0.60	24.00	10.00

Standard packaging data*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	15 (33)	n.a.
GTAW **	filler rod	1.60 - 4.00 (1/16 - 5/32)	cardboard boxes / tubes	5 (11)	1000 (39.4)

* *Other sizes and packing types are available upon request*

** *GMAW: gas metal arc welding; GTAW: gas tungsten arc welding*

Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

Customized labels are available upon request.

Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.