Technical Datasheet
IGS-Chronin 617
Wire Electrode / Welding Wire / GTAW Rod

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	
	$R_{p0.2}$	R_m	A_5	ISO-V	
as welded	400 MPa	650 MPa	35%	100 J	

Welding instructions

Polarity	Shielding gas acc. to DIN EN ISO 14175
DC / +	I1, I3, Z (ArHeHC-30/2/~0.1)
DC / -	I1, I3, R1 (max. 5% H_2)
Low heat input and interpass temperature < 150°C. 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 DIN EN ISO 544)

Diameter (mm)		Kg
1.6 / 2.0 / 2.4 / 3.2	X 1000 mm	5 / 10
0.8 / 1.0 / 1.2	BS 300 spool	15
1.6 / 2.4 / 3.2	K 415 / K 435 spool	25

Approvals on request

Deutsche Nickel