

61-70

MIG (GMAW)

SOLID WIRE FOR MIG

PRODUCT DESCRIPTION

Solid wire for MIG welding alloy 617.

CLASSIFICATIONS

AWS A5.14M ERNiCrCoMo-1
ISO 18274 S Ni 6617

ASME IX QUALIFICATION

QW432 F-No 43

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Co	Mo	Cu	Fe	Al	Ti
Min.	0.05	--	--	--	--	20.0	44.0	10.0	8.0	--	--	0.80	--
Max.	0.15	1.0	0.5	0.015	0.020	24.0	bal	15.0	10.0	0.5	3.0	1.50	0.60
Typical	0.08	0.1	0.1	0.002	<0.01	22	55	12	9	<0.2	0.5	1	0.3

ALL-WELD MECHANICAL PROPERTIES

As welded	Min.	Typical
Tensile strength [MPa]	620	710
0.2% proof strength [MPa]	400	450
Elongation [%] 4d	25	42
5d	30	40
Impact ISO-V(J) +20°C	--	>100
-196°C	--	75
Hardness cap/mid [HV]	--	--

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon *	DC+	1.2	220A, 30V

*Proprietary Ar/He mixtures also suitable.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
0.8	15	S300	M6170-08
1.0	15	S300	M6170-10

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr ³	Ni	Mo	Co	OES (mg/m ³)
1	1	17	45	9	11	0.9

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.