

61-70

TIG (GTAW)

SOLID ROD FOR TIG

PRODUCT DESCRIPTION

Solid rod for TIG 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

Typical values as welded	RT
Tensile strength [MPa]	770
0.2% proof strength [MPa]	550
Elongation [%] 4d	35
5d	32
Reduction of area [%]	40
Impact ISO-V[J] +20°C	230
-196°C	75
Hardness cap/mid [HV]	200/225

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon*	DC-	2.4	100A, 12V

* Also required as a purge for root runs.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	T6170-16
2.0	2.5	PE TUBE	T6170-24