

## Exaton NiCrCoMo-1

NiCrCoMo-1 is a nickel-chrome-cobalt-molybdenum alloy of type alloy 617. It has an excellent resistance to high temperature corrosion such as oxidation and carburization. The weld metal provides a combination of excellent metallurgical stability and strength in short and long term exposure to temperatures up to 1100°C (2012°F).

Applications for NiCrCoMo-1 are found in high temperature heat exchangers and valves, furnace tubing in the petrochemical industry, radiant heat tubes, gas turbines, components subjected to high temperatures in the chemical processing industry and components for power plants.

NiCrCoMo-1 is suitable for joining heat resistant nickel alloys, heat resistant austenitic and cast alloys such as:

- UNS N08810 (1.4958)
- UNS N08811 (1.4959)
- UNS N06617 (2.4663)

NiCrCoMo-1 can also be used for surfacing. It is used for MIG/MAG welding.

<b>Classifications Wire Electrode</b>	SFA/AWS A5.14 : ERNiCrCoMo-1 EN ISO 18274 : S Ni 6617 (NiCr22Co12Mo9) Werkstoffnummer : 2.4663
<b>Approvals</b>	CE EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	130 J (96 ft-lb)
As Welded	-196 °C (-321 °F)	105 J (78 ft-lb)

### Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Ti
0.08	<=1.0	<=1.0	<=0.010	<=0.010	53	22.5	9	1	<=0.6

### Typical Wire Composition %

Co	Fe
12	<=1.0

### Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
1.0 mm (0.040 in.)	60-220 A	15-28 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)