


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Coated SMAW Electrode</b>  <b>WA GAMMA 617-E</b>	
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#### CLASSIFICATION

ASME II C SFA 5.11 / AWS A 5.11:	ENiCrCoMo-1
EN ISO 14172:	E Ni 6117 (NiCr22Co12Mo)
UNS number:	W86117
Material number :	2.4628
ASME IX Qualification	QW432 F-N° 43

#### DESCRIPTION

- Basic coated SMAW electrode
- Ni - 22% Cr - 11% Co - 9% Mo weld deposit meeting the ENiCrCoMo-1 requirements
- For high temperature applications up to 1100°C
- Good microstructural stability, high creep strength, excellent resistance to oxidation and carburisation.

#### APPLICATIONS

WA GAMMA 617-E is suitable for welding and cladding nickel-based alloys such as alloy 617 or other heat resistant nickel base materials operating above 950°C.

#### Examples:

Alloy	UNS	EN Symbol	Material number
617	N06617	NiCr23Co12Mo	2.4663
601	N06600	NiCr15Fe	2.4816
800	N08800	X10 NiCrAlTi 32-21	1.4876
800H	N08810	X10 NiCrAlTi 32-21	1.4876
800HT	N08811	X8 NiCrAlTi 32-21	1.4959

#### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Co	Al	Ti	Fe	Ni
0.07	1.0	0.4	24.0	9.0	12.0	0.7	0.3	1.0	Bal.

#### MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> %	CVN [J]
620	400	22	+20°C : 47

#### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> %	CVN [J]
760	520	40	+20°C : 100

#### OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Current [A]	50-80	70-100	90 -130
= +	~ 70V		

Re-drying: if necessary 1h at 350°C.

#### WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE  
ASME IX: 1G, 2G, 2F, 3G, 4G

#### PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Weight/box [kg]	4.0	5.0	5.0

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.