

DT-2.4627

## Nickel Alloy MIG/MAG-Wire TIG - Rods

**Specification:**

EN ISO 18274: SG NiCr22Co12Mo9  
(S Ni 6617)  
AWS-A5.14: ER NiCrCoMo-1

**Application:**

Welding wires used for joining of alloy 617 and various dissimilar high temperature alloys like 800H/HP and 803.

**Chemical Composition  
Element by weight (%):**

Ni: Balance C: 0,06 Si: 0,3 Cr: 22 Mn: <1,00  
Mo: 9 Fe: 1,5 Co: 12 Al: 1 Ti: 0,3

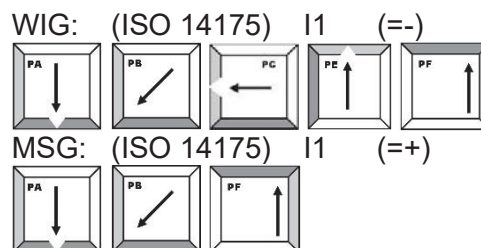
**Mechanical Properties:  
(typical)**

Yield strength (Rp0,2) ~450 N/mm<sup>2</sup>  
Tensile Strength (Rm) ~750 N/mm<sup>2</sup>  
Elongation (A)(Lo=5do) ~30 %  
Impact energy (Av) ~120 J

**Approvals:**

on demand

**Shielding gas/Polarity:**



**Typical Base Mat.:**

2.4663 – Alloy 617 N06617  
800HT, 803,  
cast alloys HK-40, HK-45

**Packaging:**

MIG: spools D100 / D200 / K200 / K300  
WIG: 10kg-boxes