

DESCRIPTION

Executive 617 is a nickel-chromium-molybdenum alloy designed for welding INCONEL® 617 alloy using TIG and MIG welding processes. This alloy is also used for joining dissimilar high temperature alloys including 800HT, 803 and HK-40. The high alloy content of Executive 617 produces weld material with high temperature strength and oxidation resistance.

Executive 617 filler metal is produced using high quality raw materials and tightly controlled chemistry to provide top quality, exceptionally clean wires that deliver the results fabricators demand.

APPLICATIONS & FEATURES

Executive 617 is used for welding INCONEL® 617 and dissimilar high temperature alloys.

High temperature alloys that can be joined include alloy 800, 803 along with HK-40 and HP materials.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Ti	Cr	Co	Mo
0.088	0.05	0.08	0.004	0.001	0.07	0.03	54.2	1.11	0.34	22.5	11.5	9.10

Tensile Strength: 90,000 PSI Min **Yield Strength:** **Elongation:** 25%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	17-20	70-90	30 to 50 CFH	100% Ar	
	.045"	19-22	75-160		75% Ar / 25% He	
	- Spray	.045"	30-32		190-250	90% He / 7.5% Ar / 2.5% CO ₂
	- Pulse	.045"	18-20		120-150	
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	500-lb Drum
GTAW (TIG)	10-lb plastic tube	40-lb box

CLASSIFICATION

AWS/SFA 5.14, Class **ERNiCrCoMo-1**

