

**MIDALLOY MASTERCOR ENiCrCoMo-1 AP FLUX-CORED WIRE**

**CLASSIFICATION**

- Chemistry conforms to AWS/SFA 5.34. The AWS classification for this flux-cored wire is ENiCrCoMo-1T1-4 for Argon-CO<sub>2</sub> shielding gas and ENiCrCoMo-1T1-1 for 100% CO<sub>2</sub>.

**DESCRIPTION**

- Midalloy Mastercor ENiCrCoMo-1 AP nickel alloy wire for welding in the flat and horizontal positions.
- UNS# W86117
- ISO# TNi6117-xy

**APPLICATIONS**

- Midalloy Mastercor ENiCrCoMo-1 AP is used for welding chromium-cobalt-molybdenum alloys such as UNS number N06617 as well as cast alloys HK-40, HP, and HP modified.
- This wire is used for overlay, cladding where similar alloy is required.
- Weld metal provides optimum strength and oxidation resistance above 1500°F.

**TYPICAL CHEMISTRY**

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Cr	Cb+Ta	Mo	Other
.08	.95	.40	.012	.004	.38	.04	54.3	11.4	22.79	.05	9.25	<.50

**TYPICAL MECHANICAL PROPERTIES**

TENSILE STRENGTH	90,000 PSI
ELONGATION	25%

**WELDING PARAMETERS**

SIZE	VOLTS	AMPS	STICK-OUT	SHIELDING GAS
1/16"	26-28	190-230	1/2"	75Ar/25CO <sub>2</sub>

**STANDARD PACKAGING**

- 33 LB. SPOOL

12-1-08

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