

## MIDALLOY ERNiCrCoMo-1 (FM 617) BARE WIRE

### CLASSIFICATION

- AWS 5.14 Class ERNiCrCoMo-1 / ASME SFA 5.14 Class ERNiCrCoMo-1

### DESCRIPTION

- Midalloy ERNiCrCoMo-1 nickel alloy bare wire is used for MGAW, GTAW, and SAW welding.

### APPLICATIONS

- Midalloy ERNiCrCoMo-1 nickel alloy bare wire is used for welding various nickel-chromium-cobalt-molybdenum alloys to themselves as well as to other dissimilar alloys such as stainless steel, carbon steel, or low alloy steel.
- This alloy is sometimes used for overlay when a similar chemistry is required. The weld metal provides excellent strength and oxidation resistance from 1500° to 2100° F.

### TYPICAL CHEMISTRY

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Cr	Mo	Co
0.06	0.10	0.60	0.005	0.001	0.11	0.01	Bal	1.0	21.5	9.0	12.0

### TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	112,000 PSI
YIELD STRENGTH	88,500 PSI
ELONGATION IN 2"	28%

### RECOMMENDED WELDING PARAMETERS

- See attached

### STANDARD PACKAGING

- Tig 10 lb. tube/60 lb. carton
- Mig 30 lb. spool
- Sub-arc 60 lb. coil

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