

MIDALLOY NI-MAX 117 COATED ELECTRODE

CLASSIFICATION

- AWS/SFA 5.11 Class ENiCrCoMo-1/ASME SFA 5.11 Class ENiCrCoMo-1 ASME SEC IX, F43

DESCRIPTION

- Midalloy NI-MAX117 coated electrode is an all-position, coated electrode used for joining UNS number NO6617 alloys to themselves.
- UNS# W86117
- ISO 14172 comparison classification ENi6117

APPLICATION

- Midalloy NI-MAX 117 is used for joining nickel-chromium, cobalt, molybdenum alloys (UNS NO6617) to themselves
- Midalloy NI-MAX 117 is used for overlay cladding when nickel-chromium, cobalt, molybdenum alloys are required.
- Because weld metal provides optimum strength and oxidation resistance above 1500°F and up to 2100°F, especially on base materials of nickel, iron, chromium alloys, it is often used for these applications.
- NI-MAX 117 can also be used on dissimilar materials for high temperature applications.

TYPICAL CHEMISTRY

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Cr	Mo	Al	Ti
.065	.80	2.0	.012	.005	.30	.05	52.5	11.5	23.5	8.8	.60	.10

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	110,000 PSI
Yield Strength	87,000 PSI
Elongation	26%

RECOMMENDED WELDING PARAMETERS

Diameter	3/32"	1/8"	5/32"	3/16"
Process	SMAW	SMAW	SMAW	SMAW
Voltage	24-28	26-30	28-32	28-32
Amperage Flat	70-85	65-100	110-140	120-160
Amperage Vertical/Overhead	65-75	65-90	100-120	110-130

STANDARD PACKAGING

- 3/32" – 8 lb. Can, 48 lb. Carton
- 1/8", 5/32", 3/16" – 10 lb. Can, 60 lb. Carton

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