

## MIDALLOY ERNiCrCoMo-1 (FM617) 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

10-15-2010

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TYPICAL WELDING PARAMETERS FOR NICKEL ALLOYS

**GMAW (SHORT CIRCUITING MODE)**

WIRE DIA.	AMPERAGE	VOLTAGE	WIRE SPEED, IN./MIN.	JOINT THICKNESS IN.	GAS
.035"	70-90	18-20	150-200	.050-3/16	75Ar/25He
	70-90	17-20	150-200	.050-3/16	90He/7.5Ar/2.5Co2
	70-90	17-20	150-200	.050-3/16	69Ar/30He/1Co2
.045"	75-160	19-22	175-225	1/8-3/4	75Ar/25He
	75-160	19-22	175-225	1/8-3/4	90He/7.5Ar/2.5Co2
	75-160	18-22	175-225	1/8-3/4	69Ar/30He/1Co2

**GMAW (SPRAY TRANSFER MODE)**

.045"	190-250	30-32	300-350	3/8 and UP	100Ar
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**GMAW (PULSED CURRENT MODE)**

.045" peak	120-150 250-300	18-20	175-225	1/8-3/4	75Ar/25He
peak	120-150 250-300	18-20	175-225	1/8-3/4	69Ar/30He/1Co2

**GTAW (TIG)**

JOINT THICKNESS IN.	TUNGSTEN ELECTRODE DIA. IN.	FILLER WIRE DIA. IN.	AMPERAGE	VOLTAGE	GAS
.030 to 1/16	1/16	1/16	35-60	9-12	100Ar
1/16 to 1/8	1/16 to 3/32	1/16 or 3/32	50-95	9-12	100Ar
1/8 to 1/4	3/32 or 1/8	3/32 or 1/8	75-150	10-13	100Ar
1/4 and up	3/32 or 1/8	3/32 or 1/8	95-200	10-13	100Ar

**SAW (SUBMERGED ARC)**

WIRE DIA.	AMPERAGE	VOLTAGE	
3/32"	275-350	28-30	Suitable flux
1/8"	350-450	29-32	Suitable flux

**SMAW (COATED ELECTRODES)**

DIA. & LENGTH	AMPERAGE/FLAT	AMPERAGE/ VERT. & OVERHEAD	VOLTAGE
3/32" x 12"	70-85	65-75	24-28
1/8" x 14"	85-110	80-90	26-30
5/32" x 14"	110-140	100-120	28-32
3/16" x 14"	120-160	110-130	28-32

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