

<b>International standards</b>	Material No.	2.4621
	DIN 1736	EL-NiCr21Co12Mo
	AWS A5.11	E NiCrCoMo-1

**Typical applications and characteristics**

CARBOWELD 117 is a basic coated core wire alloyed nickel base electrode.

Suitable for welding of NiCrCoMo-alloys and for overlay cladding where similar alloy is required.

The deposits provide optimum strength and oxidation resistance above 900°C up to 1250°C, especially when welding on NiFeCr-base alloys.

**Mechanical properties of all-weld metal**

( typical values )

Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Yield strength R <sub>p0,2</sub> N/mm <sup>2</sup>	Elongation A <sub>5</sub> %
760	600	26

**Weld metal analysis (typical, wt. %)**

C	Mn	Si	Cr	Mo	Co	Fe	Al	Ni
0,06	0,45	0,35	21,5	9	12	1,5	0,65	Bal.

**Current**

= +

**Welding positions**

PA, PB, PC, PD, PE, PF

**Rebaking**

1 h, 350 °C + / - 10 °C ( if required )

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 300	65- 75				4,0	16,0
3,2 x 350	90-105				5,0	20,0
4,0 x 350	120-135				5,0	20,0
5,0 x 450	135-155				6,0	24,0

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