

# Wire and Welding products

**HAYNES**  
Wire Company



## HAYNES® 117 Coated Electrodes

### Product Description:

HAYNES® 117 coated electrodes are used for shielded metal arc welding of HAYNES® 617. The weld metal has excellent high temperature strength and resistance to oxidation. The 117 electrodes are also useful for making dissimilar welds between other high temperature materials such as 600, 601 and 800. The electrode coating is designed for great operability, especially out-of-position welding.

### Specifications:

AWS A5.11 ENiCrCoMo-1  
ASME SFA-5.11 ENiCrCoMo-1

ASME IX F-43  
UNS W86117

### Weld Deposit Chemistry:

Ni.....	Balance	Si.....	0.75 max.
Cr.....	21.0 - 26.0	Cu.....	0.5 max.
Co.....	9.0 - 15.0	Other.....	0.5 max.
Mo.....	8.0 - 10.0	C.....	0.05 - 0.15
Fe.....	5.0 max.	P.....	0.03 max.
Mn.....	0.3 - 2.5	S.....	0.015 max.
Nb+Ta.....	1.0 max.		

### Minimum Mechanical Properties:

Tensile (psi)	90,000
Mpa	620
Elongation (%)	30

### Available Product Forms:

<b>Diameter (in)</b>	.093 (3/32)	.125 (1/8)	.156 (5/32)	.187 (3/16)
<b>Length (in)</b>	10	14	14	14
<b>Pkg Wt (lbs)</b>	5	10	10	10
<b>Current (A) DCEP</b>	40-70	70-100	80-140	120-150

Packaged in Hermetically Sealed Containers

HW-7005

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