INCONEL® Filler Metal 601

INCONEL Filler Metal 601 is used for gas-tungsten-arc welding of INCONEL alloy 601. It is the preferred welding product for all gas-tungsten-arc welding of INCONEL alloy 601. The GTAW process with INCONEL Filler Metal 601 is the only recommended joining method for applications involving temperatures over 2100°F (1150°C) or for applications at lower temperatures involving exposure to hydrogen sulfide or sulfur dioxide. The weld metal is comparable to the base metal in resistance to corrosion and oxidation.

Specifications

AWS A5.14 ERNiCrFe-11 (UNS N06601)
ASME II, Part C, SFA-5.14, ERNiCrFe-11 (UNS N06601)
ASME IX, F-No.43
*BS2901 NA 49
*DIN 1736 SG-NiCr23Al (2.4626)
*(EN) ISO 18274 – SNi6601 (NiCr23Fe15Al)
*Supply to these specifications available upon request
For manufacture to ASME III (NCA3800, NB2400), AMS and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition

Ni+Co	58.0-63.0	Mn	1.0 max.
Cr	21.0-25.0	S	0.015 max.
Fe	Remainder	Si	0.50 max.
Al	1.0-1.7	Cu	1.0 max.
C	0.10 max.	Others	0.50 max.
P	0.03 max.		

Typical Mechanical Properties

Tensile Strength, psi	94,000
MPa	648
Elongation, (4d) %	42

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)

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