



## INCONEL® Filler Metal 601

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

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