

## 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

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

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

