

NiCro 601

CATEGORY GMAW-GTAW Solid wires

TYPE Nickel-Chromium-Aluminum alloy for Mig/Tig welding alloy 601.

APPLICATIONS Filler metal 601 is used for severe applications where the exposure temperature can exceed 2100°F [1150°C].

PROPERTIES Excellent resistance against corrosion and oxidation and suitable for applications when exposed to hydrogen sulfide or sulfur dioxide.

CLASSIFICATION

AWS	5.14: ER NiCrFe-11
	UNS: N06601
EN ISO	ISO 18274: SNi6601

SUITABLE FOR The nominal composition (wt.-%) of filler metal of this classification is 61 Ni, 23 Cr, 14 Fe, and 1.4 Al. Filler metal of this classification is used for welding nickel-chromium-iron-aluminum alloy (ASTM B 166, B 167, and B 168 having UNS number N06601) to itself and to other high-temperature compositions.

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Si	Mn	P	S	Al	Ni	Cr	Cu	Fe
<0.10	0.27	<1.0	<0.03	<0.015	1.0-1.7	58-63	21-25	0.10	rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
as welded		648	42				

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2	28-30	200	D-300 / K-300	13.6	979.2

REDRYING TEMPERATURE not required

TIG WELDING Straight lengths are available in 1,6 - 2,4 and 3,2 mm in 4.54 kg tubes.