



## Nickel 601 (ERNiCrFe-11)

**CLASSIFICATIONS:** AWS A5.14/ASME SFA 5.14 Class ERNiCrFE-11 UNS N06601

**DESCRIPTION:** Nickel 601 is used for GTAW welding of Inconel® 601. It is recommended in applications over 2100°F or 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.

*Inconel® is a registered trademark of Special Metals group of companies*

**TYPICAL CHEMISTRY:**

C	Cr	Ni	Mo	Mn	Si	P	S	Fe	Cu	Al	Others
.10 max	21.0- 25.0	58.0- 63.0		1.0 max	.50 max	.03 max	.015 max	Bal.	1.0 max	1.0- 1.7	.50 max

**TYPICAL MECHANICAL PROPERTIES:**

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

**TYPICAL WELDING PARAMETERS:**

	Diameter	Voltage	Amperage	Shielding Gas
<b>TIG</b>	.035" (.9mm)	12-15	60-90	100% Ar
	.045" (1.14mm)	13-16	80-110	
	1/16" (1.6mm)	14-18	90-130	
	3/32" (2.4mm)	15-20	120-175	
	1/8" (3.2mm)	15-20	150-220	

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

**Edmonton, AB Office**  
8804 51 Ave  
Edmonton, AB T6E 5E8  
Phone: 780-468-1777  
Fax 780-468-1758

**Chilliwack, BC Corporate**  
Unit A, 44636 Yale Rd West  
Chilliwack, BC V2R 0G5  
Phone: 604-701-6533  
Fax 604-701-6559

**Surrey, BC Office**  
Unit 11, 13085 115 Ave  
Surrey, BC V3R 4S7  
Phone: 1-877-233-1378  
Fax: 604-701-6559

**Saskatoon, SK Office**  
Unit#8, 401 Pakwa Place  
Saskatoon, SK S7L 5Z9  
Phone: 306-974-9750  
Fax 306-974-9752

**Prince George**  
1557 South Lyon St  
Prince George, BC V2M 1T3  
Phone: 250-562-8922  
Fax: 250-562-8927