



## MIG NI601

### Classification

AWS A5.14 : ERNiCrFe-11

ISO 18274 : S Ni 6601 (NiCr23Fe15Al)

### Description & Applications

Solid wire for GMAW of similar Nickel-Chrom-Iron-Aluminum alloys like alloy 601. Used in the construction of equipments submitted to high temperature up to 1150°C.

**Main applications:** Furnaces, heat treatment equipments.

**Base materials :**

UNS	Alloy	DIN	Material N°
N06600	600	NiCr15Fe	2.4816
N06601	601	NiCr23Fe	2.4851

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Cu	P	S	Fe	Al	Ni	O/T
Min				21.0					1.0	58.0	
Max	0.10	0.50	1.0	25.0	1.0	0.03	0.015	20.0	1.7	63.0	0.50
Type	0.05	0.20	0.50	23.0	0.10	0.01	0.005	14.0	0.04	60.0	<0.50

### All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	-	-	-	-
Max	-	-	-	-
Type	-	-	-	-

### Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current ( A )	Voltage ( V )	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: I1 (100% Ar) I3 (Ar+10-30%He) Z (Ar+He+H+CO <sub>2</sub> ) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	
	1.6	220 - 380	24 - 34	

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