

DESCRIPTION

Executive 601 is a nickel-chromium-iron alloy designed for welding alloy 601 using TIG and MIG welding processes. The high alloy content of Executive 601 produces high strength weld material with corrosion and oxidation resistance similar to Inconel®601 base material.

Executive 601 filler metal is produced using high quality raw materials and tightly controlled chemistry to provide top quality, exceptionally clean wires that deliver the results fabricators demand.

APPLICATIONS & FEATURES

Used for GTAW welding of Inconel®601. It is recommended in applications over 2100°F (1150°C) or at lower temperatures involving exposure to hydrogen sulfide or sulfur dioxide.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Mo	Cr	Nb+Ta
0.10	1.00	Bal	0.03	0.015	0.05	1.00	58.0	1.0	0.5	23	0.5

Tensile Strength: 94,000 PSI Min

Elongation: 42%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short	.035"	17-20	70-90	30 to 50 CFH	100% Ar
	.045"	19-22	75-160		75% Ar / 25% He
	- Spray	.045"	30-32		190-250
- Pulse	.045"	18-20	120-150		
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	500-lb Drum
GTAW (TIG)	10-lb plastic tube	40-lb box

CLASSIFICATION

AWS/SFA 5.14, Class **ERNiCrFe-11**

