



Unibraze 601

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

DESCRIPTION: Unibraze 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.

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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
TIG	.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.