

**AFROX TIG ER60I**

Afrox TIG ER60I is a solid TIG wires for welding matching Ni-23% Cr-15% Fe-1.5% Al Alloys. The 60I alloys have exceptional oxidation resistance. They also have very good high temperature corrosion resistance in hydrogen sulphide/sulphur dioxide environments.

**APPLICATIONS**

The alloy finds applications up to 1200°C in **thermal processing, heat treatment, petrochemical processing and gas turbine equipment.**

**MATERIALS TO BE WELDED**

<b>ASTM/UNS</b>	N06601
<b>DIN</b>	2.4851 (NiCr23Fe)
<b>Proprietary</b>	Inconel 601 (Special Metals) Nicrofer 6023 (Krupp VDM) RA601 (Rolled Alloys)

**CLASSIFICATIONS**

AWS	A5.14	ERNiCrFe-11
BS	EN (proposed)	W Ni 6601
DIN	1736	SG-NiCr23Al
BS2901	PT5	NA49

**CHEMICAL ANALYSIS  
(WIRE ANALYSIS)**

<b>% Carbon</b>	0.1 max	<b>% Nickel</b>	58.0-63.0
<b>% Manganese</b>	1.0 max	<b>% Chrome</b>	21.0-25.0
<b>% Silicon</b>	0.5 max	<b>% Copper</b>	0.5 max
<b>% Sulphur</b>	0.015 max	<b>% Iron</b>	18.0 max
<b>% Phosphorus</b>	0.03 max	<b>% Aluminium</b>	1.0-1.7

**TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL IN THE AS WELDED CONDITION)**

<b>0,2% Proof Stress</b>	365 MPa
<b>Tensile Strength</b>	585 MPa
<b>% Elongation on 4d</b>	40
<b>% Elongation on 5d</b>	40
<b>Hardness cap/mid</b>	180/195HV

**PACKING DATA**

Diameter mm	Item Number	Consumable Length mm	Pack Mass Kg
2,4	077/634	1000	2,5 Tube

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