

TECHALLOY® 606

Nickel ■ AWS ERNiCr-3

KEY FEATURES

- Used for TIG, MIG and SAW welding of base materials such as ASTM B163, B166, B167 and B168 alloys which have UNS Number N06600
- Suitable for applications ranging from cryogenic to high temperatures making this alloy one of the most used in the nickel family
- Q2 Lot® - Certificate showing actual deposit composition available online

WELDING POSITIONS

All

DIAMETERS / PACKAGING

Diameter in (mm)	MIG 33 lb (15 kg) Steel Spool	TIG 10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton	SAW 55 lb (25 kg) Coil
0.035 (0.9)	MG606035667		
0.045 (1.1)	MG606045667		
1/16 (1.6)	MG606062667		
5/64 (2.0)		TG606062638	
3/32 (2.4)		TG606078638	
1/8 (3.2)		TG606093638	SA606093726
5/32 (4.0)		TG606125638	SA606125726
		TG606156638	

WIRE COMPOSITION⁽¹⁾ - As Required per AWS A5.14M: 2011

	%C	%Mn	%Fe	%P	%S	%Si
Requirements AWS ERNiCr-3	0.10 max	2.5 - 3.5	3.0 max	0.03 max	0.015	0.50 max
Typical Performance⁽²⁾ Techalloy® 606	0.04	2.8	1.5	0.003	0.002	0.09
	%Cu	%Ni	%Ti	%Cr	%Nb + Ta	%Others
Requirements AWS ERNiCr-3	0.50 max	67.0 min	0.75 max	18.0 - 22.0	2.0 - 3.0	0.50 max
Typical Performance⁽²⁾ Techalloy® 606	0.03	73.0	0.40	20.0	2.4	<0.50

TYPICAL OPERATING PROCEDURES

Process	Diameter in (mm)	Voltage (volts)	Amperage	Gas
MIG	0.035 (0.9) 0.045 (1.1) 1/16 (1.6)	26-29 28-32 29-33	150-190 180-220 200-250	75% Argon / 25% Helium
SAW	3/32 (2.4) 1/8 (3.2)	28-30 29-32	275-350 350-450	Lincolnweld® P2000

⁽¹⁾Typical all weld metal. ⁽²⁾See test results disclaimer on pg. 13.
Safety Data Sheets (SDS) are available on our website at www.lincolnelectric.com