



Consumable (Spec. No.):	ERNiMo-2
AWS:	5.14 (Nickel and nickel-alloy bare welding electrodes and rods)
Description:	The nominal composition (wt %) of filler metal of this classification is 71 Ni, 16 Mo, 7 Cr, and 3 Fe. Filler metal of this classification is used for welding nickel-molybdenum alloy (ASTM B 366, B 434, and B 573 having UNS number N10003) to itself, to steel, to other nickel-base alloys, and for cladding steel with nickel-molybdenum weld metal using the GTAW and GMAW processes.

F. Number:	44
A. Number:	NA
Welding position:	-
Polarity:	-
Amperage:	

Chemical Composition:

Carbon (C)	0.04 to 0.08
Manganese (Mn)	1
Silicon (Si)	1
Phosphorus (P)	0.015
Sulfur (S)	0.02
Nickel (Ni)	Rem
Chromium (Cr)	6.0 to 8.0
Molybdenum (Mo)	15.0 to 18.0
Copper (Cu)	0.5
Vanadium (V)	0.5
Iron (Fe)	5
Cobalt (Co)	0.2
Tungsten (W)	0.5
Others	0.5