



GB/T 13814 —

AWS A5.11 ENiCrMo-13

EN ISO 14172 —

# AK ENiCrMo-13

**Description:** ENiCrMo-13 is a nickel-chromium-molybdenum covered electrode with very low carbon and silicon, developed for welding low-carbon Ni-Cr-Mo alloys and related nickel-base materials. It offers excellent corrosion resistance, high mechanical strength, and strong resistance to chloride attack in low-pH service environments.

**Application:** ENiCrMo-13 is suitable for welding the clad side of steel clad with low-carbon Ni-Cr-Mo alloys, joining similar or dissimilar nickel alloys, and fabricating equipment for harsh chemical processing service. It is commonly used for reactors, piping, pressure vessels, and repair work exposed to acidic, chloride-bearing media.

## Typical Chemical Composition(%):

	C	Mn	Fe	P	S	Si	Cu	Ni	Co
Requirement	0.020	1.0	1.50	0.015	0.010	0.20	0.50	Rem.	---
Actual Result	0.010	0.50	1.25	0.010	0.005	0.10	0.20	Rem.	---
	Al	Ti	Cr	Nb+Ta	Mo	V	W	La	B
Requirement	---	---	22.0-24.0	---	15.0-16.5	---	---	---	---
Actual Result	---	---	22.95	---	15.58	---	---	---	---

## Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥690		25	
Actual Result	755		29	