



GB/T 13814 —

AWS A5.11 ENiMo-1

EN ISO 14172 —

AK ENiMo-1

Description: ENiMo-1 is a nickel-molybdenum covered electrode for SMAW, with nominal weld metal around 67Ni-28Mo-5Fe. It is intended for nickel-molybdenum alloy welding and produces a composition suited to matching Ni-Mo base materials or clad surfaces while supporting sound weld quality.

Application: It is used for welding nickel-molybdenum alloys, the clad side of steel clad with nickel-molybdenum alloy, and Ni-Mo alloys to steel or other nickel-base alloys. It is especially suitable for fabrication and repair work where clad-side compatibility and flat-position welding are important.

Typical Chemical Composition(%):

	C	Mn	Fe	P	S	Si	Cu	Ni	Co
Requirement	0.07	1.0	4.0-7.0	0.040	0.030	1.0	0.50	Rem.	2.50
Actual Result	0.04	0.82	5.60	0.015	0.010	0.60	0.10	Rem.	1.68
	Al	Ti	Cr	Nb+Ta	Mo	V	W	La	B
Requirement	—	—	1.0	—	26.0-30.0	0.60	1.0	—	—
Actual Result	—	—	0.30	—	27.45	0.10	0.20	—	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥690		25	
Actual Result	734		28	