GB/T 13814 ——

AWS A5.11 ENiMo-7

EN ISO 14172——

# AK ENiMo-7

**Description:** ENiMo-7 is a low-carbon, low-iron, low-cobalt nickel-molybdenum SMAW electrode with nominal weld metal near 69Ni-28Mo-1.5Fe-1.5Mn. It is designed for Ni-Mo alloy welding and provides a controlled weld deposit for clad -side work and corrosion-resistant nickel-molybdenum joints.

**Application:** It is used for welding nickel-molybdenum alloys, the clad side of nickel-moly alloy clad steel, and Ni-Mo alloys to steel or other nickel-base alloys. It suits fabrication and maintenance jobs where chemical consistency, corrosion resistance, and dependable flat-position welding are required.

**Typical Chemical Compostion(%):**

| | C | Mn | Fe | P | S | Si | Cu | Ni | Co |
|---|---|---|---|---|---|---|---|---|---|
| **Requirement** | 0.02 | 1.75 | 2.25 | 0.040 | 0.030 | 0.20 | 0.50 | Rem. | 1.0 |
| **Actual Result** | 0.01 | 0.95 | 1.85 | 0.015 | 0.020 | 0.10 | 0.20 | Rem. | 0.50 |
| | **Al** | **Ti** | **Cr** | **Nb+Ta** | **Mo** | **V** | **W** | **La** | **B** |
| **Requirement** | —— | —— | 1.0 | —— | 26.0-30.0 | —— | 1.0 | —— | —— |
| **Actual Result** | —— | —— | 0.52 | —— | 27.45 | —— | 0.30 | —— | —— |

**Typical Mechanical Properties:**

| | Tensile Strength (MPa) | Yield Stress ( MPa) | Elongation (%) | Impact Values ( J) |
|---|---|---|---|---|
| **Requirement** | ≥690 | | 25 | |
| **Actual Result** | 720 | | 28 | |