ERNiCrMo-3

AWS 5.14 ERNiCrMo-3 refers to Inconel 625. It maintains stable mechanical property from crystallization to high temperature-980℃ （1796℉）. The most valuable property of Inconel 625|ERNiCrMo-3 is its strong resistance to pitting, crevice corrosion and stress corrosion generated by oxidation and reducing acid.

AWS 5.14 ERNiCrMo-3 Chemical Composition

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Al	Ti	Cr	Nb+Ta	Mo	V	W	Others
0.1	0.5	5	0.02	0.015	0.50	0.5	⩾58.0	/	0.4	0.4	20.0-23.0	3.15-4.15	8.0-10.0	/	/	0.50

ERNiCrMo-3 Mechanical Properties

Grade	Density	Melting Point	Tensile Strength	Yield Strength	Elongation
AWS A 5.14 ASME SFA A5.14	8.4	1287-1348°C 2349-2458°F	760Mpa 110Ksi	420Mpa 60Ksi	27%

AWS 5.14 ERNiCrMo-3 Welding wire| Welding Rod Cover Gas

Process	Diameter	Voltage	Amperage	Gas
TIG	0.035’’(0.9mm)	12.15	60-90	100% Argon
	0.045’’(1.2mm)	13.16	80-110	100% Argon

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	1/16''(1.6mm)	14.118	90-130	100% Argon
	3/32''(2.4mm)	15.20	120-175	100% Argon
	1/8''(3.2mm)	15.20	150-220	100% Argon
	0.035''(0.9mm)	26-29	150-190	75% Argon+25% Helium
	0.045''(1.2mm)	28-32	180-220	75% Argon+25% Helium
MIG	1/16''(1.6mm)	29-33	200-250	75% Argon+25% Helium
	0.035''(0.9mm)	28-30	275-350	Suitable Flux may be used
	0.045''(1.2mm)	29-32	350-450	Suitable Flux may be used
SAW	5/32''(4.0mm)	30-33	400-550	Suitable Flux may be used

What is AWS 5.14 ERNiCrMo-3 used for?

ERNiCrMo-3 welding wires and rods are used for joining base materials such as UNS N06625, UNS N08825, and other common steel.
Valve surface weld overlay
Pipeline weld overlay
Waste Incineration Furnace

Instructions for AWS 5.14 ERNiCrMo-3 use:

Generally, it is necessary to use a small welding current to keep the arc stable combustion, and the quality of arc initiation and arc recovery is higher.

Attention should be paid to the quality of the joint, and the preheating and heat treatment temperature similar to that of the base material should be used.

Inconel is a trademark of high-performance nickel-based alloys developed by Special Metals Corporation.
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