



# NICALLOY Mo-14

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 ENiCrMo-14

### CLASSIFICATION:

ISO 14172

E Ni 6686 (NiCr21Mo16W4)

### KEY FEATURES:

- Basic coated non synthetic electrode
- Weld metal is of C-276 type
- Excellent corrosion resistance in reducing, oxidizing, crevice and pitting conditions
- Electrode gives smooth arc, medium penetration, uniform bead and easy slag removal
- All position welding capability

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of Nickel alloys like N06686, N06625, N10276, and N06022
- Used to join duplex, super-duplex and superaustenitic stainless steels, as well as nickel alloys
- Welding operations in chemical and petrochemical process, oil and gas, marine industries
- Used for overlay cladding of iron-base metals under corrosive environments


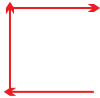
### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Cr	Mo	W
0.015	0.6	0.21	3.1	59	21	16	3.7

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	690 min	30 min

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-70	 <b>DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down  
3.15 x 350	70-95		
4.0 x 350	90-120		

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.