PRODUCT DATA SHEET

Nickel Alloy Wire

Weld Process: GMAW & GTAW

Alloy: ERNiMo-3 (Hastelloy W) Class: ERNiMo-3
Conforms to Certification: AWS A5.14 / ASME SFA 5.14

Alloy: DMHASW

AWS Chemical Composition Requirements

C = 0.12 max	Cu = 0.50 max
Mn = 1.0 max	Ni = Remainder
Fe = 4.0 – 7.0	Co = 2.5 max
P = 0.04 max	Cr = 4.0 – 6.0
S = 0.03 max	Mo = 23.0 – 26.0
Si = 1.0 max	V = 0.60 max
W = 1.0 max	Other = 0.50 max

Deposited Chemical Composition % (Typical)

C = 0.05	Cr = 5.0	Ni = 62.5
Mo = 24.0	Fe = 6.0	

Deposited All Weld Metal Properties % (AW)

Tensile Strength	109,500psi
Elongation	42%

Deposited Charpy-V-Notch Impact Properties %

Not applicable

Application

ERNiMo-3 is a 62.5 Ni, 24 Mo, 6 Fe, 5 Cr alloy that is excellent for welding dissimilar high temperature alloys. Major use is in aircraft engine repair and maintenance.

Recommended Welding Parameters for TIG and MIG Welding of Nickel Alloys

Process	Diameter of Wire	Voltage (V)	Amperage (A)	Gas
Tig	.035 inches x 36	12 -15	60 -90	100% Argon
	.045 inches x 36	13 -16	80 - 110	100% Argon
	1/16 inches x 36	14 - 18	90 - 130	100% Argon
	3/32 inches x 36	15 – 20	120 -175	100% Argon
	1/8 inches x 36	15 – 20	150 - 220	100% Argon
MIG	.035 inches	26 – 29	150 – 190	75% Argon + 25% Helium
	.045 inches	28 – 32	180 – 220	75% Argon + 25% Helium

If additional information is needed Contact Weldwire Company, Inc. 800-523-1266

1/16 inches	29 – 33	200 - 250	75% Argon + 25% Helium

Note: Other shielding Gases may be used for Mig and Tig welding. Shielding gases are chosen taking Quality, cost, and Operability into consideration.