ERNiCrMo-15 Filler Metal

For Welding Age-Hardenable Nickel-Chromium-Molybdenum Alloys

ERNiCrMo-15 filler metal is an age-hardenable nickel-chromium-molybdenum alloy designed for gas-tungsten-arc (GTAW) and gas-metal-arc (GMAW) welding. After post-weld heat treatment, it combines excellent corrosion resistance with enhanced strength and hardness.

This filler metal is particularly suitable for applications requiring post-weld heat treatment, such as oil and gas components made from low-alloy steels (e.g., 4130), where stress-relief and aging temperature ranges are compatible. Additional strength and hardness can be achieved through post-weld heat treatment.

Specification

AWS A5.14 ERNiCrMo-15 (UNS N07725)

ASME II, Part C, SFA-5.14, ERNiCrMo-15 (UNS N07725)

*(EN) ISO 18274 – SNi7725 (NiCr21Mo8Nb3Ti)

Custom specifications available upon request.

For information regarding certifications and industry approvals, please contact our Technical Department.

Limiting Chemical Composition

Element	Ni+Co	C	Mn	Fe	S	Si	Al
Content(%)	55.0 to 59.0	0.03 max	0.35 max	Remainder	0.01 max	0.20 max	0.35 max
Element	Ti	Cr	Nb+Ta	Mo	P	Others	
Content(%)	1.0 to 1.7	19.0 to 22.5	2.75 to 4.00	7.0 to 9.5	0.015 max	0.50 max	

Typical Mechanical Properties

Property	Value
Tensile Strength, psi	174,000
MPa	1200

(Age hardened condition: 1900°F (1038°C) /1 hour plus 1350°F (732°C) /8 hours,Furnace Cool to 1150°F (621°C) /8 hours, Air Cool)

Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)