

AK 506NiCrCu

Description: AK506NiCrCu is an alkaline low-alloy high-strength steel electrode, which can be welded in all positions and adopts DC reverse connection.

Application: For bridge corrosion resistant steel Q345-NH and other weathering steel.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.1	0.6	1.25	0.02	0.035	0.20-0.5	0.30-0.8	0.30	0.08
Actual Result	0.05	0.34	1.09	0.01	0.016	0.36	0.44	0.44	0.011

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥490	≥ 390	≥ 22	≥ 47J (- 40 °C)
Actual Result	537	437	28	170

Recommended welding parameters:

Diameter/ mm		0.8	1.0	1.2
Welding current (A)	F/H	70-110	100-140	140-180
	V/OH	50-80	80-110	130-170