

AK 50QNH

Description: AK50QNH is a low-alloy steel gas shielded solid welding wire. The weld has excellent atmospheric corrosion resistance, and its service life meets the needs of various specific climatic conditions. The weld metal has excellent mechanical properties and good crack resistance.

Application: Used for welding of important bridge corrosion-resistant steel such as Q355NH, etc..

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Cu	—
Actual Result	0.10	0.60	0.6-1.2	0.020	0.025	0.20-0.6	0.30-0.9	0.20-0.50	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥ 500	≥400	≥ 22	≥47J(-40℃)
Actual Result	565	475	26	115

Recommended welding parameters:

Diameter/ mm		0.8	1.0	1.2
Welding current(A)	F/H	50-180	80-250	100-360
	V/OH	50-100	70-160	80-220