

AK 556NiCrCu

Description: AK556NiCrCu is an ultra-low hydrogen and high toughness electrode with low hydrogen sodium type coating. It can be welded in all positions. It adopts DC reverse connection and has good operation technology. The weld metal has good plasticity and toughness.

Application: For welding of important bridge corrosion-resistant steel Q420-NH.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Cu	Mo
Requirement	0.10	0.6	1.60	0.02	0.025	0.20-0.6	0.30-0.9	0.20-0.40	—
Actual Result	0.08	0.42	1.53	0.007	0.008	0.41	0.62	0.31	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 540	≥440	≥ 22	≥47J(-40℃)
Actual Result	620	510	26	130

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