

AK 55QNH

Description: AK55QNH 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 Q420NH, 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	≥ 550	≥450	≥ 22	≥47J(-40℃)
Actual Result	608	510	26	88

Recommended welding parameters:

Diameter/ mm		0.8	1.0	1.2	1.6
Welding current(A)	F/H	50-180	80-250	100-360	250-500
	V/OH	50-100	70-160	80-220	