

AK 606NiCrCu

Description: AK606NiCrCu 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 Q500-NH.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Cu	Mo
Requirement	0.1	0.6	2.00	0.02	0.025	0.20-0.9	0.30-0.9	0.20-0.40	—
Actual Result	0.07	0.31	1.76	0.007	0.007	0.63	0.57	0.31	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 590	≥490	≥ 20	≥47J(-40℃)
Actual Result	680	550	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