



GB/T 5117 E5015-N5
AWS A5.5 E7015-C1
EN ISO 2560 - B:E 7015-C1

AK W607DR

Description: AK-W607DR is a low-temperature steel electrode with low-hydrogen sodium coating containing Ni, DC reverse connection, and can be welded in all positions. The deposited metal still has good impact toughness at -60°C .

Application: Welding -60°C low temperature steel structure, such as 09MnDR etc..

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	—	—	—
Requirement	0.07	0.6	1.0-1.6	0.009	0.015	0.6-1.0	—	—	—
Actual Result	0.058	0.38	1.25	0.007	0.010	0.85	—	—	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥490	≥ 390	≥ 22	54J(-60°C)
Actual Result	570	480	28	120

Recommended welding parameters: DC+

Diameter/ mm	2.5	3.2	4.0	5.0
Electrode Length (mm)	300	350	400	400
Welding current / A	60-100	80-130	140-200	180-240

1. The electrode must be baked at about 350C for 1 hour before welding, and it can be used as it is baked.
2. Before welding, the rust, oil, moisture and other impurities in the weldment must be removed.