

AK 607GX

Description: AK-607GX is a low-alloy high-strength steel electrode with low hydrogen sodium typecoating for pipelines. It adopts DC reverse connection and can perform all-position welding.

Application: It is used for welding of X70 pipeline steel and low alloy steel structures with low S and P requirements of equivalent strength grades.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ti	Nb	Mo	V
Requirement	0.09	0.40	1.65	0.006	0.020	0.025	0.08	0.40	0.06
Actual Result	0.04	0.28	1.35	0.0025	0.012	0.01	0.024	0.32	0.003

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation(%)	Impact Values (J)
Requirement	≥620	≥ 530	≥ 17	≥ 110 J / - 20 °C
Actual Result	650	565	25	150

Recommended welding parameters:

Diameter/ mm		2.5	3.2	4.0
Welding current (A)	F/H	70-110	100-140	140-180
	V/OH	50-80	80-110	130-170