

AK 657GX

Description: AK-657GX is a low-alloy high-strength steel electrode with low-hydrogen sodium type coating for X80 pipeline. It adopts DC reverse connection and can perform all-position welding.

Application: It is used for welding of X80 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	Cu	Cr	Mo	Ni
Requirement	0.12	0.4	1.0-2.0	0.006	0.020	0.03	0.25	0.4	0.30
Actual Result	0.053	0.35	1.62	0.002	0.012	0.12	0.23	0.32	0.21

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 590	≥490	≥ 15	≥60J(-20℃)
Actual Result	630	530	26	130

Recommended welding parameters:

Diameter/ mm		2.5	3.2	4.0
Welding current(A)	F/H	70-110	90-130	140-180
	V/OH	50-80	80-110	130-170