

AK 707Q

Description: AK707Q is an ultra-low hydrogen and high toughness electrode with low hydrogen sodium type coating, which adopts DC reverse connection. All-position welding is possible, with good overall performance.

Application: For important low alloy steel bridge welded structures.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cu	Cr
Requirement	0.10	0.6	1.0-2.0	0.015	0.020	0.8-1.7	0.10-0.40	---	---
Actual Result	0.072	0.3	1.62	0.007	0.008	1.54	0.28	---	---

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥690	≥ 590	≥ 15	≥47J/-40℃
Actual Result	770	630	25	115

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