



GB/T 5118-1995 E7515-G
AWS A5.5 E10018M
EN ISO 18275 A E 695 Z1.5Mn2NiMoB3 2

AK 757Q

Description: AK757Q 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	0.12	0.6	1.0-2.0	0.025	0.025	0.6-2.5	0.8	0.6	—
Actual Result	0.07	0.34	1.882	0.007	0.008	2.11	0.56	0.42	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥740	≥ 640	≥ 13	≥47J/-40℃
Actual Result	820	710	25	105

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