

AK A506NiCu

Description: AK-A506NiCu is a low hydrogen potassium type alkaline low alloy refractory weathering steel electrode. AC and DC dualuse, can perform all-position welding. The welding process performance is good, and the weld metal has good atmospheric corrosion resistance, crack resistance and good plasticity and toughness.

Application: It is suitable for welding of 50kg weathering steel, such as welding of vehicles, offshore engineering structures and bridges.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cu	Cr	Mo
Requirement	0.12	0.7	0.30-0.9	0.03	0.035	0.20-0.5	0.20-0.5	— —	— —
Actual Result	0.08	0.30	0.8	0.010	0.015	0.40	0.35	— —	— —

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥490	≥400	≥ 22	≥27J(-40℃)
Actual Result	560	470	25	100

Recommended welding parameters:

Diameter/ mm	2.5	3.2	4.0	5.0
Welding current(A)	60-90	80-120	150-190	180-220