

AK-50M

Description: AK-50M is a seamless rutile flux cored wire for welding with Argon/CO2 mixed shielding gas; The diffusible hydrogen content of deposited metal is low; It has a stable welding arc with less spatter and perfect bead surface, it also has excellent weldability in all positions; The flux cored wire has excellent impact properties at low temperature.

Application: Welding for ships, bridges, steel structures, offshore platforms, pipes, pressure vessels, etc.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	
Requirement	0.12	0.90	1.60	0.03	0.04	0.50	0.20	0.30	—
Actual Result	0.05	0.43	1.25	0.007	0.01	0.01	0.02	0.01	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)		
Requirement	490-620	≥400	≥22	≥27(-30℃)	-40℃	-60℃
Actual Result	570	510	26	101	100	85

Recommended welding parameters:

Diameter/ mm	1.2	1.6		
Welding voltage/V	20-30	20-30	—	—
Welding current/A	140-250	160-260	—	—