

AK-62M

Description: It is a seamless rutile flux cored wire which contains 1.5% Ni, and the diffusible hydrogen content of deposited metal is low (<3ml/100g); It has a stable welding arc with less spatter and perfect bead surface, it also has excellent weldability; The flux cored wire has excellent impact properties at low temperature.

Application: Welding for the same strength grade of bridge, port machinery, ship-building and other welding.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	
Requirement	0.15	0.80	0.5-1.75	0.03	0.03	1.00-2.00	0.15	0.35	—
Actual Result	0.04	0.25	1.00	0.003	0.008	1.80	0.02	0.01	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)		
Requirement	620-760	≥ 540	≥ 17	≥27(-20℃)	-40℃	-60℃
Actual Result	630	580	24	150	135	90

Recommended welding parameters:

Diameter/ mm	1.2	1.6		
Welding voltage/V	20-32	25-35	—	—
Welding current/A	180-300	250-350	—	—