AK-76M

GB/T 17493 E761T1-K3M

AWS A5.29 E111T1-K3M

EN ISO 18276-A:T 69 4 Mn2NiMo P M21 1

Description: It is a seamless rutile flux cored wire which contains 2%Ni; Due to the seamless design ,the wire has an extremely low hydrogen content which is very important when welding extra high tensile steels; It has a stable welding arc with less spatter and perfect bead surface,it also has excellent weldability;.

Application: Welding for the same strength leave structures of bridge, port machinery,suchas:HY-100,A514,Q690.

Typical Chemical Compostion(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	
Requirement	0.15	0.80	0.75-2.25	0.03	0.03	1.25-2.60	0.15	0.25-0.65	——
Actual Result	0.054	0.45	1.79	0.005	0.010	2.26	0.02	0.39	——

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)		
Requirement	760-900	≥680	≥ 15	≥27(-20℃)	-40℃	-60℃
Actual Result	820	760	19	133	115	73

Recommended welding parameters:

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