GB/T 17493 E120C-K4

AWS A5.28 E120C-K4

EN ISO 18276-A:T894 Mn2NiMo M M21 1

AKM-100

Description: The deposited metal has an ultra-low and seamless structure make the diffusible hydrogen content as low as 3ml/100g; the arc is soft and stable, with less spatter, beautiful shape, almost no slag, the least smoke and dust, and high deposition efficiency; Excellent low temperature impact performance.

Application: Suitable for welding of ultra-high strength stee.

Typical Chemical Compostion(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	
Requirement	0.15	0.80	0.75-2.25	0.025	0.025	0.5-2.50	0.15-0.65	0.15-0.65	——
Actual Result	0.10	0.77	1.78	0.009	0.015	2.26	0.25	0.35	——

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)		
Requirement	≥ 1000	≥890	≥ 15	≥27(-20℃)	-40℃	-50℃
Actual Result	1100	950	15	115	78	62

Recommended welding parameters:

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