



AKM-50

GB/T 8110 ER50-6

AWS A5.18 E70C-6M H4

EN ISO 17632-A:T46 4 M21 1 H5

Description: AKM-50 is a seamless metal cored wire for low carbon steels with mixed gas shielded the deposited metal has ultra-low diffusible hydrogen content (3ml/100g); It consists mainly of metal flux which ensures high productivity. Compared with the solid welding wire, the deposition rate is increased by 20%~40%; It is especially used for automatic welding of robots.

Application: Mainly used in mechanical and automotive manufacturing industry, especially for robot high-speed pipeline welding.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	
Requirement	0.12	0.9	1.75	0.030	0.030	0.5	0.2	0.30	—
Actual Result	0.052	0.53	1.35	0.012	0.011	0.023	0.064	0.001	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)		
Requirement	≥480	≥400	≥22	≥27(-20℃)	-40℃	-50℃
Actual Result	565	465	27.5	133	95	73

Recommended welding parameters:

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