



GB/T8110 E100T15-M21 K3 H4
AWS A5.18 E100T15-M21 K3
EN ISO 18276-A:T62 5Z M M21 1 H5

AKM-69

Description: AKM-69 is a metal powder type seamless flux-cored welding wire, containing 2%Ni-0.3%Mo, based on seamless design, with ultra-low diffusible hydrogen content ($\leq 3\text{ml}/100\text{g}$); soft and stable arc, less spatter, forming Beautiful appearance, almost no slag, least smoke and dust, high deposition efficiency; excellent low temperature impact performance.

Application: Suitable for high-strength steel welding and welding of A514 materials such as port machinery bridges.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	
Requirement	0.15	0.8	0.75-2.25	0.025	0.025	0.5-2.5	0.15	0.25-0.65	—
Actual Result	0.055	0.45	1.35	0.005	0.010	1.87	0.02	0.30	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)		
Requirement	690-830	≥ 610	≥ 16	$\geq 27(-20^{\circ}\text{C})$	-40°C	-50°C
Actual Result	750	680	20	135	97	78

Recommended welding parameters:

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