



GB/T 8110 E110C-M21 H4

AWSA5.18 E110C- K4

EN ISO 18276-A:T69 5Z MM21 1 H5

AKM-76

Description: AKM-76 is a metal powder type seamless flux-cored 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, especially suitable for robot automatic welding; excellent low temperature impact performance.

Application: It is suitable for welding low-alloy high-strength steel with yield strength exceeding 690MPa and armor steel with the same strength level.

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	0.15-0.65	0.25-0.65	—
Actual Result	0.06	0.35	1.65	0.005	0.009	1.80	0.25	0.35	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)		
Requirement	≥ 760	≥ 680	≥ 15	$\geq 27(-20^{\circ}\text{C})$	-40°C	-50°C
Actual Result	810	760	20	125	98	75

Recommended welding parameters:

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