GB/T 5118 E6015-B3L
AWS A5.5 E9015-B3
EN ISO 3580 B E6216 2C1M

AKR407L

Description: AKR407L is a kind of low carbon heat-resistant steel electrode with low-hydrogen natrium type coating. It has excellent technological performance, low spatter, stable arc, good slag detachability, beautiful appearance of weld. DCRP (Direct Current Reversed Polarity). All-position welding. The weld ments should be given preheating to 160~220℃ before welding. The weldments should be given tempering at 680-720℃ after welding.

Application: Used for welding Cr2.25%-Mo1.0% (like 2.25Cr1Mo) heat-resistant steel below 550 ℃ such as high temperature and high pressure pipes, chemical machinery, petroleum cracking unit ,etc..

Typical Chemical Compostion(%):

	C	Mn	P	S	Si	Cr	Mo
Requirement	0.05	0.9	0.03	0.03	1.0	2.0-2.5	0.9-1.2
Actual Result	0.046	0.8	0.008	0.006	0.32	2.2	1.1

Typical Mechanical Properties :① =normaltemperature

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550	≥460	≥ 15	2 7J / ①
Actual Result	590	510	19	1 6 0J / ①

Notes on Usages:

1. **The electrodes must be baked at350~380℃for an hour before welding and used as soon as baking is completed.**

2. **The stains on the weldments, such as rust, oil stains, moisture, etc., must be cleared away before welding**