

AKR417

Description: Lo-sodium type coating of low alloy heat-resistant steel electrode: suitable for DC reverse polarity. short arc operation, all-position welding can be carried out. Operating characteristics of an electrode, and has good resistance to fatigue property of welded joints. high strength, excellent creep resistance at elevated temperatures can get good strength and low temperature toughness. Suitable for field installation and construction. compliance with AWS A5.5 B9016-B3 about the project requirements. And compared to ordinary steel welding material, has the following characteristics.

1. Deposited metal purity. impurities such as S and P is extremely low, $S < 0.010\%$ $P < 0.010\%$
2. Excellent low temperature toughness of deposited metal, $KWg (J, -30^{\circ}C) > 54J$.
3. Excellent resistance to temper embrittlement of weld metal, x factor is very low.

Application: Used in petroleum refining, petrochemical, chemical, power generation, using harsh conditions, such as corrosion medium complex AsMe SA542 Type of large equipment. Class D.4 A832 Gr. 22 v (2.25Cr1Mo0.25v) class steel plate welding.

Typical Chemical Composition(%):

	C	Mn	P	S	Si	Cr	Mo	Sb	As	Sn	V
Actual Result	0.06	0.72	0.006	0.003	0.19	2.27	1.02	0.001	0.004	0.001	0.22

Typical Mechanical Properties :

①=normal temperature ②=heat treatment $705^{\circ}C \times 8h$ ③=heat treatment $705^{\circ}C \times 26h$

$^{\circ}C$	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
①	690	590	20	② 99 104 105
475	—	510	—	
①	630	540	23	③ 146 165 124
475	—	430	—	