

AKR517

Description: Low-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. Transition from core alloy composition operating characteristics of an electrode, and welded joints of high strength, excellent creep resistance at elevated temperatures can get good strength and toughness. Suitable for field installation and construction, compliance with AWS A5.5 E8016-B6 about the project requirements. And compared to ordinary steel welding material and deposited metal purity.

Application: Used in petroleum refining petrochemical, chemical, power generation and other conditions of use harsh, corrosive medium large, complex equipment ASME SA387. Gr. 5 (5Cr- 0.5Mo) welding of steel.

Typical Chemical Composition(%):

	C	Mn	P	S	Si	Cr	Mo	—	—
Actual Result	0.06	0.75	0.008	0.003	0.23	5.5	0.53	—	—

Typical Mechanical Properties : ①=normal temperature ②=heat treatment 750°C×8h

°C	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
①	570	450	26	② 147 134 145
475	—	510	—	

Recommended welding parameters:

Diameter / mm	—	3.2	4.0	5.0
Welding Current (A)	—	90-120	140-180	180 - 220