



GB/T 17493 E551T-1M

AWSA5.36 E71T1-M21A2-CS1

EN ISO 17632 -A:T464 P M21 1 H5

AK-55M

Description: It is a rutile-type seamless flux-cored wire, containing 1%Ni, and the deposited metal has ultra-low diffusible hydrogen content($\leq 3\text{ml}/100\text{g}$);the arc is soft and stable, with less spatter, beautiful shape, good slag removal performance, and excellent Welding process performance;excellent low temperature impact performance.

Application: It is suitable for welding of bridges, port machinery, shipbuilding, offshore platforms, LPG storage tank cryogenic equipment, etc. of the same strength level, such as welding of 1Ni steel, etc.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	
Requirement	0.12	0.80	1.50	0.03	0.04	0.80-1.10	0.15	0.35	— —
Actual Result	0.032	0.38	1.30	0.006	0.01	0.97	0.01	0.01	— —

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)		
Requirement	550-690	≥ 470	≥ 19	$\geq 27(-30^{\circ}\text{C})$	-40 $^{\circ}\text{C}$	-60 $^{\circ}\text{C}$
Actual Result	606	540	25	142	130	92

Recommended welding parameters:

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