

# AK E10015-D2

**Description:** AK-E10015-D2 is a low alloy high strength steel electrode with low hydrogen sodium type coating. With DC reverse connection, all-position welding can be performed. The welding process performance is excellent, the arc is stable, the spatter is small, the slag removal is easy, and the welding seam is beautiful. The weld metal has good low temperature impact toughness.

**Application:** Suitable for low alloy steel structures of corresponding strength welding grades, such as 15MnMoV, 14MnMoNb, etc..

## Typical Chemical Composition(%):

|               | C    | Si   | Mn       | S    | P    | Mo        | — | — |
|---------------|------|------|----------|------|------|-----------|---|---|
| Requirement   | 0.15 | 0.6  | 1.65-2.0 | 0.03 | 0.03 | 0.25-0.45 | — | — |
| Actual Result | 0.07 | 0.40 | 1.85     | 0.02 | 0.01 | 0.035     | — | — |

## Typical Mechanical Properties:

|               | Tensile strength ( MPa) | Yield Stress (MPa) | Elongation ( % ) | Impact Values (J) |
|---------------|-------------------------|--------------------|------------------|-------------------|
| Requirement   | ≥690                    | ≥ 600              | ≥ 15             | ≥27J(-30℃)        |
| Actual Result | 720                     | 620                | 20               | 50                |

## Recommended welding parameters:

| Diameter/ mm        | 2.5   | 3.2     | 4.0     | 5.0     |
|---------------------|-------|---------|---------|---------|
| Welding current / A | 60-80 | 80- 120 | 140-180 | 180-220 |