

AK E6019

Description: Basic coated electrode designed for high quality welding. Excellent strength and toughness properties. It is also suitable for welding steels with low purity and high carbon content.

Application: For welding of steel structures, boiler and vessel construction, vehicle construction, shipbuilding and machinery construction and buffer layer when constructed on high carbon steel.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Mo	Cr	Ni	V
Requirement	0.20	1.0	1.2	0.035	0.040	0.30	0.20	0.30	0.08
Actual Result	0.08	0.28	0.37	0.020	0.025	0.005	0.035	0.03	0.004

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥430	≥ 330	≥ 20	≥27J(-20℃)
Actual Result	490	410	28	70

Recommended welding parameters:

Diameter/ mm	2.5	3.2	4.0	5.0
Welding current /A	—	90-140	150-210	200-270