

AK E71T-5M

Description: E71T-5M is made of high-quality materials. It has a smooth welding effect. Low melting point, strong weldability and corrosion resistance, high thermal conductivity, high electrical conductivity, and excellent processing performance.

Application: The Typical Applications are welding of heavy sections in pressure vessels, Construction equipment and Offshore structures.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	---	---	---	---
Requirement	0.12	0.90	1.75	0.03	0.03	---	---	---	---
Actual Result	0.06	0.44	1.38	0.011	0.012	---	---	---	---

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	490-670	≥ 390	≥22	≥27J(-40℃)
Actual Result	550	430	27	93

Recommended welding parameters:

Diameter/ mm	1.2	1.6	---	---
Welding voltage/V	24-30	24-30	---	---
Welding current/A	160-300	180-300	---	---