

AK E81T1-K2

Description: AK-E81T1-K2 is a CO₂ gas shielded flux-cored welding wire of titanium slag system. The welding process performance is better, the arc is stable, the spatter is less, the slag removal is easy, the welding seam is beautiful, and the all-position welding process performance is excellent. The weld has good plasticity and low temperature toughness.

Application: It is suitable for the welding of 550MPa high-strength steel structures, and is mostly used for the welding of steel structures such as ships, machinery manufacturing, containers, petrochemicals, bridges, and offshore platforms.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	—	—	—
Requirement	0.15	0.80	0.5-1.75	0.03	0.03	1.0-2.0	—	—	—
Actual Result	0.05	0.4	1.2	0.009	0.011	1.5	—	—	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	550-680	≥470	≥20	≥47J(-40℃)
Actual Result	620	550	25	120

Recommended welding parameters:

Diameter/ mm	1.0	1.2	1.6	
Welding voltage/V	15-20	22-32	25-38	—
Welding current/A	100-250	180-300	280-400	—