

AK E91T1-K2

Description: E91T1-K2 belongs to 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 metal has good plasticity and low temperature toughness.

Application: It is suitable for the welding of 620MPa grade high strength steel structures, and is mostly used for the welding of steel structures such as marine engineering, machinery manufacturing, containers, petrochemicals, bridges, etc.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	—
Requirement	0.15	0.80	0.50-1.75	0.03	0.03	1.00-2.00	0.15	0.35	—
Actual Result	0.055	0.40	1.30	0.008	0.012	2.10	0.05	0.015	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	620-760	≥ 540	≥ 17	≥47J(-40℃)
Actual Result	670	590	22	75

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	—