

AK E91T1-Ni2

Description: E91T1-Ni2 belongs to CO₂ gas shielded flux-cored welding wire of titanium slag system. Better welding process performance and stable arc Less spatter, easy slag removal, beautiful weld formation, and excellent all-position welding process performance. The weld metal has good plasticity and low temperature toughness.

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

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	—	—	—
Requirement	0.12	0.80	1.50	0.03	0.03	1.75-2.75	—	—	—
Actual Result	0.055	0.40	1.30	0.008	0.012	2.10	—	—	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	620-760	≥ 540	≥ 17	≥27J(-40℃)
Actual Result	650	570	23	101

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	—