



GB/T 5293 H08MnA
AWS A5.17 EM12
EN ISO 14171-AS2

AK EM12

Description: EM12 is a manganese buried arc welding wire in high-quality carbon steel. With the corresponding welding, the melting metal has a lower S, P content, excellent crack resistance and low temperature impact toughness.

Application: Combined with welding of carbon steel and low-alloy high-strength structure steel, such as Q235 and Q345 with welding (such as SJ101, etc.), such as Q235 and Q345.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.10	0.07	0.80-1.10	0.015	0.020	0.30	0.20	0.20	0.20
Actual Result	0.06	0.04	0.95	0.01	0.013	0.005	0.002	0.005	0.003

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	480-600	≥400	22	30J(-20℃)
Actual Result	550	455	28	92