

AK ER49-1

Description: AK-ER49-1 is a CO₂ gas shielded welding wire with H08Mn2SiA disc element and copper plated surface. The welding wire can be welded with a large current, with less spatter and good antiporosity. Also available for all-position welding of short-circuit transitions.

Application: Suitable for welding low carbon steel and some low alloy steel structures. It can be used to weld thin plates that require a smooth bead and steels with less severe rust and oxidation

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Cu	Other
Requirement	0.11	0.65-0.95	1.8-2.1	0.030	0.030	0.30	0.20	0.5	0.50
Actual Result	0.08	0.72	1.95	0.012	0.020	0.02	0.02	0.12	0.50

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥490	≥ 372	≥ 20	4 7J (2 5 °C)
Actual Result	545	425	30	120J