

AK ER60SD

Characteristics and applications: AK-ER60SD is low alloy steel copper-plated gas shielded wire, wire melting speed, arc stability, small spatter, beautiful weld shape, weld metal has good mechanical properties. Suitable for welding 600MPa steel structure. Commonly used in the same strength level of hydropower, bridges, petrochemical, engineering machinery, coal mining machinery and other structural steel welding.

Note:

1. The protective gas is rich argon or CO₂ gas, the gas flow rate is 15-20L/min.
2. The impurities such as water, oil and embroidery must be removed from the welding place.
3. When the current is more than 250A, the wire dry elongation should be 20-25mm.

Chemical composition of deposited metal (mass fraction) :

	C	Si	Mn	S	P	Ni	Cu	Mo
Requirement	0.12	0.40-0.80	1.40-2.10	0.025	0.025	0.15	0.50	0.20-0.50
Actual Result	0.082	0.62	1.60	0.007	0.008	0.015	0.12	0.33

Mechanical properties of deposited metal:

	Tensile strength (MPa)	Yield strength (MPa)	Elongation (%)	Impact function (J)	Protective gas
Requirement	≥600	≥480	≥ 17	≥27J/-40℃	—
Actual Result	635	544	25.5	78	CO ₂

Recommended parameters: (Polarity: DC)

Diameter/mm		1.0	1.2	1.6	—
Current (A)	F/H	80-250	100-350	170-390	—
	V/OH	110-160	120-180	—	—