

AK J507RH

Description: AK-J507RH is an ultra-low hydrogen high toughness low alloy steel electrode with low hydrogen sodium type alkaline coating. With DC reverse connection, all-position welding can be performed. The welding process performance is excellent, the arc is stable, the spatter is small, the slag removal is easy, and the welding seam is beautiful. The weld metal has good plasticity, low temperature toughness and crack resistance.

Application: Suitable for welding of ships, bridges, offshore platforms and other important structures.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni
Requirement	0.12	0.6	1.0-1.5	0.02	0.025	0.30-0.8
Actual Result	0.06	0.35	1.3	0.010	0.015	0.065

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥490	≥400	≥ 22	≥47(-40℃)
Actual Result	570	460	30	160

Recommended welding parameters:

Diameter/ mm	2.5	3.2	4.0	5.0
Welding current / A	70-100	100-140	140-180	180-220