AK J607RH

GB/T 32533 E5915-GPU

AWS A5.5 E9015-G

Characteristics and Applications: AK-J607RH is a special low alloy steel electrode for pressure equipment with ultra -low hydrogen and high toughness, excellent welding performance, less spatter, beautiful shape, easy slag. It is used for welding 600MPA grade low alloy steel of pressure equipment with higher low temperature requirement, such as water, electricity and low temperature storage tank, or for welding between heat-resistant and low temperature low alloy steel.

Note:

1. The electrode must be baked for one hour at 380-400 ° C before using.
2. Impurities such as water, oil and embroidery must be removed from the surface of the welding part.
3. Short arc narrow pass welding, the maximum swing should not exceed three times the line diameter.

Chemical composition of deposited metal (mass fraction) :

	C	Si	Mn	S	P	Ni	Mo
Requirement	0.10	0.80	≥ 1.00	0.015	0.025	0.60-1.20	0.10-0.40
Actual Result	0.068	0.45	1.30	0.010	0.016	0.90	0.20

The mechanical properties of deposited metal were (620 ± 15 ° CX1H)

	Tensile strength (MPa)	Yield strength (MPa)	Elongation (%)	Impact function (J)
GB/NB Standard	≥ 590	≥490	≥ 16	≥27J/-20C
AWS Standard	≥620	≥ 530	≥ 17	——
Actual Result	640	540	27	120

Diffused hydrogen content of molten metal: ≤4.0mL/100g(mercury method or thermal conductivity method)
Molten metal X-ray detection requirements: Grade I
Recommended parameters: (Polarity: DC)

Diameter/mm		2.5*300	3.2*350	4.0*400	5.0*400
Current (A)	F/H	70- 100	90-130	140- 180	170-200
	V/OH	60-90	80- 120	130- 170	——