

AK J62CF

NB/T 47018 E6215-G

GB/T 32533 E6215-G

AWS A5.5 E9015-G

Characteristics and Applications: AK-J62CF is a 620MPa grade low alloy steel electrode, the coating type is basic low hydrogen sodium type, the arc stability is good, the spatter is small, the weld shape is beautiful, the penetration is moderate, the slag is easy. The deposited metal has excellent ductility and crack resistance. It is suitable for welding 600MPa grade steel such as hydropower volute and pressure pipeline, and the same grade steel such as ship, bridge and building.

Note:

1. The electrode must be baked at 380 ° C for one hour before use.
2. Impurities such as water, oil and embroidery must be removed from the surface of the welding parts.
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	0.07	0.50	1.35	0.009	0.015	0.87	0.23

Note: In order to meet the requirements of group G alloy, the undiluted weld metal shall be at least conducive to a minimum value in this table

	Tensile strength (MPa)	Yield strength (MPa)	Elongation (%)	Impact function (J)	Bending performance (D =4t, a =180°)
GB/NB Standard	≥620	≥ 530	≥ 15	≥ 54J/-50C	No defects
AWS Standard	≥620	≥ 530	≥ 17	—	—
Actual Result	670	580	25	120	Conformity

Diffused hydrogen content of deposited metal: ≤ 5.0mL/100g(mercury method or thermal conductivity method)

X-ray detection requirements for deposited metal: 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	—