

AK J707RH

Description: AK-J707RH is an ultra-low hydrogen high toughness high strength steel electrode with low hydrogen sodium type 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 cold bending, crack resistance and explosion resistance of the welded joint are good, and the weld metal has good plasticity and toughness.

Application: Suitable for welding low alloy steel structures with tensile strength equivalent to 690MPa.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.12	0.8	1.3-1.8	0.03	0.030	1.4-2.0	0.25-0.5	—	—
Actual Result	0.05	0.3	1.69	0.007	0.018	1.78	0.37	—	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 690	≥ 600	≥ 15	≥34J(-50℃)
Actual Result	730	660	24	82

Recommended welding parameters:

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