

AK W607

Description: AK-W607 is a low-temperature steel electrode with low-hydrogen sodium coating containing Ni, DC reverse connection, and can be welded in all positions. The deposited metal still has good impact toughness at -60°C .

Application: Welding -60°C low temperature steel structure, such as 13MnSi63, 09MnNiNb, E36, etc..

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	—	—	—
Requirement	0.07	0.5	1.2-1.7	0.035	0.035	0.6-1.0	—	—	—
Actual Result	0.055	0.35	1.28	0.008	0.015	0.93	—	—	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥490	≥ 390	≥ 22	5 4J (- 4 0 °C)
Actual Result	570	480	28	120(-40°C)

Recommended welding parameters: DC+

Diameter / mm	2.5	3.2	4.0	5.0
Electrode Length (mm)	300	350	400	400
Welding Current (A)	60-100	80-130	140-200	180-240

1. The electrode must be baked at about 350C for 1 hour before welding, and it can be used as it is baked.
2. Before welding, the rust, oil, moisture and other impurities in the weldment must be removed.