

AK W807Ni

Description: AK-W807Ni is a low-temperature steel electrode containing Ni in a low-hydrogen sodium coating, DC reverse connection, and can be welded in all positions. The deposited metal still has good impact toughness at -80°C .

Application: Welding 1.5Ni steel structures working at -80°C .

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	—	—	—
Requirement	0.08	0.6	1.25	0.035	0.035	1.00	—	—	—
Actual Result	0.051	0.28	0.68	0.01	0.013	1.90	—	—	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥490	≥ 390	≥ 22	27J(-80°C)
Actual Result	540	450	28	120

Recommended welding parameters:

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.