

AK W907Ni

Description: AK-W907Ni is a low-temperature steel electrode with a 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 -90°C .

Application: Welding 3.5Ni low-temperature low-alloy steel structures working at- 90°C .

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	—	—	—
Requirement	0.12	0.80	1.25	0.030	0.030	3.0-3.75	—	—	—
Actual Result	0.06	0.25	0.70	0.01	0.02	3.40	—	—	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550	≥460	≥ 17	2 7J (- 9 0 °C)
Actual Result	580	480	27	110(-90°C)

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.