



GB/T 5293 H08MnA
AWS A5.17 EM12
EN ISO 14171-AS2

AK EM12

Description: EM12 is a manganese buried arc welding wire in high-quality carbon steel. With the corresponding welding, the melting metal has a lower S, P content, excellent crack resistance and low temperature impact toughness.

Application: Combined with welding of carbon steel and low-alloy high-strength structure steel, such as Q235 and Q345 with welding (such as SJ101, etc.), such as Q235 and Q345.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.06-0.15	0.10	0.80-1.25	0.030	0.030	—	—	—	0.35
Actual Result	0.08	0.04	0.86	0.015	0.010	—	—	—	0.20

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	480-600	≥400	22	30J(-20℃)
Actual Result	550	455	28	92