



GB/T 5293S55A 6 FB-SUN2M1  
 AWS A5.23 F8A8-ENi5-Ni5  
 EN ISO 14171-A S 46 6 FBT2Ni5

# AK ENi5

**Description:** ENi5 is a high quality submerged arc welding wire for low temperature steel. Low content of S and P, excellent low temperature toughness.

**Application:** With flux (such as SJ101, etc.), it is used for welding of cryogenic vessels, offshore platforms and ships, such as submerged arc welding of S355 steel.

### Typical Chemical Composition(%):

	C	Si	Mn	S	P	Mo	Ni	Cu	
<b>Requirement</b>	0.12	0.05-0.30	1.20-1.60	0.020	0.020	0.10-0.30	0.75-1.25	0.35	
<b>Actual Result</b>	0.04	0.18	1.40	0.005	0.009	0.20	0.94	0.20	

### Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress ( MPa)	Elongation (%)	Impact Values ( J)
<b>Requirement</b>	550-700	≥470	22	27J(-60°C)
<b>Actual Result</b>	610	545	23	128