

GMAW Solid Wire for High Tensile Strength Steel

KM-55

Classification

AWS	A5.18	ER80S-G
JIS	Z3312	YGW18
EN	14341-A	G50 0 C1 Z
GB	T 8110	ER50-G

Shielding Gas: CO₂

Applications and Features

- (1) KM-55 is suitable for welding 490, 520 and 540N/mm² grade steel at high current and interpass temperature.
- (2) Due to its special alloy content, it will provide excellent weldability, stable arc, low spatters and mechanical properties with higher heat input and interpass temperature.
- (3) Ideal for welding pillars and beams at high current.

Welding Position

F, H-fillet, H

Welding Instruction

Please refer to Appendix B.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.100	0.48	1.07	0.019	0.009

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %	Charpy V-Notch °C	J (kgf -m)
579(59.0)	500(51.0)	28	0	137(14.0)
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Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6	
Amp	F/H-fillet	200~350	250~450	300~550
	H	200~320	250~400	300~450