

# GMAW Solid Wire for High Tensile Strength Steel

# KM-57

## Classification

AWS	A5.18	ER70S-7
JIS	Z3312	YGW14
EN	14341-A	G423C G0
GB	T 8110	ER50-7

Shielding Gas: CO<sub>2</sub>

## Applications and Features

- (1) KM-57 provides good weldability for galvanize steel plate due to appropriate alloy content.
- (2) Good wettability and puddle fluidity at high travel speed.
- (3) Ideal for welding galvanize steel plate in containers, vehicles and constructions.

## Welding Position

All Positions

## Welding Instruction

Please refer to Appendix B.

## Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.060	0.55	1.75	0.010	0.015

## Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation %	Charpy V-Notch	
			°C	J (kgf -m)
580(59.0)	473(48.2)	29	0	85(8.7)
			-30	61(6.2)

## Size and Suggested Operating Range (DC+)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6	
Amp	F	50~180	50~200	80~250	150~350	150~450	250~500
	V-up	50~100	50~140	80~160	80~180	100~180	—
	OH	50~100	50~100	70~120	80~150	—	—
	V-down	50~100	50~200	80~220	80~240	—	—