

# GMAW Solid Wire for High Tensile Strength Steel

# KM-70

## Classification

AWS	A5.28/A5.28M	ER70S-6 /ER48S-6
JIS	Z3312	YGW12
EN	16834-A	G423C G2Si
GB	T 8110	ER50-6

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

## Applications and Features

- (1) KM-70 is suitable for welding mild steel and 490N/mm<sup>2</sup> grade sheet metal.
- (2) Stable arc and low spatters at low current.
- (3) Ideal for welding sheet metal in vehicles and body repair.

## Welding Position

All Positions

## Welding Instruction

Please refer to Appendix B.

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

C	Si	Mn	P	S	Al
0.080	0.60	1.10	0.014	0.010	0.006

## 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)
545(55.6)	480(49.0)	29	0	84(8.6)
			-30	61(6.2)

## Size and Suggested Operating Range (DC+)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6
F	50~180	50~200	80~250	100~350	100~470	200~500
V-up	50~100	50~100	50~120	80~150	100~180	—
OH	50~100	50~140	70~160	80~180	—	—
V-down	50~100	50~200	80~220	80~240	—	—