

GMAW Solid Wire for High Tensile Strength Steel

KM-50ZS

Classification

AWS A 5.18/A5.18M	ER70S-G/ ER48S-G
JIS Z3312	G49 A 2 M 0
EN ISO14341-A	G42 2 M21 Z
GB T8110	ER50-G

Shielding Gas: 80%Ar+20%CO₂

Applications and Features

- (1) Suitable for welding 490N/mm² grade steel with Ar+CO₂ shielding gas.
- (2) Better bead appearance on a galvanized steel plate with high-speed welding.
- (3) It improves electrodeposition coating properties due to ultra-low slag.
- (4) Ideal for welding automotive components.

Welding Position



Welding Instruction

- (1) Please use pulse welding.
- (2) Please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S
0.05	0.08	2.15	0.012	0.007

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
610	550	28	-20	80

Size and Suggested Operating Range (DC+)

Diameter (mm)		1.0	1.2
Current (A)	F/H-Fillet	80~250	150~320