

## GMAW Solid Wire for High Tensile Strength Steel

# KM-50LS

### Classification

AWS A 5.18/A5.18M	ER70S-G/ ER49S-G
JIS Z3312	G49 A 2 M 0
EN ISO14341-A	G42 2 M21 Z
GB T8110	ER50-G

Shielding Gas:80%Ar+20%CO<sub>2</sub>

### Applications and Features

- (1) Suitable for welding 490N/mm<sup>2</sup> grade steel with Ar+CO<sub>2</sub> shielding gas.
- (2) Better wetting and bead shape on a with high-speed welding.
- (3) It improves electrodeposition coating properties due to extremely-low slag.
- (4) Ideal for welding automotive components with galvanized steel plate.

### Welding Position



### Welding Instruction

- (1) Please use pulse mode 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 <sup>2</sup>	N/mm <sup>2</sup>	%	°C	J
610	550	25	-20	55

### Size and Suggested Operating Range (DC+)

Diameter (mm)		1.0	1.2
Current (A)	F/H-Fillet	80~250	100~300
	V-up	80~140	80~160