

# KM-50LSZ

Classification

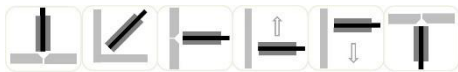
|                   |                  |
|-------------------|------------------|
| AWS A 5.18/A5.18M | ER70S-G/ ER49S-G |
| JIS Z3312         | G49 A 2 M 0      |
| EN ISO14341-A     | G42 2 M21 Z      |
| GB T8110          | ER50-G           |

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

Applications and Features

- (1) KM-50LSZ is a non-copper coating GMAW wire and 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  |
| 640               | 602               | 26         | -20            | 50 |

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  |