

GMAW Wires for Low Alloy Steel

KM-100SG

Classification

AWS A5.28/A5.28M	ER100S-G/ ER69S-G
JIS Z3312	G69A5M0
EN ISO 16834-A	G62 5 M21 Z
GB T39281	G57A5M21ZN1M2T

Shielding Gas: 80%Ar+20%CO₂

Applications and Features

- (1) Suitable for welding 690N/mm² grade steel.
- (2) Ni-Cr-Mo alloy provides high tensile strength and good impact toughness.
- (3) Ideal for welding cranes, construction machine and automobiles.

Welding position



Welding Instruction

Please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Ni	Mo
0.07	0.62	1.61	0.012	0.008	0.61	0.30

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
699	504	23	-50	150

Size and Suggested Operating Range (DC+)

Diameter (mm)		1.2	1.4	1.6
Current (A)	F/HF	100~350	150~450	200~550
	H	100~300	150~350	200~400