

GMAW Wires for Low Alloy Steel

KM-110SG

Classification

AWS A5.28/A5.28M	ER110S-G/ ER76S-G
JIS Z3312	G76A6M0
EN ISO 16834-A	G69 6 M21 Mn4Ni1.5CrMo
GB T39281	G 76A 6 M21 ZN4CM2T

Shielding Gas: 80%Ar+20%CO₂

Applications and Features

- (1) Suitable for welding 760N/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	Cr	Mo
0.08	0.60	1.70	0.009	0.010	1.45	0.17	0.47

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
824	710	19	-40	60
			-60	50

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