

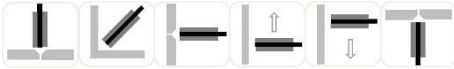
# KM-50LS

**Classification**

AWS A5.18/A5.18M	ER70S-G/ ER49S-G
JIS Z3312	G49A2M0
EN ISO 14341-A	G42 2 M21 Z
GB T8110	ER50-G

Shielding Gas:80%Ar+20%CO<sub>2</sub>**Applications and Features**

- (1) KM-50LS is a copper coated wire for welding 490N/mm<sup>2</sup> grade steel.
- (2) Better wetting and bead shape at high travel speed.
- (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
646	603	25	-20	55

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

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