

KM-50ZN

Classification

AWS A5.18/A5.18M	ER70S-G/ ER49S-G
JIS Z3312	YGW17
EN ISO 14341-A	G42 3 M21 S17
GB T8110	ER50-G

Shielding Gas:80%Ar+20%CO₂**Applications and Features**

- (1) KM-50ZN is a copper coated wire for welding 490N/mm² grade steel.
- (2) Proper alloy design provides excellent weldability on galvanized steel sheet.
- (3) Better wetting and bead shape at high travel speed.
- (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
0.09	0.31	1.70	0.009	0.001

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
572	494	30	-30	191

Size and Suggested Operating Range (DC+)

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