

GMAW Solid Wire for High Tensile Strength Steel

KM-53

Classification

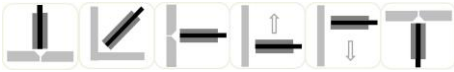
AWS A5.18/A5.18M	ER70S-3/ ER49S-3
JIS Z3312	YGW16
EN ISO 14341-A	G42 2 M21 2Si
GB T8110	ER50-3

Shielding Gas: 80%Ar+20%CO₂

Applications and Features

- (1) KM-53 is a copper coated wire for welding 490N/mm² grade steel.
- (2) Excellent weld pool fluidity, crack resistance, low spatter and thin slag with easy removal in short-circuit transfer at low current.
- (3) Design for welding sheet metal requiring smooth and fine bead appearance and all position welding.
- (4) Ideal for automotive, shipbuilding, pipe, steel structure, bridge and machinery.

Welding Position



Welding Instruction

Please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S
0.08	0.61	1.33	0.012	0.014

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
525	429	32	-20	153

Size and Suggested Operating Range (DC+)

Diameter (mm)		0.9	1.0	1.2
Current (A)	F/HF	50~220	50~250	80~300
	V-up	50~150	50~160	50~180
	OH	50~150	50~160	50~180