

GMAW Solid Wire for High Tensile Strength Steel

KM-54

Classification

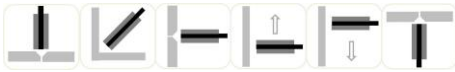
AWS A 5.18/A5.18M	ER70S-4/ ER49S-4
JIS Z3312	G49A3UC4
EN ISO 14341-A	G42 3 C1 3Si1
GB T8110	ER50-4

Shielding Gas: 100%CO₂

Applications and Features

- (1) KM-54 is a copper coated wire for welding 490N/mm² grade steel.
- (2) Low spatter, stable arc and good bead appearance.
- (3) Design for welding sheet metal, all position welding and root pass welding at high travel speed.
- (4) Ideal for welding 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
0.07	0.79	1.40	0.013	0.014

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
549	460	32	-30	86

Size and Suggested Operating Range (DC+)

Diameter (mm)	0.9	1.0	1.2	1.4	1.6	
F/HF	50~200	80~250	100~350	100~470	200~500	
Current (A)	V-up	50~140	50~140	50~160	100~180	-
	OH	50~120	50~120	50~140	-	-