

## GMAW Solid Wire for High Tensile Strength Steel

# KM-55

### Classification

AWS A5.28/A5.28M	ER80S-G/ ER55S-G
JIS Z3312	YGW18
EN ISO 14341-A	G50 0 C1 Z
GB T8110	ER55-G

Shielding Gas:100%CO<sub>2</sub>

### Applications and Features

- ( 1 ) KM-55 is a copper coated wire for welding 490N/mm<sup>2</sup> grade steel.
- ( 2 ) Excellent welding performance and mechanical properties under high heat input and interpass temperature.
- ( 3 ) Stable arc and low spatter at high current.
- ( 4 ) Ideal for welding steel structure, bridge, pressure vessel and shipbuilding.

### Welding Position



### Welding Instruction

Please refer to Appendix B.

### Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Ti
0.05	0.79	1.77	0.010	0.005	0.18

### 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
579	500	28	0	137

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

Diameter (mm)	1.2	1.4	1.6	
Current (A)	F/HF	150~350	250~450	300~550
	H	150~320	250~400	300~450