

## GMAW Solid Wire for High Tensile Strength Steel

# KM-56

### Classification

|                  |                  |
|------------------|------------------|
| AWS A5.18/A5.18M | ER70S-6/ ER49S-6 |
| JIS Z3312        | YGW12            |
| EN ISO 14341-A   | G42 3 C1 3Si1    |
| GB T8110         | ER50-6           |

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

### Applications and Features

- ( 1 ) KM-56 is a copper coated wire for welding 490N/mm<sup>2</sup> grade steel.
- ( 2 ) Wide welding parameter range, stable arc and low spatter.
- ( 3 ) Design for welding sheet metal and all positions 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     |
|------|------|------|-------|-------|
| 0.06 | 0.87 | 1.46 | 0.013 | 0.011 |

### 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  |
| 565               | 435               | 28         | -30            | 68 |

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

| Diameter (mm) | 0.8    | 0.9    | 1.0    | 1.2     | 1.4     | 1.6     |   |
|---------------|--------|--------|--------|---------|---------|---------|---|
| F/HF          | 50~180 | 50~200 | 80~250 | 100~350 | 100~470 | 200~500 |   |
| Current (A)   | V-up   | 50~100 | 50~140 | 50~140  | 50~160  | 100~180 | - |
|               | OH     | 50~100 | 50~120 | 50~120  | 50~140  | -       | - |