

KM-59

Classification

AWS A5.28/A5.28M	ER80S-G/ER55S-G
JIS Z3312	YGW19
EN ISO14341-A	G50 0 M21 Z
GB T8110	ER55-G

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

- (1) KM-59 is a copper coated wire for welding 550N/mm² grade steel with Ar+CO₂ shielding gas.
- (2) Good mechanical properties can be achieved even under high heat input welding.
- (3) Suitable for high-current welding of thick plate butt joints, fillet welding, and horizontal welding.
- (4) Ideal for welding steel structures, ship-building, bridges, and machinery.

Welding Position**Welding Instruction**

Please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Mo	Ti
0.07	0.48	1.51	0.003	0.001	0.16	0.09

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
609	609	29	0	95

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6	
Current (A)	F/HF	250~350	250~450	300~500
	H	130~230	150~250	150~300