

## GMAW Solid Wire for High Tensile Strength Steel

# KM-60

### Classification

AWS A5.28/A5.28M	ER80S-G/ER55S-G
JIS Z3312	G59JA1UC3M1T
EN ISO 14341-A	G50 0 C1 Z
GB T8110	ER55-G

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

### Applications and Features

- ( 1 ) KM-60 is a copper coated wire for welding 590N/mm<sup>2</sup> grade steel.
- ( 2 ) Ti addition in the wire reduces droplet size, stabilizes the arc and decreases spatter at high current.
- ( 3 ) Ideal for welding steel structures, pressure vessels, and bridges.

### Welding Position



### Welding Instruction

Please refer to Appendix B.

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

C	Si	Mn	P	S	Mo	Ti
0.07	0.53	1.44	0.014	0.006	0.13	0.22

### 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
650	560	26	-5	82

### 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