

GMAW Solid Wire for High Tensile Strength Steel

KM-60A

Classification

AWS A 5.28/A5.28M

JIS Z3312

EN ISO14341-A

GB T8110

ER80S-G/ER55S-G

G62A3UM4M31

G50 3 M21 G4M31

ER55-G

Shielding Gas: 80%Ar+20% CO₂

Applications and Features

- (1) KM-60A is a copper coated wire for welding 590N/mm² grade steel with Ar+CO₂ shielding gas.
- (2) Excellent impact toughness at -30°C.
- (3) Ideal for welding steel structures, pressure vessels, and bridges.

Welding Position



Welding Instruction

Please refer to Appendix B.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Mo
0.07	0.51	1.61	0.011	0.010	0.41

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
696	623	21	-30	121

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