

Metal Cored Wire for High Tensile Strength Steel

KMX-70M

Classification

AWS A5.18/A 5.18M	E70C-6M H4/E49C-6M H4
JIS Z3313	T49J0T15-0MA-U
EN ISO 17632-A	T42 4 M M21 1 H5
GB T10045	T49 4 T15-1 M21 A H5

Shielding Gas: 80%Ar+20%CO₂

Applications and Features

- (1) KMX-70M is a metal cored wire for welding 490N/mm² grade high tensile steel.
- (2) Higher deposition rate and faster travel speed can increase the welding efficiency.
- (3) Stable arc, low spatter, very low slag and good bead appearance.
- (4) Ideal for welding machinery, steel structure, bridge, construction machine, LPG, pipeline, offshore structure, and foundation of offshore wind mill.

Welding position



Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.06	0.58	1.55	0.019	0.007

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
572	492	30	-40	61

Size and Suggested Operating Range (DC+)

Diameter (mm)	0.9	1.2	1.4	1.6
F/HF	55~250A/16~28V	100~300A/16~30V	200~450A/18~43V	250~500A/20~45V