

KM-50LSZ

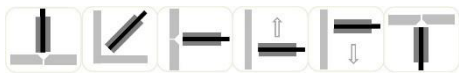
Classification		
AWS A5.18/A5.18M	ER70S-G/ ER49S-G	
JIS Z3312	G49A2M0	
EN ISO 14341-A	G42 2 M21 Z	
GB T8110	ER50-G	

Shielding Gas:80%Ar+20%CO₂

Applications and Features

- (1) KM-50LSZ is a non-copper coated wire for welding 490N/mm² grade steel.
- (2) Better wetting and bead shape at high travel speed.
- (3) It improves electrodeposition coating properties due to extremely-low slag.
- (4) Ideal for welding automotive components with galvanized steel plate.

Welding Position



Welding Instruction

- (1) Please use pulse mode welding.
- (2) Please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S
0.05	0.08	2.15	0.012	0.007

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
640	602	26	-20	50

Size and Suggested Operating Range (DC+)

Diameter (mm)		1.0	1.2
Current (A)	F/HF	80~250	100~300
	V-up	80~140	80~160