GMAW Solid Wire for High Tensile Strength Steel

KM-53Z

Shielding Gas:80%Ar+20%CO_2

Classification

AWS A5.18/A5.18M	ER70S-3/ ER49S-3
JIS Z3312	YGW16
EN ISO 14341-A	G42 2 M21 2Si
GB T8110	ER50-3

Applications and Features

(1) KM-53Z is a non-copper coated wire for welding 490N/mm² grade steel.

(2) Excellent weld pool fluidity, crack resistance, low spatter and thin slag with easy removal in short-circuit transfer at low current.

(3) Design for welding sheet metal requiring smooth and fine bead appearance and all position welding.

(4) Ideal for automotive, shipbuilding, pipe, steel structure, bridge and machinery.

Welding Position

Welding Instruction

Please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S
0.08	0.69	1.19	0.012	0.016

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm²	N/mm²	%	℃	J
549	424	29	-20	105

Size and Suggested Operating Range (DC+)

Diameter (mm)		0.9	1.0	1.2
Current (A)	F/HF	50~220	50~250	80~300
	V-up	50~150	50~160	50~180
	OH	50~150	50~160	50~180