

GMAW Solid Wire for High Tensile Strength Steel

KM-55Z

Classification

AWS A5.28/A5.28M	ER80S-G/ ER55S-G
JIS Z3312	YGW18
EN ISO 14341-A	G50 0 C1 Z
GB T8110	ER55-G

Shielding Gas:100%CO₂

Applications and Features

- (1) KM-55Z is a non-copper coated wire for welding 490N/mm² grade steel.
- (2) Excellent welding performance and mechanical properties under high heat input and interpass temperature.
- (3) Stable arc and low spatter at high current.
- (4) Ideal for welding steel structure, bridge, pressure vessel and shipbuilding.

Welding Position



Welding Instruction

Please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Ti
0.06	0.78	1.79	0.015	0.005	0.17

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
585	510	29	0	132

Size and Suggested Operating Range (DC+)

Diameter (mm)		1.2	1.4	1.6
Current (A)	F/HF	150~350	250~450	300~550
	H	150~320	250~400	300~450