

# KM-56Z

Shielding Gas:100% CO<sub>2</sub>

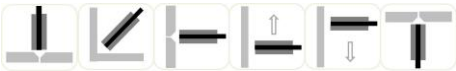
### Classification

|                  |                  |
|------------------|------------------|
| AWS A5.18/A5.18M | ER70S-6/ ER49S-6 |
| JIS Z3312        | YGW12            |
| EN ISO 14341-A   | G42 3 C1 3Si1    |
| GB T8110         | ER50-6           |

### Applications and Features

- ( 1 ) KM-56Z is a non-copper coated wire for welding 490N/mm<sup>2</sup> grade steel.
- ( 2 ) Wide welding parameter range, stable arc and low spatter.
- ( 3 ) Design for welding sheet metal and all positions 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     |
|------|------|------|-------|-------|
| 0.07 | 0.85 | 1.48 | 0.016 | 0.013 |

### Typical Mechanical Properties of Weld Metal

| Tensile Strength  | Yield Strength    | Elongation | Charpy V-Notch |    |
|-------------------|-------------------|------------|----------------|----|
| N/mm <sup>2</sup> | N/mm <sup>2</sup> | %          | °C             | J  |
| 548               | 433               | 29         | -30            | 95 |

### Size and Suggested Operating Range (DC+)

| Diameter (mm) |      | 0.8    | 0.9    | 1.0    | 1.2     | 1.4     | 1.6     |
|---------------|------|--------|--------|--------|---------|---------|---------|
| Current (A)   | F/HF | 50~180 | 50~200 | 80~250 | 100~350 | 100~470 | 200~500 |
|               | V-up | 50~120 | 50~140 | 50~140 | 50~160  | 100~180 | -       |
|               | OH   | 50~100 | 50~120 | 50~120 | 50~140  | -       | -       |