

KM-60Z

Classification

AWS A5.28/A5.28M	ER80S-G/ER55S-G
JIS Z3312	G59JA1UC3M1T
EN ISO 14341-A	G50 0 C1 Z
GB T8110	ER55-G

Shielding Gas: 80%Ar+20%CO₂**Applications and Features**

- (1) KM-60Z is a non-copper coated wire for welding 590N/mm² grade steel.
- (2) Ti addition in the wire reduces droplet size, stabilizes the arc and decreases spatter at high current.
- (3) Ideal for welding steel structures, pressure vessels, and bridges.

Welding Position**Welding Instruction**

Please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Mo	Ti
0.06	0.54	1.42	0.015	0.008	0.13	0.22

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
666	565	27	-5	85

Size and Suggested Operating Range (DC+)

Diameter (mm)		1.2	1.4	1.6
Current (A)	F/HF	250~350	250~450	300~500
	H	130~230	150~250	150~300