

# GMAW Solid Wire for High Tensile Strength Steel

# KM-58

## Classification

AWS	A5.18	ER70S-G
JIS	Z3312	YGW11
EN	14341-A	G42 0 C1 Z
GB	T 8110	ER50-G

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

## Applications and Features

- (1) KM-58 provides stable arc due to additional Ti content.
- (2) It also provides low spatters and fumes at high current.
- (3) Ideal for welding thick plate for ship-building, steel structures and bridges with good weldability at high currents.

## Welding Position

All Positions

## Welding Instruction

Please refer to Appendix B.

## Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.100	0.57	1.26	0.014	0.011

## Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation %	Charpy V-Notch	
			°C	J (kgf -m)
588(60.0)	520(53.0)	29	0	98(10.0)
			-30	—

## Size and Suggested Operating Range (DC+)

Diameter (mm)	1.0	1.2	1.4	1.6	
F	50~220	100~350	150~450	250~550	
Amp	V-up	50~200	100~300	150~350	—
	OH	50~100	100~140	150~160	—
	V-down	50~100	100~200	—	—