

# KM-56

## Classification

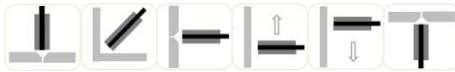
AWS	A 5.18/A5.18M	ER70S-6/ ER48S-6
JIS	Z3312	YGW12
EN	14341-A	G42 3 C1 3Si1
GB	T8110	ER50-6

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

## Applications and Features

- (1) KM-56 is suitable for welding 490N/mm<sup>2</sup> grade steel.
- (2) Wide operation range, stable arc and low spatters.
- (3) It is designed for welding in vehicles, ship-building, steel structures, bridges and pipes with single pass or multi-pass welding.

## Welding Position



## Welding Instruction

Please refer to Appendix B.

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

C	Si	Mn	P	S
0.07	0.61	1.14	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
565	435	28	0	119
			-30	68

## Size and Suggested Operating Range (DC+)

Diameter (mm)		0.8	0.9	1.0	1.2	1.4	1.6
Current (A)	F	50~180	50~200	50~220	80~350	100~470	200~500
	V-up	50~100	50~140	50~140	50~140	100~180	-
	OH	50~100	50~120	50~120	50~160	-	-
	V-down	50~100	50~200	-	-	-	-