

GMAW Solid Wire for High Tensile Strength Steel

KM-56Z

Classification

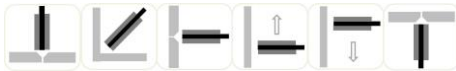
AWS	A 5.18/A5.18M	ER70S-6/ ER48S-6
JIS	Z3312	YGW12
EN	14341-A	G42 3 C1 3Si1
GB	T8110	ER50-6

Shielding Gas: 100% CO₂

Applications and Features

- (1) KM-56Z is a non-copper coating GMAW wire and suitable for welding 490N/mm² 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
0.08	0.65	1.16	0.014	0.011

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
			°C	J
N/mm ²	N/mm ²	%	0	130
			-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	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	-	-	-	-