GMAW Solid Wire for Stainless Steel

KMS-307Si

Classification

AWS A5.9/A5.9M

JIS Z3323

EN 14343A G 18 8 Mn

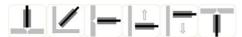
YB T5092

Shielding Gas: Ar+1~2%O₂(CO₂)

Applications and Features

- (1) Weld metal is austenitic structure with 20%Cr-9%Ni-6%Mn.
- (2) High silicon level for increased puddle fluidity and toe wetting.
- (3) 6% Manganese (Mn) increases resistance to hot cracking.
- (4) Suitable for welding work hardening manganese steel and armor plate.
- (5) Designed for joining dissimilar stainless steel.

Welding Position



Welding Instruction

- (1) Use Ar+1~2%O₂ for spray transfer and Ar+1~2%CO₂ for short-circuit transfer.
- (2) For other instructions, please refer to Appendix B and F.

Typical Chemical Composition of Weld Metal (wt%)

С	Si	Mn	Р	S	Cr	Ni
0.06	0.82	6.10	0.018	0.012	19.22	8.10

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation		
N/mm²	N/mm²	%		
610	460	41		

Size and Suggested Operating Range (DC+)

Diameter (mm)		8.0	0.9	1.0	1.2	1.4	1.6
Ar+1~2%CO ₂	Current (A)	40~120	60~140	80~160	100~210	-	-
	Voltage (V)	15~20	15~21	16~22	17~22	-	-
Ar+1~2%O ₂	Current (A)	160~210	170~260	180~280	200~300	210~320	220~330
	Voltage (V)	24~28	24~30	24~30	24~30	24~32	24~32