

Metal Cored Wire for Low Alloy Steel

KMX-100G

Classification

AWS A5.28/A5.28M

JIS Z3313

EN ISO 18276-B

GB T17493

E100C-G/ E69C-G

T694T15-0MA-G

T694T15-3M21A-G

E69C-G

Shielding Gas: 80%Ar+20% CO₂

Applications and Features

- (1) Suitable for welding 690N/mm² grade steel.
- (2) Higher deposition rate, faster travel speed, superior arc wetting and better bead appearance.
- (3) Ideal for welding vehicles, electric bus, heavy construction machine and coal mining equipment.

Welding position



Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr
0.08	0.57	1.75	0.013	0.006	0.55

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
723	665	23	-29	112
			-40	86

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.0	1.2	1.4	1.6	
Current (A)	F/HF	100~230	180~350	200~450	350~600