

KM-60

Classification

AWS A5.28/A5.28M	ER80S-G/ ER55S-G
JIS Z3312	G59JA1UC3MIT
EN ISO 14341-A	G50 0 C1 Z
GB T8110	ER55-G

Shielding Gas:100% CO₂

Applications and Features

- (1) KM-60 is a copper coating GMAW wire and suitable for welding 590N/mm² grade steel.
- (2) Wide operation range stable arc and good weldability.
- (3) Ideal for welding in bridges, construction and pressure vessels.

Welding Position



Welding Instruction

Please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Mo	Ti
0.07	0.53	1.44	0.014	0.006	0.13	0.22

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
650	560	26	-5	82

Size and Suggested Operating Range (DC+)

Diameter (mm)		1.2	1.4	1.6
Current (A)	F/HF	250~350	250~450	300~500
	H	130~230	150~250	150~300