

KM-56

Classification

AWS	A5.18/A5.18M	ER70S-6/ER48S-6
JIS	Z3312	YGW12
EN	14341-A	G423C G2Si
GB	T8110	ER50-6

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

Applications and Features

- ( 1 ) KM-56 is a GMAW wire.
- ( 2 ) Wide operation range, stable arc and low spatters.
- ( 3 ) It is designed for welding in vehicles, shipbuilding, steel structures, bridges and pipes in sing pass or multi-pass welding.

Welding Position

All position

Welding Instruction

Please refer to P.2-16

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.080	0.60	1.13	0.010	0.011

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation %	Charpy V-Notch	
			°C	J (kgf -m)
555(56.7)	431(44.0)	29	0	80(8.2)
			-30	69(7.1)

Size and Suggested Operating Range (DC+)

Diameter	(mm)	0.8	0.9	1.0	1.2	1.4	1.6
Amp	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	—	—	—	—