

KM-56

Classification

AWS	A5.18	ER70S-6
JIS	Z3312	YGW12
EN	14341-A	G42 3 C1 4Si1
GB	T 8110	ER50-6

Shielding Gas: CO₂

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, ship-building, steel structures, bridges and pipes with single pass or multi-pass welding.

Welding Position

All Positions

Welding Instruction

Please refer to Appendix B.

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 ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	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
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	—	—	—	—

Diam.	5kg Spool	15kg Spool
0.8mm	KM560805	KM560815
0.9mm	KM560905	KM560915
1.2mm		KM561215

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