

TALWELD S6

Copper Free

Applications and Features

- (1) KM-56Z is a non-copper coating GMAW wire and suitable for welding 490N/mm² grade steel.
- (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



Welding Instruction

Please refer to Appendix B.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.65	1.16	0.015	0.011

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation %	Charpy V-Notch	
			°C	J
548	433	29	0	130
			-30	95

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
Current (A)	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.	15 kg Spool
0.9mm	KM56CF0915
1.2mm	KM56CF1215

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