

# KM70

MILD STEEL SOLID WIRE

## Classifications:

AWS A5.18 ER70S-6  
 A5.18M ER48S-6  
 EN G3Si1  
 ISO 14341 B-49A3C G6

## Characteristics and Applications:

KM70 is a copper coated manganese-silicone wire butt and fillet MAG welding of mild and high tensile steels. Stable arc, less spatter, smooth weld bead appearance, high deposition rate and low sensitivity for porosity can be obtained. It is suitable for vehicle, bridge, construction, shipbuilding, machinery, pressure vessel, boiler and etc, as well as for the welding of plate and tube.

Welding Position:

## Typical Chemical Composition of Weld Metal:

Alloy	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
AWS	0.06-0.15	1.40-1.85	0.80-1.15	0.15	0.15	0.15	0.025	0.035	0.50
KM70	0.081	1.60	0.85	0.03	0.01	0.04	0.018	0.014	0.16

## Typical Mechanical Properties of Weld Metal:

Mechanical Property	Y.S. (MPa)	T.S. (MPa)	EI(%)	CVN(J/°C)
AWS	400	480	22	27J /-30°C
KM70	463	555	27	85J /-30°C

## Notes on Usage:

- 1.Polarity: DC+.
- 2.Shield gas: pay attention to the purity of the shield gas, pure CO2 or mixed gas can be used.
- 3.Flow rate: 20-25L/min.
- 4.Wire stick-out must be kept between 15-25mm.
- 5.Clean up the rust, wet, oil, and dust of the welding part.

## Sizes Available and Recommended Parameters:

Diameter/mm		1.0	1.2	1.6
Electric current range (Amp)	F	50-220	80-350	170-550
	OH	50-120	50-150	—
	VU	50-140	50-160	—
	VD	50-200	50-250	—