

LKM-56



LINKWELD ALLOYS INC.

AWS A5.18 ER70S-6
JIS Z3312 YGW12

Characteristics:

LKM-56 is designed for welding of mild steel and 490N/mm² grade steel. Commonly used is butt or fillet welding. It performs with smooth wire feeding, stable arc, low spatter loss and high deposition efficiency.

Applications:

It is suitable for welding of vehicles, ships, buildings and bridges

Notes on Usage:

1. Electrode Stick Out must be kept between 15-25 mm.
2. Use 100%CO₂ as shielding gas.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu
0.07	1.48	0.85	0.015	0.011	0.024	0.027	0.023	0.003	0.020

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -30 °c J
450	550	30	52

Sizes and recommended current range (DC <+>)

Diameter (mm)	0.9	1.0	1.2	1.6
Amps	50-200	80-250	30-350	170-500
Weight per spool (kg)	15	15	15/20	15/20