

# LKM-60



LINKWELD ALLOYS INC.

AWS A5.18 ER80S-G  
JIS Z3312 YGWJ18

## Characteristics:

LKM-60 is designed for welding of mild steel and 590N/mm<sup>2</sup> grade steel. Commonly used is butt or fillet welding. It can be operated with a wider range of welding currents.

## Applications:

It is suitable for welding of high strength steel used in vehicles, buildings and bridges

## Notes on Usage:

1. Electrode Stick Out must be kept between 15-25 mm.
2. Use 100%CO<sub>2</sub> as shielding gas.

## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Mo	Cu
0.07	1.52	0.67	0.015	0.011	0.20	0.10

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL %	IV -30 °c J
510	598	30	52

## Sizes and recommended current range (DC <+> )

Diameter (mm)	1.2	1.6
Amps	100-350	200-500
Weight per spool (kg)	15	15