

KC-28

Premium MIG Wire

Typical Applications:

KC-28 MIG Wire is typically used for welding low to medium strength low alloy steels.

This premium wire is suitable for high-speed automatic and manual welding in all positions with stable arc and low spatter generation. Flow quantity of shielding gas should be 15 to 20 l/min in general. For best performance use windscreen against wind and keep the distance between tip and base material within 6-15mm for 250 Amp or under or within 15-25mm for 250 Amp and over of welding current. Can be used with mixed gases.

Typical chemical composition of all weld metal (%)

Shielding Gas	C	Si	Mn	P	S
CO ₂	0.08	0.5	1.05	0.014	0.01
Ar+ 20% CO ₂	0.07	0.52	1.1	0.014	0.01

Typical mechanical properties of all weld metal

Shielding Gas	Y.P N/mm ² (kgf/mm ²)	T.S N/mm ² (kgf/mm ²)	El (%)	Charpy V-notch I.V J(kgf.m) (-29deg. C)
CO ₂	450 (46)	550 (56)	30	70 (7)
Ar+ 20% CO ₂	480(49)	580 (59)	28	80 (8)

Sizes available, packaging and recommended currents (AC or DC+)

Dia (mm)	0.6	0.8	0.9	1.0	1.2	1.6
Amp. F	40-150	40-180	50-200	70-250	100-350	200-550
Amp. V & OH	40-100	40-120	50-120	50-150	50-180	120-300
Spool (kg)	1/5/15	1/5/15	5/15	15	15	15



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