



E Bond

MILD STEEL GENERAL PURPOSE (MSGP)



General Purpose Electrode for Welding Mild Steel and Low Carbon Steels

CLASSIFICATION :	AWS A/ SFA 5.1	IS 814	APPROVALS :
	E 6013	ER 4121	BIS

KEY FEATURES :

- Superior welding characteristics
- All position electrode
- Operates at low OCV
- Ideal for mild steel and low carbon Mn steel with UTS of 430-540 MPa

WELDING POSITION :



AC (50 OCV min.)/ DCEN

TYPICAL APPLICATIONS :

- Sheet metal work
- Storage tanks
- Vehicles, Railway wagons
- Shipbuilding, Pipes
- Steel furniture
- General structural application
- Welding IS 2062 and equivalent grades upto 20 mm thick

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.08	0.35	0.25	0.02	0.02
Specification	0.10 max	0.2-0.5	0.30 max.	0.03 max.	0.03 max.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 27°C, J
Typical	As Welded	490	435	24	58
Specification		430-540	370-480	22-26	40-70

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-90	150	6	17
3.15 x 350	100-130	85	6	29
3.15 x 450	100-130	85	6	36
4.0 x 450	140-180	55	6	56
5.0 x 450	180-240	36	6	87