



E Bond M

MILD STEEL GENERAL PURPOSE (MSGP)

Mild Steel Electrode for General Purpose Fabrication

CLASSIFICATION : AWS A/ SFA 5.1

E 6013

KEY FEATURES :

- Rutile type coating
- Specially designed for general purpose fabrication application
- Superior welding characteristics
- All position electrode

WELDING POSITION :



AC (50 OCV min.)/ DCEN

TYPICAL APPLICATIONS :

- Sheet metal work
- Storage tanks
- Steel furniture
- General fabrication

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.08	0.3	0.1	0.02	0.02
Specification	0.10 max	0.2 min	0.20 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	At 0°C, J
Typical	As Welded	460	405	26	60	41
Specification		430-540	370-480	22 min	40-70	30-50

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-85	150	6	17
3.15 x 350	90-120	87	6	28
3.15 x 450	90-120	87	6	36
4.0 x 450	130-170	55	6	57
5.0 x 450	170-200	36	6	88