



Kingbond

MILD STEEL GENERAL PURPOSE (MSGP)



Mild Steel Electrode for All Position General Fabrication

CLASSIFICATION :	AWS A/ SFA 5.1	IS 814	APPROVALS :
	E 6013	ER 4211X	BIS

KEY FEATURES :

- Rutile type medium coated
- Operates at low OCV
- X-ray quality weld deposit
- Vertical down welding capability
- Suitable for major structural work

WELDING POSITION :



AC (50 OCV)/DCEN/DCEP

TYPICAL APPLICATIONS :

- General fabrication in steel plants
- Light construction work
- Shipbuilding, Pipes
- Storage tanks, Furniture work
- Automobile bodies
- Joining steel grade IS 2062, 226

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.1	0.4	0.3	0.02	0.02
Specification	0.12 max	0.25-0.55	0.12-0.35	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 0°C, J
Typical	As Welded	520	440	24	57
Specification		450-540	370-480	22-28	50 min

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	18
3.15 x 350	90-130	85	6	29
3.15 x 450	90-130	85	6	37
4.0 x 450	140-180	55	6	59
5.0 x 450	180-240	36	6	90