



# Superbond SS

MILD STEEL GENERAL PURPOSE (MSGP)

## Mild Steel Electrode for High Speed Structural Welding

CLASSIFICATION :	AWS A/ SFA 5.1	IS 814	APPROVALS :
	E 6013	ERR 4222X	ABS/DNV/BV/LRA/IBR/BIS/IRS

### KEY FEATURES :

- Rutile based heavy coated
- Touch type electrode
- X-ray quality weld deposit
- Suitable for major structural work and bridging wide root gap

WELDING POSITION : 



AC (50OCV min.)/ DCEN

### TYPICAL APPLICATIONS :

- Pressure vessels, Storage tanks
- Locomotive fireboxes, Boilers
- Railway coach panels
- Fine steel furniture
- Automobile bodies
- Joining steels like- ASTM SA 36/36M  
SA 283/283M Gr.A/B/C/D  
SA285/285M Gr.A/B/C  
SA 414/414M Gr.A/B

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.06	0.45	0.2	0.02	0.02
Specification	0.10 max	0.60 max	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 0°C, J
Typical	As Welded	515	445	25	65
Specification		460-550	370-480	23-30	50-80

### PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.0 x 300	40-60	495	4	10
2.5 x 350	60-90	244	4	20
3.15 x 450	100-140	114	4	44
4.0 x 450	140-190	73	4	68
5.0 x 450	190-250	48	4	102