



## 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 % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.08	0.35	0.25	0.02	0.02
Specification	0.2 max	1.2 max	1.0 max	-	-

#### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact at 27°C, J</b>
Typical	As Welded	490	435	24	58
Specification		430 min	330 min	17 min	40-70

#### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Approx. Pcs/Carton</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
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