



## MAGNABOND

MILD STEEL GENERAL PURPOSE (MSGP)



Mild Steel Electrode for Sheet Metal Work Application

**CLASSIFICATION : ISO 2560-A**

E38 0 R 1 1

**APPROVALS :**

ABS/BV/DNV/IRS/LRA/BHEL

### KEY FEATURES :

- Rutile type medium coated
- Quick freezing slag
- X-ray quality weld deposit
- Vertical down welding capability
- Best suited for thin plates and horizontal butt joint of storage tanks

**WELDING POSITION :**



**AC (50 OCV min.)/DCEP/DCEN**

### TYPICAL APPLICATIONS :

- Ship building, Bridges
- Pressure vessels, Pipes
- Storage tanks, Automobile bodies
- Sheet metal work
- Construction and Furniture work
- Joining steel grade ASTM SA 36/36M, SA 53/53M, SA 283/283M Gr.A/B/C/D

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

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.09	0.4	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 0°C, J</b>
Typical	As Welded	500	415	26	54
Specification		430 min	330 min	17 min	47-70

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Carton/Box</b>	<b>Net wt./Box, Kg</b>
2.5 x 350	60-100	5	4	20
3.15 x 450	85-130	5	4	20
4.0 x 450	130-190	5	4	20
5.0 x 450	150-240	5	4	20