

# METALBOND

AWS A/SFA 5.1 **E6013**

MILD STEEL GENERAL PURPOSE (MSGP)

## CLASSIFICATION:

ISO 2560-A  
E38 0 R 1 2

IS 814  
ER 4112X

## KEY FEATURES:

- Rutile type medium coated
- Operates at low OCV
- X-ray quality weld deposit
- All position welding capability
- Suitable for mild steel structural work

**APPROVALS:** ABS/BV/DNV/IRS/LRA/BIS/IBR/NTPC/BHEL/CE

## TYPICAL APPLICATIONS:

- Storage tanks, Pipes
- Machine frames
- Construction equipment
- Welding steel grade IS 2062, 226


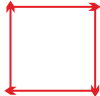
## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.09	0.4	0.25

## 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	510	430	25	55
Specification		430 min	330 min	17 min	50 min.

## PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		All Positions
2.5 x 350	60-80	 AC (50OCV min.)/ DCEN	
3.15 x 350	100-130		
3.15 x 450	100-130		
4.0 x 450	140-180		

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each.