



## SUPERBOND

MILD STEEL GENERAL PURPOSE (MSGP)



Mild Steel Electrode for General Purpose Welding

**CLASSIFICATION : ISO 2560-A**

**IS 814**

**APPROVALS :**

E38 0 R 1 1

ER 4212X

ABS/BV/DNV/IRS/LRA/IBR/BIS/NKK/MND

### KEY FEATURES :

- Rutile coated
- Suitable for general purpose structural steels
- All position operating characteristics
- X-ray quality weld deposit

### WELDING POSITION :



**AC (50 OCVmin.)/ DCEN**

### TYPICAL APPLICATIONS :

- Steel structures
- Tanks
- Truck frames and bodies
- Ships, Pipelines
- Bridges
- Joining ASTM SA 283 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	0.07	0.5	0.2	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, MPa</b>	<b>EL%</b>	<b>CVN Impact at 0°C, J</b>
Typical	As Welded	500	430	25	60
Specification		430 min	330 min	17 min	50 min

### 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	296	4	17
3.15 x 350	100-130	171	4	29
3.15 x 450	100-130	139	4	36
4.0 x 450	140-180	90	4	55
5.0 x 450	180-240	58	4	85