

SUPERBOND S

AWS A/SFA 5.1 E6013

MILD STEEL GENERAL PURPOSE (MSGP)

CLASSIFICATION:

ISO 2560-A
E38 0 R 1 2

IS 814
ER 4222X

KEY FEATURES:

- Rutile type medium coated
- Outstanding welding characteristics
- X-ray quality weld deposit
- All position capability

APPROVALS: ABS/IRS/LRA/IBR/BIS/CE

TYPICAL APPLICATIONS:

- Boiler tubes
- Storage tanks
- Railway wagons
- Shipbuilding, Bridges
- Pressure vessels
- Joining steels like - ASTM SA 36/36M, SA 283/283M Gr.A/B/C/D, SA 285/285M Gr.A/B/C, SA 414/414M Gr.A/B


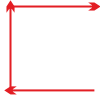
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.06	0.5	0.2

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	440	25	68
Specification		430 min	330 min	17 min	47 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
1.6 x 250	30-50	 AC (50 OCV min.)/ DCEN	All Positions Except Vertical Down: 
2.0 x 300	40-60		
2.5 x 350	60-90		
3.15 x 450	100-140		
4.0 x 450	140-190		
5.0 x 450	180-250		

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