



SUPERBOND S

MILD STEEL GENERAL PURPOSE (MSGP)



Mild Steel Electrode for Radiographic Quality Welding

CLASSIFICATION : ISO 2560-A

IS 814

APPROVALS :

E38 0 R 1 2

ER 4222X

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

KEY FEATURES :

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

WELDING POSITION :



AC (50OCV min.)/ DCEN

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.06	0.5	0.2	0.02	0.02
Specification	0.2 max	1.2 max	1.0 max	-	-

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	63
Specification		430 min	330 min	17 min.	50 min.

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
1.6 x 250	30-50	942	4	5
2.0 x 300	40-60	505	4	10
2.5 x 350	60-90	277	4	18
3.15 x 450	100-140	129	4	39
4.0 x 450	140-190	84	4	59
5.0 x 450	180-250	55	4	89