



OPTO BOND

MILD STEEL GENERAL PURPOSE (MSGP)



General Purpose Electrode for Welding Mild Steel and Low Carbon Steels

CLASSIFICATION : ISO 2560-A

EN ISO 2560-A

E35 2 RA 1 2

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KEY FEATURES :

- Low hydrogen Ilmenite coated welding electrode
- Suitable for major structural work
- Ideal for mild steel and low carbon Mn steel with UTS of 430-540 MPa

WELDING POSITION :



AC (50 OCV)/ DCEN

TYPICAL APPLICATIONS :

- Sheet metal work
- Storage tanks
- Vehicles, Railway wagons
- Shipbuilding, Pipes
- Steel furniture
- General structural application
- TWelding IS 2062 and equivalent grades upto 25 mm thick

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.08	0.60	0.25	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 -20°C, J
Typical	As Welded	490	435	30	60
Specification		430 min.	330 min.	22 min.	27 min.

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg
2.5 x 350	60-90	5	4	20
3.15 x 350	100-130	5	4	20
3.15 x 450	100-130	5	4	20
5.0 x 450	140-180	5	4	20
5.0 x 450	180-240	5	4	20