



# Metalbond

MILD STEEL GENERAL PURPOSE (MSGP)

## Mild Steel Electrode for General Purpose Structural Application

CLASSIFICATION :	AWS A/ SFA 5.1	IS 814	APPROVALS :
	E 6013	ER 4112X	ABS/BV/DNV/IRS/LRA/BIS/IBR/ NTPC/BHEL

### 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

WELDING POSITION :		AC (50OCV min.)/ DCEN
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### TYPICAL APPLICATIONS :

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

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

	C	Mn	Si	S	P
Typical	0.09	0.4	0.25	0.02	0.02
Specification	0.12 max	0.55 max	0.35 max.	0.03 max.	0.03 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	430	25	55
Specification		460-550	370-470	2-28	50 min.

### PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-80	296	4	17
3.15 x 350	100-130	177	4	28
3.15 x 450	100-130	137	4	36
4.0 x 450	140-180	91	4	54