

SUPERBOND

AWS A/SFA 5.1 E6013

MILD STEEL GENERAL PURPOSE (MSGP)

CLASSIFICATION:

ISO 2560-A
E38 0 R 1 1

IS 814
ER 4212X

KEY FEATURES:

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

APPROVALS: ABS/DNV/BV/IRS/LRA/BIS/IBP/CV/CE

TYPICAL APPLICATIONS:

- Steel structures
- Tanks
- Truck frames and bodies
- Ships, Pipelines
- Bridges
- Joining ASTM SA 283 Gr.A/B/C/D



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

| C | Mn | Si |
|-----|------|-----|
| 0.1 | 0.45 | 0.2 |

MECHANICAL PROPERTIES OF ALL WELD METAL:

| | Condition | UTS, MPa | YS, MPa | EL% | CVN Impact at 0°C, J |
|---------------|-----------|----------|---------|--------|----------------------|
| Typical | As Welded | 500 | 430 | 25 | 68 |
| Specification | | 430 min | 330 min | 17 min | 47 min |

PARAMETERS - PACKING DATA:

| Ø x L, mm | Amperage, A | | |
|------------|-------------|---|--|
| 2.5 x 350 | 60-90 |  AC (50 OCV min.) / DCEN | All Positions  |
| 3.15 x 350 | 100-130 | | |
| 3.15 x 450 | 100-130 | | |
| 4.0 x 450 | 140-180 | | |
| 5.0 x 450 | 180-240 | | |

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