



KINGBOND

MILD STEEL GENERAL PURPOSE (MSGP)

AWS A/SFA 5.1 **E6013**

CLASSIFICATION:

ISO 2560-A
E38 0 R 1 1

IS 814
ER 4211X

KEY FEATURES:

- Rutile type medium coated
- Operates at low OCV
- X-ray quality weld deposit
- Vertical down welding capability
- Suitable for major structural work

APPROVALS: BIS/RDSO/CE

TYPICAL APPLICATIONS:

- General fabrication in steel plants
- Light construction work
- Shipbuilding, Pipes
- Storage tanks, Furniture work
- Automobile bodies
- Joining steel grade IS 2062, 226



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.1	0.4	0.3

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	520	440	24	57
Specification		430 min	330 min	17 min	50 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-85	 AC (50OCV)/DCEN/DCEP	All Positions 
3.15 x 350	90-130		
3.15 x 450	90-130		
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 kg each.