



SUPERBOND SS

MILD STEEL GENERAL PURPOSE (MSGP)

AWS A/SFA 5.1 **E6013**

CLASSIFICATION:

ISO 2560-A
E38 0 RR 1 3

IS 814
ERR 4222X

KEY FEATURES:

- Rutile based heavy coated
- Touch type electrode
- X-ray quality weld deposit
- Suitable for major structural work and bridging wide root gap

APPROVALS: ABS/LRA/BIS/IRS/CE

TYPICAL APPLICATIONS:

- Pressure vessels, Storage tanks
- Locomotive fireboxes, Boilers
- Railway coach panels
- Fine steel furniture
- Automobile bodies
- Joining steels like - ASTM SA 36/36M
SA 283/283M Gr.A/B/C/D, SA285/285M
Gr.A/B/C, SA 414/414M Gr.A/B


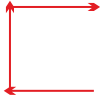
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.06	0.45	0.2

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	515	445	25	65
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 Except Vertical Down 
3.15 x 350	100-140		
3.15 x 450	100-140		
4.0 x 450	140-190		
5.0 x 450	190-250		

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