



KINGBOND S

MILD STEEL GENERAL PURPOSE (MSGP)



Mild Steel Electrode for General Purpose Structural Fabrication

CLASSIFICATION : AWS A/SFA 5.1

IS 814

APPROVALS :

E 6013

ER 4211X

BIS

KEY FEATURES :

- Rutile type coating
- Superior welding characteristics
- All position welding capability
- Radiographic weld quality

WELDING POSITION :



AC (50 OCV)/DCEN

TYPICAL APPLICATIONS :

- General purpose fabrication
- Light construction work
- Sheet metal work
- Steel furniture

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	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 0°C, J
Typical	As Welded	430 min	330 min	22 min	47 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. Pcs/Box
2.50 x 300	60-85	150	6	900
3.15 x 350	90-130	90	6	540
3.15 x 450	90-130	90	6	540
4.0 x 450	140-180	60	6	360
5.0 x 450	180-240	40	6	240