



MASTERBOND

E 6012

MILD STEEL RUTILE COATED ELECTRODES

Conforms to Standard AWS 5.1-91 E6012;
BS 639-1976 E4311 R24 & JIS D4313

**ONE ELECTRODE,
MANY USAGES**



FOR FAST AND LOW-COST WELDING

Masterbond is generally used for lightweight steel welding for grills, gates, steel furniture repairs, steel framework, constructing bus and truck bodies, and all kinds of fabrication. Plates with high levels of corrosion can also be welded.

USAGE:



Truck or Bus Body Construction



Steel Framework



Steel Furniture

KEY FEATURES OF MASTERBOND:

- Medium thickness, adequate amount of flux coating
- Less spatter, thus creates less smoke
- Perfect for welding tough-to-join cracks and fractures
- Easy striking





TYPICAL MECHANICAL PROPERTIES:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (J)	Elongation (LO=5d0) (%)
Lowest 450	510–550	(Min) 98 at room temperature	Lowest 26

TYPICAL CHEMICAL COMPOSITION OF WELDED STEEL (%)

Carbon(C)	Manganese(Mn)	Silicon(Si)	Sulphur(S)	Phosphorus (P)
0.10	0.30	0.20	0.03	0.03



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

Type of Current: AC/DC (Minimum OCV 70 Volt)

OPERATING & PACKING INFORMATION:

Dia (mm)	Length (mm)	Weight Per Package (KG)	Proposed Current Range (A)
2.50	350	3	70–90
3.20	450	5	95–125
4.00	450	5	125–175
5.00	450	5	165–260

RULES FOR STORAGE:

Keep the electrodes in a dry place. If the electrodes become wet or humid, preheat at 110 °C for 40–50 minutes before use.

WARNING:



Avoid inhaling of welding fumes and gases for health



Welding Arc rays can injure eyes & burn skin



Read and understand safety instructions & practices before use



Always weld in an open & well ventilated space with sufficient airflow



Wear protective safety gear for your eyes, ears & body



Always be careful when handling electrical equipment

 BSRM

WIRES

BSRM Wires Ltd.

Mirsharai, Chattogram

BSRM Sheba

+88 01777744099 (SMS only)

Fax: +880 31 610101

Email: mail@bsrmwires.com

Web: www.bsrmwires.com