

TOPSTAR 140

AWS A/SFA 5.1 E7024

C-Mn STEEL (High Efficiency)

CLASSIFICATION:

ISO 2560-A

E 42 0 RR 53

IS 814

E RR 5242 KX

KEY FEATURES:

- Iron powder type
- Outstanding deposition rates
- Radiographic quality weld

APPROVALS: - CE

TYPICAL APPLICATIONS:

- Heavy steel structures, Storage tanks
- Pressure vessels, Ships
- Pipelines, Bridges
- Joining ASTM SA 283 Gr.A/B/C/D, SA 414/414M Gr.C/D/E steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.07	0.6	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	550	460	27	65
Specification		490 min	400 min	17 min	50 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	 AC/DCEN	Flat butt and fillet welds only
2.5 x 350	80-120	REDRYING CONDITION: 150°C for 1 hr.	
3.15 x 450	150-170		
4.0 x 450	200-240		
5.0 x 450	250-290		

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