



TOPSTAR 140 SPL

C-Mn STEEL (High Efficiency)



Mild Steel Welding Electrode for Heavy Structural Welding

CLASSIFICATION : ISO 2560-A

E 42 2 RR 53

KEY FEATURES :

- Heavy coated iron powder type
- Very high deposition efficiency of approx. 140%
- Best suited for down hand butt & horizontal fillet welds
- Higher output & productivity

WELDING POSITION :



AC/DCEP

TYPICAL APPLICATIONS :

- Heavy structures like Cranes, Bridge girders
- Earth moving equipments
- Ship building, Pressure vessels
- Thick plates in penstock pipe lines
- Heavy machinery parts, Boilers
- Joining ASTM SA 414/414M Gr.C/D/E SA 516/516M Gr.55/60

REDRYING CONDITION : 150°C for 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.06	0.8	0.4	0.02	0.02
Specification	0.15 max	1.25 max	0.9 max	0.035 max	0.035 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -20°C, J
Typical	As Welded	565	460	26	40
Specification		490 min	400 min	22 min	27 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
3.15 x 450	150-170	5	4	20
4.0 x 450	200-240	5	4	20
5.0 x 450	250-290	5	4	20