



TOPSTAR 110

C-Mn STEEL (High Efficiency)



Welding Electrode known for its High Welding Speed

CLASSIFICATION : AWS A/SFA 5.1

IS 814

E 7014

E RR5222 JX

KEY FEATURES :

- An iron powder type
- Ideal for vertical down welding
- Radiographic quality weld

WELDING POSITION :



AC/DCEN

TYPICAL APPLICATIONS :

- Steel structures, Storage tanks
- Pressure vessels, Ships
- Pipelines, Bridges
- Joining ASTM SA 283 Gr.B/C/D steels

REDRYING CONDITION : 150°C for 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.08	0.45	0.22	0.01	0.01
Specification	0.10 max	0.65 max	0.30 max	0.03 max.	0.03 max.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 27°C, J
Typical	As Welded	560	450	25	78
Specification		510-600	415-490	22-28	60-100

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
3.15 x 450	100-140	128	4	39
4.0 x 450	150-200	81	4	62
5.0 x 450	200-250	50	4	100

