



TOPSTAR 140

C-Mn STEEL (High Efficiency)



Stick Welding Electrode for Mild Steel Structural Fabrication

CLASSIFICATION : AWS A/SFA 5.1 IS 814

E 7024 E RR 5242 KX

KEY FEATURES :

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

WELDING POSITION : **AC/DCEN**

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

REDRYING CONDITION : 150°C for 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.07	0.6	0.2	0.02	0.02
Specification	0.06-0.10	0.40-0.75	0.14-0.35	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 0°C, J
Typical	As Welded	550	460	27	65
Specification		500-600	420-500	24-28	50-100

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	80-120	192	4	26
3.15 x 450	150-170	86	4	58
4.0 x 450	200-240	56	4	89
5.0 x 450	250-290	31	4	161

