



# TOPSTAR 140 SPL

**C-Mn STEEL (High Efficiency)**



Mild Steel Welding Electrode for Heavy Structural Welding

**CLASSIFICATION : AWS A/SFA 5.1**

E 7024-1

**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 % :**

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.06	0.8	0.4	0.02	0.02
Specification	0.09max	1.25 max	0.2-0.6	0.03 max.	0.03 max.

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact at -20°C, J</b>
Typical	As Welded	565	460	26	40
Specification		500 min	400 min	17 min	27 min

**PARAMETERS - PACKING DATA :**

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Carton/Box</b>	<b>Net wt./Box, Kg.</b>
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

