



# TOPSTAR 140

C-Mn STEEL (High Efficiency)

AWS A/SFA 5.1 E7024

## 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		
2.5 x 350	80-120	 AC ( 70 OCV)/DCEN <b>REDRYING CONDITION:</b> 150°C for 1 hr.	Flat butt and fillet welds only 
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 kg each. Also available in vacuum packing