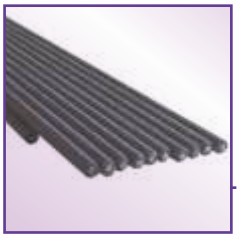

TOPSTAR

C-Mn STEEL (High Efficiency)

Stick Electrode for Mild Steel Welding

CLASSIFICATION : AWS A/SFA 5.1 IS 814

E 6020 E A4222X

KEY FEATURES :

- Medium-heavy coated
- High currents & travel speed recommended for economical welding
- Resistant to high stress & fatigue
- Best suited for flat and horizontal position
- Specially designed for mild steel welding for high strength requirement

WELDING POSITION : AC/DCEN

TYPICAL APPLICATIONS :

- Heavy structural work, machine base
- Pressure vessels, shipbuilding, truck chassis frames
- Bridges, cranes, locomotive fire boxes
- Excellent for continuous downhand or fillet welds

REDRYING CONDITION : 150-180°C for 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.08	0.5	0.2	0.02	0.02
Specification	0.06-0.10	0.40-0.65	0.11-0.29	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	490	430	27	70
Specification		460-550	370-480	24-28	50-100

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
3.15 x 450	90-140	132	4	38
4.0 x 450	140-200	78	4	64
5.0 x 450	180-220	50	4	100