



# TOPSTAR

C-Mn STEEL (High Efficiency)

AWS A/SFA 5.1 **E6020**

### CLASSIFICATION:

ISO 2560-A  
E 38 0 A 13

IS 814  
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

**APPROVALS:** - CE

### 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


### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


C	Mn	Si
0.08	0.5	0.2

### 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		430 min	330 min	22 min	50 min

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
3.15 x 450	90-140	 <b>AC (70 OCV)/DCEN</b>
4.0 x 450	140-200	
5.0 x 450	180-220	
		<b>REDRYING CONDITION:</b> 150-180°C for 1 hr..

Flat butt and fillet welds only 

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing