

TOPSTAR

CLASSIFICATIONS

AWS ASFA 5.1 E6020
IS 814 E A4222X

IDENTIFICATION: Name Printed

CHARACTERISTICS

A medium-heavy coated electrode producing fluid slag, for flat and horizontal welding. The electrode specially designed for welding mild steel where high strength and radiographic quality welds are required. The electrode produces a smooth, clean deposit with very little spatter loss. The heavy slag is porous and brittle ensuring easy removal. Use high currents and high speed of travels to get economical welding. Ideal for applications where resistance to high stress and fatigue are important.

TYPICAL APPLICATIONS

- Heavy structural work, machine base • Bridges, cranes, locomotive fire boxes • Pressure vessels, shipbuilding, truck chassis frames
- Excellent for continues down load or horizontal fillet welds.

WELD METAL CHEMISTRY, (%)

C	-	0.06-010	S	-	0.03 max
Mn	-	0.40-0.65	P	-	0.03 max
Si	-	0.11-0.29			

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L= 4xd)	CVN Impacts, J 0°C
As-welded	460-550	370-480	24-28	50-100

CURRENT CONDITIONS: AC or DC (-)

5.0	4.0	3.2
180-220	140-200	90-140

WELDING POSITIONS

F, H, Fillet

READRYING CONDITIONS

Temperature Range 150 -180 °C for 1 hour.

PACKING DATA

Dia., mm	5.0	4.0	3.2
Length, mm	450	450	450
Pcs per carton, Nos	50	78	132
Cartons / box	4	4	4
Pcs per box, Nos	200	312	528
Approx. Wt. of 1000 pcs,kg	100	64	38



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ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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