

Rutile type C-Mn steels

STARBLAZE 6013

Classification **AWS A 5.1: E 6013** **DIN EN ISO 2560-A : E 38 0 RC 11** **IS 814: ER 4211X**

Description and applications Rutile type medium coated mild steel universal electrode with versatile applications in steel construction, ship building, boiler, tank fabrication and pipeline construction. Superior weldability, very low spatter, smooth arc, fine rippled weld bead, self lifting slag, good strike and re strike. Welds are of radiographic quality.

Base materials S(P) 235 to S(P) 355; GP 240; GP 280

Typical weld metal Chemical Composition (%)

C	Mn	Si	S	P
0.08	0.40	0.30	0.030	0.030

All weld metal mechanical properties (typical)

Yield strength R_p (N/mm ²)	Tensile strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy Impact value (I S O-V J 0°C)
≥ 380	470-540	≥ 24	≥ 60

Amperes (A)

2.50 mm	3.15 mm	3.20 mm	4.00 mm	5.00 mm
60-90	90-130	90-130	140-180	180-230

Welding Instruction Re-drying generally not required. If necessary :
100-110°C for 1 hour.

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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