

Rutile type C-Mn steels

STARBLAZE PRIME 6013S

- ★ Superior weldability, finely rippled smooth weld beads.
- ★ Very soft arc, minimum spatter, radiographic quality welds.
- ★ Superior slag detachability.
- ★ Excellent impact notch toughness at 0°C.

Classification **AWS A5.1:** E 6013 **DIN EN ISO 2560-A:** E 38 0 R 12 **IS 814:** ER 4221X

Description and applications Rutile type medium coated electrode, used for the welding of large structures and process pipe work in the shipbuilding and construction industries where precise fit-ups are difficult to achieve. Starblaze Prime 6013 is a high quality electrode designed to give high impact toughness properties. The electrode formulation promotes a forceful arc to ensure sound fusion and is tolerant to variations in welding current, which are important considerations when welding under site conditions.

Base Materials **S(P)235 to S(P)355; GP240-GP280**

Typical Weld Metal Chemical Composition(%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.07 | 0.30 | 0.40 | 0.030 | 0.030 |

All weld metal Mechanical Properties (Typical)

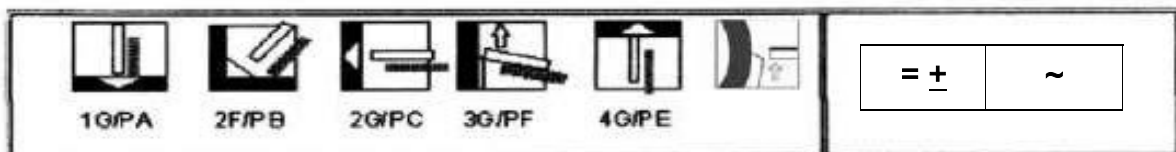
| Heat Treatment | Tensile Strength R_m (N/mm ²) | Yield Strength R_p (N/mm ²) | Elongation A_5 (%) | Charpy impact value (ISO-V J 0°C) |
|----------------|--|--|-------------------------|--------------------------------------|
| As welded | 470-540 | ≥380 | ≥24 | ≥70 |

Amperes (A)

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

Welding Instruction Keep dry and avoid condensation.
Re-drying not generally 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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Plant 3: B-100, Mayapuri Industrial Area, Phase-1, Near Police Station, New Delhi-110064

Plant 4: A-334, RIICO Industrial Area, Karoli, Bhiwadi, Rajasthan - 301707

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