

Rutile type C-Mn steels

STARBLAZE PRIME 6013SS

- ★ Ultra smooth weldability – best in class.
- ★ Very smooth fusion with excellent slag detachability.
- ★ Especially suited for thick section fillet joints.
- ★ Supports high current, extremely easy to use touch welding.

Classification **AWS A5.1:E 6013** **DIN EN ISO 2560-A: E 42 0 RR 12** **IS 814 : ERR 4222X**

Description and applications

Rutile type heavy coated multi-purpose electrode featuring outstanding welding properties. Touch type electrode, exceptional ease of operability. Suitable for high speed structural welding. Very easy arc striking and re-striking, self peeling slag, smooth and finely- rippled weld beads blending into the base metal without undercutting. Welds are of radiographic quality.

Base materials

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

Typical weld metal Chemical Composition (%)

C	Si	Mn	P	S
0.08	0.35	0.45	0.03	0.03

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	480-540	≥420	≥24	≥60

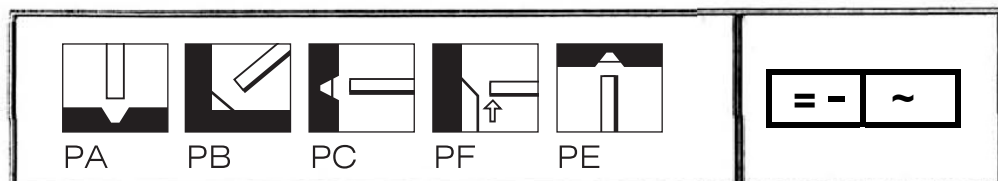
Amperes (A)

2.50mm	3.15mm	3.20mm	4.00mm	5.00mm
60-90	100-140	100-140	140-190	190-240

Welding instruction

Keep dry and avoid condensation. Re-drying generally not required.
If necessary: 100-110 °C for 30 minutes.

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

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

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