

**Hardfacing electrode resistant to Impact, compression and abrasion**

# STARBLAZE PRIME 550

**Classification**                    **DIN EN 8555: E6-UM-60P**

**Description and applications**                    Rutile type hard surfacing electrode for tough - hard, impact tough And abrasive resistant surfacing on unalloyed and low alloyed materials with higher tensile strength. Recommended For surfacing on machine parts, dredge teeth, beater bars, conveyor worms, mill hammers, mixer arms, crusher jaws,cones.....

Typical weld metal Chemical Composition (%)	C	Si	Mn	Cr	V	Mo	Fe
	0.60	0.40	0.60	7.00	0.60	0.70	Rem

All weld metal Mechanical properties (Typical)	Hardness
	57- 61 HRC

Obtained in pure weld metal

Amperes (A)	3.15mm	4.00mm	5.00mm
	90- 120	140- 180	180- 240

**Welding instruction**                    Guide electrode with a short arc. On materials sensitive to cracks use a buffer-layer of 18/8Mn type is recommended. Low alloyed, high carbon tool steels etc, have to be preheated to 200-400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

Welding Positions	=+                    (~50V)	
 <p>1G/PA                    2F/PB                    2G/PC</p>		

## Stellaris Specialities India Ltd.

(Division: StarBlaze India)

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

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