

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

# STARBLAZE PRIME 550LH

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

**Description and applications**      Basic 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, scrapers, conveyor worms, rock drills, drill bits, coal cutter blades, excavator teeth, mixer arms, crusher jaws, cones.....

**Typical weld metal Chemical Composition (%)**

C	Si	Mn	Cr	V	Mo	Fe
0.50	1.0	0.50	9.0	0.60	0.80	Rem

**All weld metal Mechanical properties (Typical)**

Hardness
58- 60 HRc




Obtained in pure weld metal

**Amperes (A)**

3.15mm	4.00mm	5.00mm
90- 120	140- 180	180- 240

**Welding instruction**      Redrying, if necessary, 2h/300°C. Guide electrode almost vertically 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**

 1G/PA	 2F/PB	 2G/PC	=+	(~70V)
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## Stellaris Specialities India Ltd.

(Division: StarBlaze India)

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

Plant 1: A-125, Okhla Industrial Area, Phase 2, New Delhi - 110020

Corporate Office & Plant 2: 552, Pace City II, Sector 37, Gurugram, Haryana - 122001

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

Tel: +91 124 4499523 | Email: sales@starblazeindia.com | Website: www.starblazeindia.com