

C-Mn and low-alloy steels

STARBLAZE PRIME 6013 M

- ★ Rutile medium coated, finely rippled smooth weld beads.
- ★ Soft arc action keeps spatter at a minimum & produces a smooth fine rippled radiographic weld bead.
- ★ Superior slag detachability.
- ★ Excellent arc striking and restriking.

Classification **AWS A5.1:** E 6013 **EN ISO 2560-A:** E 38 0 R 12

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. 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. Stable arc, fine rippled, minimum spatter and self peeling slag. Good arc striking and re-striking. Suitable for use in structural engineering, construction industries, steel structures, frames, bridges etc.

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

Typical Weld Metal Chemical Composition(%)

C	Si	Mn	P	S
0.070	0.30	0.45	0.030	0.030

All weld metal Mechanical Properties (Typical)

Heat Treatment	Yield Strength R_p (N/mm ²)	Tensile Strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy impact value (ISO-V J 0°C)
As welded	≥400	470-540	≥24	≥70

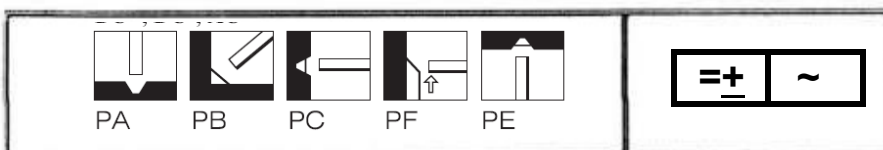
Amperes (A)

2.50mm	3.15mm	4.00mm	5.00mm
50-80	75-135	120-170	140-220

Welding instruction

Keep dry and avoid condensation.
Re-drying not generally 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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