

Rutile type C-Mn steels

STARBLAZE PRIME 6013 (MOD)

- ★ 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	≥60

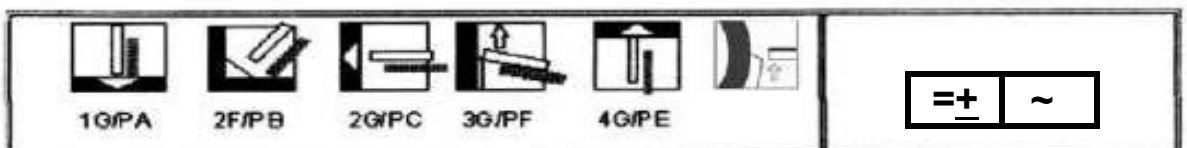
Amperes (A)

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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