

STAR 6013 ELECTRODES

Star medium coated rutile type general purpose all position mild steel electrodes

CLASSIFICATION	APPLICATION
AWS A 5.1 E 6013 IS ; 814 ;ER 4224X	Welding of highly stressed joints,steel structures,pipe lines, boilers,truck chassis and bodies,rail wagons,general weldings

WELD METAL MECHANICAL PROPERTIES

UTS	YS	ELONGATION (L=4d)%	CVN impact Value at -30°C
410 - 510 N/mm ²	330 N/mm ² Min	22 Min	50 J Min

WELD METAL CHEMICAL PROPERTIES

C	Mn	Si	S	P
0.12%	0.04 - 0.06%	0.03%	0.03%	0.03%

WELDING PARAMETERS FOR SETTING

SIZE IN MM	AMPS
2.0	40-60
2.5	60-90
3.15	100-140
4.0	140-190
5.0	180-240

CHARACTER

It has excellent running and deslagging characteristics giving smooth,bright and well ripped beads. Its operates with a smooth arc producing quality weld deposits with high deposition efficiency, low spatter and smoke,easy to weld in all position including vertical down