



AQUASTAR

E 6013

MILD STEEL RUTILE COATED ELECTRODES

Conforms to Standard AWS 5.1-91 E6013;
BS 639-1976 E433R13 & JIS D4303

**THE
MARINE
EXPERT**

HEAVY DUTY & HIGH-PERFORMANCE WELDING



Aquastar can be used in regular construction work, as well as for welding for structures and framework, sheet metal, ships and ship bodies, railway carriage framework, wagons, storage tanks and other heavy duty work. Aquastar electrodes can be used for welding in any condition and from any position.

USAGE:



Ship body construction



Railway carriage framework construction



Structure and framework

KEY FEATURES OF AQUASTAR:

- Very low spatter
- Excellent weld bead
- Slag can be easily removed from the weld bead
- Easy striking at low OCV





TYPICAL MECHANICAL PROPERTIES:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (J)	Elongation (L0=5d0) (%)
Lowest 450	510–550	(Min) 70 at –20 degree celsius	Lowest 26

TYPICAL CHEMICAL COMPOSITION OF WELDED STEEL (%)

Carbon(C)	Manganese(Mn)	Silicon(Si)	Sulphur(S)	Phosphorus (P)
0.06	0.55	0.16	0.01	0.02



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

Type of Current: AC/DC (Minimum OCV 50 Volt)

OPERATING & PACKING INFORMATION:

Dia (mm)	Length (mm)	Weight Per Package (KG)	Proposed Current Range (A)
2.50	350	3	75–100
3.20	350	4	100–125
4.00	450	5	135–175
5.00	450	5	150–280

RULES FOR STORAGE:

Keep the electrodes in a dry place. If the electrodes become wet or humid, preheat at 110°C for 40–50 minutes before use.

WARNING:



Avoid inhale of welding fumes and gases for health



Welding Arc rays can injure eyes & burn skin



Read and understand safety instructions & practices before use



Always weld in an open & well ventilated space with sufficient airflow



Wear protective safety gear for your eyes, ears & body



Always be careful when handling electrical equipment



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