

 **Starweld 60**

AC / DC +

ALLOY STEEL

Description :

High-strength low-alloy electrode with a basic coating for deposits with very low diffusible hydrogen content. Recommended for welding low alloy steels with high yield strength, low to medium carbon steels, and steels generally sensitive to cracking.

Characteristics :

- **Highly resistant to cracking**
- Excellent radiographic quality
- Excellent all-positions weldability
- Excellent machinability
- Stable arc and low spatter
- Flame-cuttable deposit

Mechanical properties :

- Polarity AC / DC +
- Charge de rupture : 110 000 psi (758 MPa)
- Elongation : up to 28 %
- Preheating is recommended for thicker parts.

Description :

Remove any trace of oil, grease and/or dirt from the surface. Remove cracks with **Starweld G12** electrode. Maintain a short arc and peen while still hot between each pass to stress relieve. Cool slowly.

+ **Diamètre**
+ **Ampérage**

2.5 mm
80 A

3.2 mm
120 A

4.0 mm
150 A

Applications :

Recommended for welding heavy equipment parts, monorails, mining equipment, steels such as T1, Corten, Scandia, CHT, SPS 245, Impacto and Hardox, as well as low alloy steels containing nickel, chromium and molybdenum.

Also available in flux-cored wire FCAW: Starweld 2060 FFG

1 800 361 9097

