

TECHNICAL DATA SHEET

 **Starweld 65**

AC / DC+

ALLOY STEEL

Description :

Unique double-coated, controlled hydrogen, electrode with low alloy core specifically suited for welding structural steels and heavy equipment parts.

Characteristics :

- Exceptional moisture resistance, resulting in crack-free deposits
- Excellent all positions weldability
- Very stable arc and low spatter
- Easy slag removal
- Superior mechanical properties, even at low temperatures

Mechanical properties :

- Polarity AC / DC +
- Tensile strength : 82 000 psi (565 MPa)
- Yield strength : 62 000 psi (427 MPa)
- Elongation : 35 – 40 %
- Impact kv at 20°C : 95 J at –20°C

Procedure :

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Starweld 512B** electrode. Maintain a short arc. Remove slag only when the glaze blackens.

Note : If necessary, anneal the electrodes in an oven at 232° to 288°C (450° to 550°F).

+ **Diameter**

+ **Amperage**

2.5 mm
60 - 90 A

3.2 mm
90 - 140 A

4.0 mm
140 - 190 A

5.0 mm
190 - 250 A

Applications :

Structural steels, cast steels, alloy steels with low content of manganese, chromium and molybdenum, truck frames, heavy equipment, farm machinery, excavation equipment. Ideal for forestry equipment and any other application outdoors and in wet environments.

Also available in FCAW flux-cored wire Starweld 2065 FFG

1 800 361 9097

 **Starweld**