



StarCore 6

GAS-SHIELDED WIRE
AWS E70C-6M H4

ProStar StarCore 6 has higher manganese and silicon levels than solid S-6 wires with slightly lower spatter and higher strength. The increased deoxidization level allows for more tolerance of mill scale, with fewer root pores. ProStar StarCore 6 is recommended for single-pass and multi-pass welding in flat and horizontal positions with 75-92% Ar/CO₂ with no detrimental effects at the higher argon levels. The wetting action is better than solid wire, minimizing cold lap on heavier sections of steel.

Product Characteristics:

- ◇ Higher deoxidizer level than solid wires to improve performance on mill scale plate
- ◇ Better wetting action than solid wire, minimizing cold lap
- ◇ Superb operator appeal
- ◇ Good choice to use for short-circuit or pulse applications

Specifications:

E70C-6M H4 per AWS A5.18, ASME SFA 5.18
CWB E491C-6M H4

Shielding Gas:

75-92% Ar/Bal CO₂, 35-50 C.F.H.

Welding Positions:

Flat and Horizontal

Standard Diameters:

.035", .045", .052", 1/16"

Typical Undiluted Weld Metal Chemistry:

Carbon (C)	0.06
Manganese (Mn)	1.64
Silicon (Si)	0.75
Phosphorus (P)	0.012
Sulphur (S)	0.019

Typical Mechanical Properties:

Tensile Strength	91,000 psi (628 MPa)
Yield Strength	81,000 psi (559 MPa)
Elongation	27%
CVN @ -20°F (-29°C)	53 ft•lbs (72J)



Premium Quality

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Diameter Electrical Stickout, Position	Voltage	Current DCEP (+) Amps	Approx. Wire Feed Speed (in/min)
.035"	26	200	550
3/8" - 5/8"	28	250	760
Flat and Horizontal	30	260	800
.045"	29	250	395
3/8" - 1/2"	31	300	520
Flat and Horizontal	34	350	650
.052"	30	300	355
3/8" - 3/4"	32	350	450
Flat and Horizontal	33	400	640
1/16"	30	275	185
3/8" - 3/4"	31	350	270
Flat and Horizontal	33	450	380

Part Numbers:

	33# Spool	44 # Spool	60# Coil	500# Drum
.035"	PRSS249408-729	--	--	--
.045"	PRSS249412-729	PRSS249412-744	PRSS249412-702	PRSS249412-713
.052"	PRSS249415-729	PRSS249415-744	PRSS249415-702	PRSS249415-713
1/16"	--	PRSS249419-744	PRSS249419-702	PRSS249419-713
3/32"	--	--	PRSS280629-702	--