



STELLAR BLUE TECHNOLOGIES

WELD BETTER

IT'S MEANT TO BE STRONG

STELIO
Innovation with Quality

ACEON[®]
WELD BETTER



Stellar Blue Technologies is a trusted manufacturer, supplying top quality welding consumables within India and overseas with an experience of more than 40 years in welding consumable business.

We have a state of art manufacturing facility located centrally at Kishangarh, Rajasthan.

We have a planned plant production capacity of 1000 MT per month spread across 36000 sq ft of area for welding wires and electrodes.

“ We trust welds strongest bonding and we owe on it. Save your from the expenditures of repairs with us. ”

We have kept our focus on quality, reliability and listening to customer voice.

For delivering quality we have best in class machines (Straight Line Wire Draw Machine, High precision MIG wet drawing machines with centralized fluid rotating systems and high speed Layer winding machines), a robust quality management system and an efficient team. We are ISO 9001:2015 certified company.

We have wide experience of dealing with export and domestic corporate clients with requirement of quality product and timely delivery/ response. We supply in various sectors including but not limited to following: Automobile, Heavy Structure Fabrication, Pre Engineered Building, Railway, Earth Moving Equipment, Mining, Handicraft, Cable Drums, Transformer and Radiators.

We have a strong distribution base as well catering to instant requirements of our customers.

We have 100% working Effluent Treatment Plant which we have made part of our manufacturing process rather than a standalone system.

With this we have insured consistent quality and no environmental damage because of our production process.

At Stellar Blue TechnoloGies we have partners who are into welding consumable business since 40 years and with technical background of Industrial engineering and quality management.



AWS A5.18/ASME SFA5.18 ER70S-6


Applications


- General fabrication
- Steel Industry
- Automotive


Features


- All position welding by short-circuiting type transfer
- Stable arc and low spatter
- Good bead appearance
- Cooper Coated Mild Steel Welding wire

Welding Position









1G

2F

3G

4G

(PA)

(PB)

(PF-PG)

(PE)

Current

DC +

Shielding Gas

100% CO₂
Ar + 20~25% CO₂

Typical Chemical Composition of the Wire(%)

C	Si	Mn	P	S
0.07	0.83	1.48	0.011	0.015

Typical Mechanical Properties of All-Weld Metal

	YS Mpa(lbs/in ²)	TS Mpa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
As welded with 100% CO ₂	460 (67,000)	555 (80,000)	29.3	-29 (-20)	85 (63)
As welded with 80% Ar + CO ₂	495 (72,000)	585 (85,000)	27.5	-29 (-20)	113 (83)
As welded with 90% Ar + CO ₂	495 (72,000)	590 (85,600)	26.4	-29 (-20)	101 (74)

Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
0.8 (0.033)	√	√	√	√	√	√
0.9 (0.035)	√	√	√	√	√	√
1.0 (0.040)	√	√	√	√	√	√
1.2 (0.045)	√	√	√	√	√	√
1.4 (0.052)	√	√	√	√	√	√
1.6 (1/16)	√	√	√	√	√	√

AWS A5.20 / ASME SFA5.20 E71T-1C
JIS Z3313 T49J 0 T1-1 C A-U H10
EN ISO 17632-A-T 42 0 P C 1

Applications

All position welding of building, shipbuilding, bridges, machinery and vehicles.

Characteristics on Usage

STELIO-71 is a titania type flux cored wire for all position welding with Co₂. Compared with solid wire, spatter loss is low, bead appearance is beautiful and arc is soft with good stability. Slag covering is uniform with good removal.





Notes on Usage

- ①

Proper preheating(50~150° C)(122~302° F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ②

One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.
- ③

Use 100% CO₂ gas

Welding Position				Current	Shielding Gas
				DC +	CO ₂
1G (PA)	2F (PB)	3G (PF.PG)	4G (PE)		

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.04	0.49	1.29	0.010	0.009

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
548 (79,600)	582 (84,500)	28	0 (32)	86 (64)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
· · F & HF	120~300	200~350	200~400
· · V-up, OH	120~260	180~280	180~280
V-down	200~300	220~320	250~300



STELLAR BLUE TECHNOLOGIES

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