

MMA Electrodes C-Mn and Low-alloy Steels

STARBLAZE PRIME 7018-G

Classification

AWS A5.5 : E7018-G

DIN EN ISO 2560-A: E 42 5 B 32 H5

Description and applications

SUPER OPTIMAL 7018-G is basic coated low hydrogen iron powder LMA type electrode producing tough and crack-free welded joints. The electrode features a stable and concentrated arc, very easy slag removal, smooth weld bead, excellent in positional welding. Welds are of X-ray quality. Welding of high tensile steels, earth moving equipments, heavy structures subject to dynamic loading and mechanical restraint.

Base materials

S(P)235 to S(P)360; GP240-GP280
SA 516 gr.60; SA 516 gr.70; SA 106 gr.B; SA333 gr1/6.

Typical Weld Metal Chemical Composition(%)

C	Mn	Si	Ni	P	S
0.06	1.20	0.30	0.50	0.020	0.015

All weld metal Mechanical Properties (Typical)

Heat Treatment	Yield Strength R_p (N/mm ²)	Tensile Strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy impact value ISO-V J -50°C
PWHT 620°C x 1h	≥400	500-600	≥24	≥50
As Welded	≥460	520-650	≥26	≥50

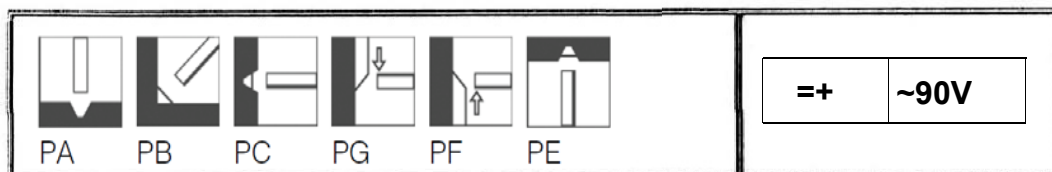
Amperes (A)

2.50mm	3.15mm	4.00mm	5.00mm
60-90	90-140	140-185	180-250

Welding instruction

Keep dry and avoid condensation,
Re-dry electrodes at 300°-350°C for 1hr.

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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Corporate Office & Plant 2: 552, Pace City II, Sector 37, Gurugram, Haryana - 122001

Plant 3: B-100, Mayapuri Industrial Area, Phase-1, Near Police Station, New Delhi-110064

Plant 4: A-334, RIICO Industrial Area, Karoli, Bhiwadi, Rajasthan - 301707

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