

C-Mn and low-alloy steels

STARBLAZE PRIME 7018S H4R

- ★ H4R grade, outstanding low moisture pick up.
- ★ Ultra smooth finely rippled weld beads.
- ★ Less than 4.0 ml /100g diffusible hydrogen level.
- ★ Excellent impact notch toughness at -50°C.
- ★ Superior reliability for the critical welding of C-Mn microalloyed & low alloy structural steels.
- ★ Recommended for critical security welding applications.
- ★ Suitable for marine and off shore applications.

Classification

AWS A5.1 : E 7018-1 H4R

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

Description and applications

Basic heavy coated, iron powder extremely low moisture pick up, low hydrogen electrode for producing tough and crack-free welded joints even on steels having a carbon content up to 0.40%. Good operating characteristics when positional welding. Weld metal has good toughness properties down to -50°C. Ultimate mechanical properties in 7018-1 group.

Base Materials

S(P)235-S(P)420; GP240-GP280; L245-L360

Typical Weld Metal Chemical Composition(%)

C	Si	Mn	P	S
0.07	0.35	1.50	0.020	0.020

All weld metal Mechanical Properties (Typical)

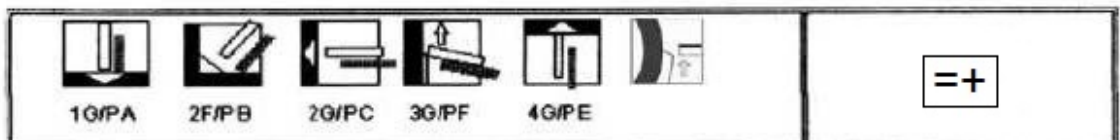
Heat Treatment	Tensile Strength R_m (N/mm ²)	Yield Strength R_p (N/mm ²)	Elongation A_5 (%)	Charpy Impact Value (ISO-V J -45°C)	Charpy Impact Value (ISO-V J -50°C)
As welded	550-640	>450	28	85	80

Amperes (A)

2.40mm	2.50mm	3.15mm	3.20mm	4.00mm	4.80mm	5.00mm
60-90	60-90	110-140	110-140	140- 190	180- 230	180-230

Welding instruction Keep dry and avoid condensation.

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

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

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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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