

C-Mn and low-alloy steels

STARBLAZE PRIME 7018S

- Ultra smooth finely rippled weld beads.
- Less than 4.0 ml diffusible hydrogen level.
- Highest impact notch toughness in class.
- Superior reliability for the critical welding of C-Mn microlloyed & low alloy structural steels.

Classifications AWS A 5.1: E 7018-1 H4 **DIN EN ISO 2560**: E 42 5 B 32 H5 **IS 814**: EB 5629H3JX

Description and applications

Basic heavy coated, electrode for producing tough and crack-free welded joints even on steels having a carbon content up to 0.40%. Weld metal recovery is approximately 115%. Good operating characteristics when positional welding. Weld metal has good toughness properties down to -50°C. Ultimate mechanical properties in 7018-1 group. Suitable for buffer layers.

Base materials

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

All weld metal mechanical properties (typical)

Heat Treatment	Tensile Strength R _m (N/mm²)	Yield Strength R _p (N/mm²)	Elongation A₅(%)	Charpy Impact value (ISO-V J -45°C)
As welded	550-620	450	30	80

Typical weld metal Chemical Composition (%)

С	Si	Mn	Р	s
0.07	0.35	1.40	0.020	0.020

Amperes (A)

2.50mm	3.15mm	3.20mm	4.00mm	5.00mm
50-90	100-140	100-140	130-180	180-230

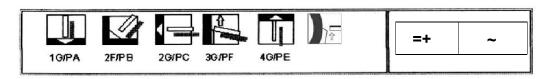
Welding Instruction

Keep dry and avoid condensation,

Revised on: 21/02/2024

HD≤5: Re-dry at 340-360°C for 2 hours, 5 times max. HD≤10: Re-dry at 300-350°C for 2 hours, 5 times max,

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

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

Plant 1: A-125, Okhla Industrial Area, Phase 2, New Delhi - 110020

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

Tel: +91 124 4499523 I Email: sales@starblazeindia.com I Website: www.starblazeindia.com

'Technical Modification Reserved'

Make Better