

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 microalloyed & low alloy structural steels.

Classifications AWS A5.1: 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/mm ²)	Yield Strength R_p (N/mm ²)	Elongation A_5 (%)	Charpy Impact value (ISO-V J -45°C)
As welded	550-620	450	30	80

Typical weld metal Chemical Composition (%)

C	Si	Mn	P	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,
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

					
1G/PA	2F/PB	2G/PC	3G/PF	4G/PE	
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(Division: StarBlaze India)

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

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