

180% Recovery

STARBLAZE PRIME 7024SS

Classification

AWS A 5.1 : E 7024

ISO 2560-A: E 42 0 RR 73

Description and Application

Rutile coated iron powder electrode with an efficiency of approx 180% . Used to produce long fillet welds and filing large weld sections. Excellent arc stability, soft fusion, fine ripples, self releasing slag, very low spatter. Applied for heavy steel structures, storage tanks, bridge girders, fabrication of earth moving equipments, pressure vessels etc. Frequently used for butt-welding plates with a heavy thickness and for fillet welds.

Base materials

Construction steels for general use , Tube steels, Ship steels

EN- Designation:	S185 – S355	L210 – L360
	P235 – P355	
Ship steels:	Quality A and B	
ASTM:	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65

Typical weld Metal Chemical Composition (%)

C	Si	Mn	S	P
0.08	0.40	1.00	0.020	0.025

All weld metal Mechanical Properties (Typical)

Yield strength $R_p(N/mm^2)$	Tensile strength $R_m(N/mm^2)$	Elongation A5 (%)	Charpy impact value ISO-V J 0°C
>420	510-610	≥24	≥60

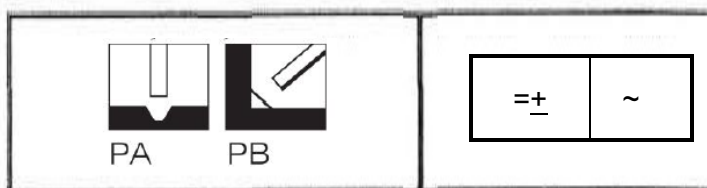
Amperes (A)

2.40mm	2.50mm	3.15mm	3.20mm	3.25mm	4.00mm	4.80mm	5.00mm
70-110	80-120	120- 150	120- 150	120- 150	150- 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

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, RIIICO Industrial Area, Karoli, Bhiwadi, Rajasthan - 301707

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