

MMA Electrodes C-Mn steels (Low Hydrogen)

STARBLAZE 6018

- Basic coated, low hydrogen
- Superior weldability, smooth weld beads.
- Less than 5.0 ml diffusible hydrogen level per 100gm weld metal.
- Excellent mechanical properties.
- Radiographic quality welds including pipe welding.

Classification

AWS A5.1 : E6018

DIN EN ISO 2560-A: E 38 3 B 32 H5

Description and applications

Basic heavy coated iron powder, hydrogen controlled MMA electrode for crack resistant, reliable welds and excellent toughness values at low temperatures on mild steels. Superior weldability, self releasing slag, low spatters, smooth bead appearance, good striking and re-striking. Ideal for structural engineering, ship buildings applications, bridges, heavy structures etc. Excellent mechanical properties in class.

Base materials

S(P) 235 to S(P) 355; GP 240; GP 280, IS 2002,2062 steels

Typical weld metal Chemical Composition (%)

C	Si	Mn	P	S
0.06	0.30	0.55	0.020	0.012

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-30°C)	Charpy Impact value (ISO-V J RT)
As welded	≥ 350	450-550	≥ 24	≥ 47	150

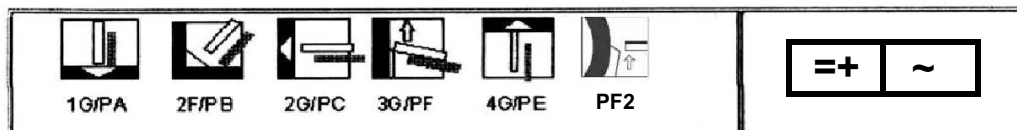
Amperes (A)

2.50 mm	3.15 mm	4.00 mm	5.00 mm
50-90	100-140	140-180	190-240

Welding Instruction

Keep dry and avoid condensation,
Re-dry electrodes at 350°C for 1-2 hrs, if necessary.

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

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

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