

C-Mn and low-alloy steels

STARBLAZE 7016

- ★ Unusually stable arc makes this ideal for root passes & positional welding.
- ★ Superior reliability for the critical welding of C-Mn microlloyed & low alloy structural steels.
- ★ Less than 4.0 ml diffusible hydrogen.
- ★ Ultra smooth finely rippled weld beads.

Classification

AWS A5.1: E 7016 - H4

DIN EN 499: E 42 4 B 12 H5

DIN EN ISO 2560-A: E 42 4 B 12 H5

Description and applications

Basic coated, low hydrogen electrode for producing tough and crack-free welded joints. Excellent for joints access making electrodes suitable for root joint welding. Weld metal has good toughness properties down to -40°C. Suitable for offshore, petrochemicals, power engineering industries and for buffer layers on carbon steels and low alloy steels before hardfacing and for M.S to cast steel joints.

Base materials

Carbon steels and low alloy steels

Typical Weld Metal Chemical Composition(%)

C	Si	Mn	P	S
0.07	0.40	1.20	0.025	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 -30°C)
As welded	520-620	≥420	30	80

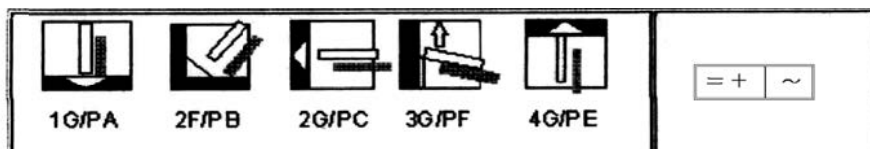
Amperes (A)

2.50 mm	3.15 /3.20 mm	4.00 mm	5.00mm
50-80	90-130	130-170	180-220

Welding instruction

Keep dry and avoid condensation. Re-drying not generally required, If necessary: 300-350°C for 2 hour, 3 times max

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

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

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Plant 4: A-334, RIICO Industrial Area, Karoli, Bhiwadi, Rajasthan - 301707

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