

C-Mn and low-alloy steels

STARBLAZE PRIME 7016

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

Classification

AWS A5.1: E 7016 - H4

EN 499: E 42 5 B 12 H5

DIN EN ISO 2560-A: E 42 5 B 12 H5

Description and applications

Basic coated, low hydrogen electrode for producing tough and crack-free welded joints. Good operating characteristics when positional welding. Excellent for joints access making electrodes suitable for root joint welding. Weld metal has good toughness properties down to -50°C. Suitable for offshore, petrochemicals and power engineering industries.

Base materials

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Typical Weld Metal Chemical Composition(%)

C	Si	Mn	P	S
0.06	0.40	1.30	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	550-620	≥420	30	100

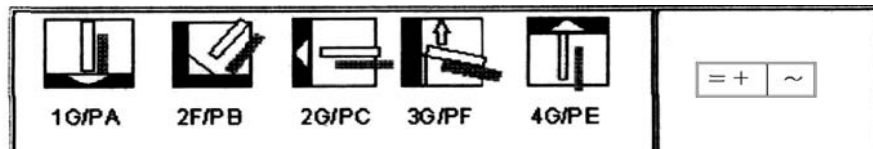
Amperes (A)

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

Welding instruction

Keep dry and avoid condensation,
HD≤5: Re-dry at 340-360°C for 1 hours, 3 times max. HD≤10:
Re-dry at 300-350°C for 2 hours, 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 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

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