

Low alloy  
high- strength steels

# STARBLAZE PRIME 14018M

**Classification** AWS A5.5 ~ E 14018-M

**Description and applications** Basic coated extra low hydrogen electrode for welding of high strength steels having yield strength more than 950N/mm<sup>2</sup>. The electrode features stable and concentrated arc, low spatters, very easy slag removal, finely rippled weld beads. Ni-Cr-Mn-Mo alloyed weld deposit is excellent crack resistant. Welds are of radiographic quality. Excellent mechanical properties and impact toughness at -50°C.

**Base Materials** Fine grain steel with YS >900 MPA.

**Typical Weld Metal Chemical Composition(%)**

C	Si	Mn	Ni	Cr	Mo	S	P
0.07	0.30	1.30	3.80	0.70	1.10	0.010	0.012

**All weld metal Mechanical Properties (Typical)**

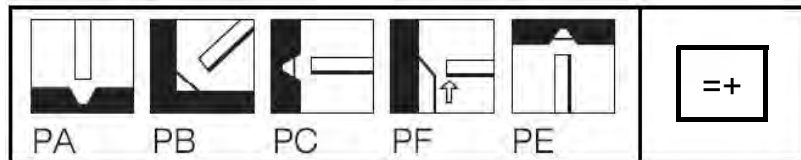
Test Condition	Yield strength R <sub>p</sub> (N/mm <sup>2</sup> )	Tensile strength R <sub>m</sub> (N/mm <sup>2</sup> )	Elongation A <sub>5</sub> (%)	Charpy impact value (ISO-V J -40°C)
As Welded	≥950	1000-1100	≥ 15	≥ 47

**Amperes (A)**

2.50mm	3.15mm	4.00mm	5.00mm
50-90	90-140	130-180	180-240

**Welding instruction** Keep dry and avoid condensation.  
Re-dry at 300 - 350°C for 1-2 hours.

**Welding positions**



## Stellaris Specialities India Ltd.

(Division: StarBlaze India)

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

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