

## MMA Electrodes C-Mn and low-alloy steels

## STARBLAZE 7018 (SPL)

- Superior weldability, ultra smooth finely rippled weld beads.
- Less than 4.0 ml diffusible hydrogen level.
- Excellent mechanical properties.
- Radiographic out of position welds including pipe welding

**Classification**      **AWS A5.1** : E7018 H4      **DIN EN ISO 2560-A**: E 42 4 B 32 H5      **IS 814**: EB 5426H3JX

**Description and applications**      Hydrogen controlled Iron powder, basic heavy coated MMA electrode for crack resistant, reliable welds and excellent toughness values at low temperatures on unalloyed and low alloyed steels. Superior weldability, self-releasing slag, very low spatters, smooth bead appearance, good striking and re-striking. Ideal for structural engineering, ship buildings applications, bridges, boilers, tanks and heavy structures. Excellent mechanical properties recommended for service temperature down to - 40° C.

**Base materials**      S(P)235-S(P)420; GP240-GP280; L245-L360

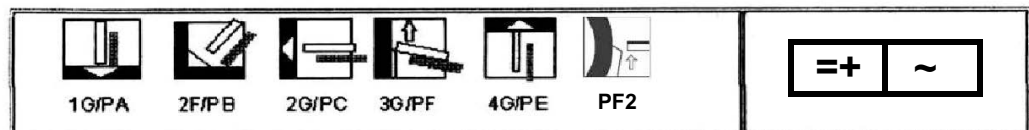
Typical weld metal Chemical Composition (%)	C	Si	Mn	P	S
	0.07	0.40	1.20	0.020	0.020

All weld metal mechanical properties (typical)	Heat Treatment	Tensile Strength $R_m$ (N/mm <sup>2</sup> )	Yield Strength $R_p$ (N/mm <sup>2</sup> )	Elongation $A_5$ (%)	Charpy Impact value (ISO-V J-30°C)
	As welded	550-620	≥ 450	≥ 28	≥ 80

Amperes (A)	2.50 mm	3.15 mm	3.20 mm	4.00 mm	5.00 mm
	50-90	100-140	100-140	130-180	180-230

**Welding Instruction**      Keep dry and avoid condensation,  
Re-dry electrodes at 350°-400°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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