

Low alloy high- strength steels

STARBLAZE PRIME 12018M

Classification **AWS A5.5 : E 12018-M** **EN ISO 18275-A : E 79 5 Z B 32 H5**

Description and applications Basic coated low hydrogen electrode for welding of high strength steels having yield strength upto 850N/mm². 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 **S 890, S(P)690**

Typical Weld Metal Chemical Composition(%)

C	Si	Mn	Ni	Cr	Mo	S	P
0.07	0.40	1.80	2.30	0.45	0.45	0.010	0.020

All weld metal Mechanical Properties (Typical)

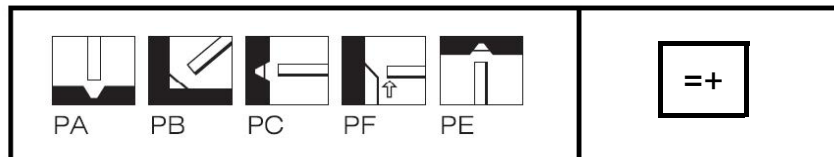
Test Condition	Yield strength R _p (N/mm ²)	Tensile strength R _m (N/mm ²)	Elongation A ₅ (%)	Charpy impact value (ISO-V J -50°C)
As Welded	745-830	≥ 880	≥ 18	≥ 47

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



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