StarBlaze®
SUPERIOR TECHNOLOGY | SUPERIOR PERFORMANCE

C-Mn and low-alloy steels

STARBLAZE PRIME 7016 A1

- ★ Ultra smooth finely rippled weld beads.
- ★ Less than 4.0 ml diffusible hydrogen.
- ★ Excellent for C - 0.50% Mo Steels.

Classification ***AWS A5.5*:** E 7016-A1 ***EN 1599*:** E Mo B 42 H5

Description and applications Basic coated, low hydrogen electrode for producing tough and crack-free welded joints. Weld deposit contains 0.50% Moly. Ideal for welding 0.50% Moly Steels, 16 Mo3 – steels. Weld metals possesses good creep strength at 525^{O}C. Good operating characteristics when positional welding. Excellent for joints access making electrodes suitable for root joint and pipe welding.

Base materials S (P) 235-S (P) 420; GP240-GP280; L245-L360
16 Mo3, G20MO5,
ASTM A 355, Gr.P1; A182M Gr.F1

Typical weld metal Chemical Composition (%)

C	Si	Mn	P	S	Mo
0.07	0.40	0.80	0.025	0.020	0.50

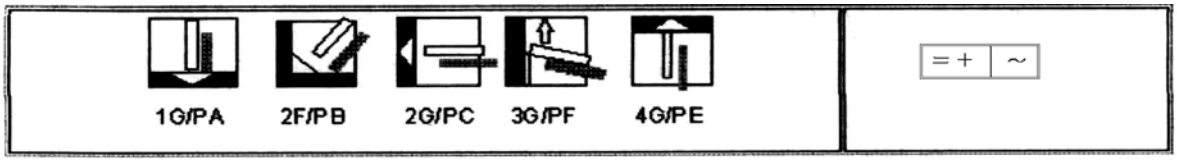
All weld metal mechanical properties (typical)

Heat Treatment	Yield Strength R_m (N/mm^2)	Tensile Strength R_m (N/mm^2)	Elongation A_5%	Impact Energy ISO-V(J)- 20°C	Hardness
As welded	450	550-620	26	70	--
PWHT 620^{O}C X 1h	≥420	510-610	≥24	≥47	--

Amperes (A)

2.50	3.15	4.00	5.00
60-80	100-130	140-170	180-220

Storage and Redrying : 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,



Stellaris Specialities India Ltd.
(Division: StarBlaze India)
GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850
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Corporate Office & Plant 2: 552, Pace City II, Sector 37, Gurugram, Haryana - 122001
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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