

STAR 7018 ELECTRODES

STAR BASIC COATED LOW HYDROGEN ELECTRODES

CLASSIFICATION	APPLICATION
AWS A 5.1 E 7018 IS ; 814 ; EB5426H33JX	Welding of steel structures, pressure vessels. Pipe joints, boilers, truck chasis and steel fabrications

WELD METAL MECHANICAL PROPERTIES

UTS	YS	ELONGATION (L=4d)%	CVN impact Value at -30°C
510-650 N/mm ²	360 N/mm ² Min	24 Min	27 J Min

WELD METAL CHEMICAL PROPERTIES

C	Mn	Si	S	P
0.10%	1.60%	0.75%	0.03%	0.03%

WELDING PARAMETERS FOR SETTING

SIZE IN MM	AMPS
2.5	60-100
3.15	100-140
4.0	190-240
5.0	190-240
6.3	240-300

CHARACTER

It's a iron powder coated with hydrogen control electrodes,its gives stable and smooth arc,self depositing slag and superb welding performance weld metal is of radiographic quality,High notch ductility at sub-zero temperature and weld metal recovery is 115 degree multi positional electrode.