SPECIAL WIRES



STAR 7018 ELECTRODESSTAR BASIC COATED LOW HYDROGEN ELECTRODES

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

WELD METAL MECHANICAL PROPERTIES

UTS	YS	ELONGATION (L=4d)%	CVN impact Value at -30°C
510-650 N/mm2	360 N/mm2 Min	24 Min	27 J Min

WELD METAL CHEMICAL PROPERTIES

С	Mn	Si	S	Р
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 deposing slag and superb welding performance weld metal is of radiographic quality, High notch ductility at sub-zero temperatore and weld metal recovery is 115 degree multi positional electrode.