STARCAST BM

TOP FEATURES

- The bi-metal core wire gives excellent welding characteristics including positional welding. Higher weld metal strength than STARCAST Ni.
- Striking, stable arc, finely-rippled bead surface.
- Weld at low heat input and with short beads, ~10 to 30 mm, and hammer peen.

CLASSIFICATION

AWS A5.15	ENiFe-CI
EN ISO 1071-A	E C NiFe-CI 1

CURRENT TYPE

AC, DC-, DC+

WELDING POSITIONS

All positions

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Ni	Cu	Fe	Al
≤1.5	≤0.8	≤0.8	bal.	≤1	45	≤0.7

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Hardness (HB)
AWS A5.15	AW	296–434	296–434	6–18	165–218
EN ISO 1071-A	AW	≥250	≥350	≥6	not specified
Typical values	AW	≥300	400-580	≥6	165-200

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	50-70
3.2 x 350	80-110

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	125	2.0	W100383718
3.2 x 350	VPMD	83	2.6	W100258784

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.