



BLUESHIELD™ LA 10018-D2

Low Alloy Steel Electrode

STANDARDS

CSA W48-01-M/W48-06, Class E6918-D2
AWS A5.5, Class E10018-D2

DESCRIPTION & APPLICATIONS

It is a basic low hydrogen type covered electrode containing additions of manganese and molybdenum in the covering. Used for welding low alloy high tensile strength.

- Repair of manganese-moly castings and fabrication of armor plates.

THE **BLUESHIELD™** ADVANTAGE

- Smooth stable arc
- Ease of use
- Easy slag removal

TYPICAL WELDING PARAMETERS



- As with all basic type electrodes, as short an arc as possible should be maintained using either direct current electrode positive (DCEP) or alternating current.
- Stringer beads are preferred to weaving.
- Attention must be paid at the beginning of a bead to obtain full coverage with slag in order to prevent porosity.
- Preheating is governed by the hardenability and/or thickness of the steel being welded

Diameter		Amperage Range	Optimum Current
mm	in		
2.5	3/32	75 – 115	100
3.2	1/8	90 – 160	130
4.0	5/32	130 – 220	175
5.0	3/16	160 – 315	250

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Fe	V	Cu	Ti
0.08	0.07	0.07	0.30	0.017	0.010	2.00	0.46	–	–	–	–	–

TYPICAL MECHANICAL PROPERTIES

	As Welded	
Tensile Strength	708 MPa	103 ksi
Yield Strength	645 MPa	94 ksi
Elongation in 40 mm – 1.5 in	26 %	26 %
Impact (Charpy V-notch) Test Temperature Energy	-50°C 60 J	-58°F 44 ft-lb

PACKAGING

Diameter		Length		Packaging		Item Number
mm	in	mm	in	kg	lb	
2.5	3/32	300	12	4 x 2.5	4 x 5.5	BLU-32977006
3.2	1/8	350	14	4 x 5	4 x 11	BLU-32977008
4.0	5/32	350	14	4 x 5	4 x 11	BLU-32977010
5.0	3/16	350	14	4 x 5	4 x 11	BLU-32977012