

# BLUESHIELD™ LA 24-HD

## Mild Steel Electrode

### STANDARDS

CSA W48-01-M/W48-06, Class E4924  
AWS A5.1, Class E7024

### DESCRIPTION & APPLICATIONS

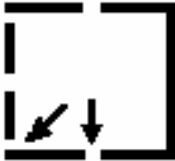
This highly efficient electrode with a heavy rutile covering containing more than 50% iron powder. This high content of iron powder allows optimum currents that are higher than most mild steel electrodes.

- Welding ornamental iron, structural steel, low and medium carbon steel.
- Requiring high deposit rate; example fillet welding.

### THE *BLUESHIELD*™ ADVANTAGE

- Exceptional stretchability and mileage.
- Higher deposition rates.
- Slag is easily removed (self-peeling).
- It produces a smooth weld and maintains a stable arc.

### TYPICAL WELDING PARAMETERS



- Flat position.
- Is designed to be used with AC or DC current, electrode negative preferred.
- A drag technique is preferred to an open arc technique.
- Increase in iron powder limits use in the incline position.

Diameter		Amperage Range	Optimum Current
mm	in		
4.0	5/32	175 – 250	230
5.0	3/16	225 – 350	285

### TYPICAL CHEMISTRY

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Ta	V	Cu	Ti
0.05	0.04	0.05	0.023	0.013	0.015	0.68	0.53	–	–	–	–	–

### TYPICAL MECHANICAL PROPERTIES

	As Welded	
	Tensile Strength	533 MPa
Yield Strength	449 MPa	65 ksi
Elongation in 40 mm – 1.5 in	22 %	22 %

### PACKAGING

Diameter		Length		Packaging		Item Number
mm	in	mm	in	kg	lb	
4.0	5/32	450	18	4 x 4.5	4 x 10	BLU-30972420
5.0	3/16	450	18	4 x 4.5	4 x 10	BLU-30972422