

BLUESHIELD LA 6010

Mild Steel Electrode

STANDARDS

CSA W48-01-M/W48-06, Class E4918-1-H4
 AWS A5.1, Class E7018-1

DESCRIPTION & APPLICATIONS

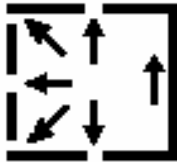
This is all position electrode used for producing very high quality welds. It has a cellulosic covering which produces a forceful, deep penetrating arc and a thin friable easily removed slag. *BLUESHIELD*™ LA 6010 yields welds that possess excellent mechanical properties. As it can be used in all positions, it finds wide usage in structural work, pressure vessels, ship-building and pipeline welding and is sometimes used on galvanized steel.

- It is ideally suited for root/hot pass welding pipe.
- Also suitable for maintenance work on dirty or rusty material.

THE *BLUESHIELD*™ ADVANTAGE

- Maintains a forceful deep penetrating arc throughout the entire length of electrode.
- Weld puddle easily controlled. - Excellent strike and re-strike.
- Stable arc characteristics combined with good wetting action and fast freezing weld puddle.

TYPICAL WELDING PARAMETERS



- Use direct current electrode positive.
- Maintain a short to medium arc length.
- Use a slight whipping motion to control bead sag on out-of-position welds.
- Stringer, bead, or weave technique can also be used.
- To maximize the penetration, use a short arc length with the electrode inclined 20° in the direction of travel.

Diameter		Amperage Range	Optimum Current
mm	in		
2.5	3/32	50 – 85	75
3.2	1/8	80 – 140	115
4.0	5/32	110 – 170	140

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Ta	V	Cu	Ti
0.16	0.06	0.08	0.01	-	-	0.45	0.18	-	-	0.01	-	-

TYPICAL MECHANICAL PROPERTIES

	As Welded	
Tensile Strength	574 MPa	74.5 ksi
Yield Strength	424 MPa	61.5 ksi
Elongation in 40 mm – 1.5 in	25.2 %	25.2 %
Impact (Charpy V-notch) Test Temperature Energy	-30°C 49 J	-20°F 37 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-30971106
3.2	1/8	350	14	4 x 5	4 x 11	BLU-30971108
4.0	5/32	350	14	4 x 5	4 x 11	BLU-30971110