

# BLUESHIELD™ LA ULTRA™ 11

## Mild Steel Electrode

### STANDARDS

CSA W48-01-M/W48-06, Class E4311.  
AWS A5.1, Class E6011.

### DESCRIPTION & APPLICATIONS

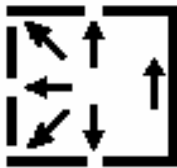
It is a good mild steel, general purpose, all-position cellulosic-type covered electrode. Cellulose in the coating produces an exceptionally stable, forceful penetrating arc. This electrode is ideally suited for maintenance work where dirty or rusty materials are often found. It is also used where LA 6010 is required, but where only AC current is available.

- Typically include shipyards, general metal fabrication, farm equipment, sheet metal, and repair.

### THE **BLUESHIELD™** ADVANTAGE

- Versatility lends itself well to a variety of user skill levels and applications.
- Flexibility can be used with limited input AC/DC type welding power sources.
- Aggressive arc action allows this electrode to perform extremely well under harsh environments.
- Its ability to be used on AC current makes it handy in reducing the effects of magnetic arc blow.
- Yields maximum travel speeds on sheet metal applications.

### TYPICAL WELDING PARAMETERS



- Either AC or DC electrode positive can be used.
- A stringer or weave type welding technique may be used.
- Overhead fillet welds are generally made using stringer beads.
- Maintain a short-to-medium arc length.

Diameter		Amperage Range	Optimum Current
mm	in		
2.5	3/32	50 – 85	70
3.2	1/8	80 – 130	115
4.0	5/32	110 – 160	140
5.0	3/16	130 – 190	180
6.0	1/4	200 – 300	225

### TYPICAL CHEMISTRY

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Ta	V	Cu	Ti
0.14	0.03	0.03	0.01	-	-	0.59	0.28	-	-	0.01	-	-

### TYPICAL MECHANICAL PROPERTIES

	As Welded	
	MPa	ksi
<b>Tensile Strength</b>	548 MPa	79.5 ksi
<b>Yield Strength</b>	462 MPa	67 ksi
<b>Elongation in 40 mm – 1.5 in</b>	30 %	30 %
<b>Impact: (Charpy V-notch) Test Temperature Energy</b>	-30°C 59 J	-20°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-30970106
3.2	1/8	350	14	4 x 5	4 x 11	BLU-30970108
4.0	5/32	350	14	4 x 5	4 x 11	BLU-30970110
5.0	3/16	350	14	4 x 5	4 x 11	BLU-30970112
6.0	1/4	450	18	4 x 5	4 x 11	BLU-30970116