

BLUESHIELD LA 6013

Mild Steel Electrode

STANDARDS

CSA W48-01-M/W48-06, Class E4313
AWS A5.1, Class E6013

DESCRIPTION & APPLICATIONS

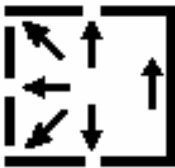
It is an extremely versatile, user friendly, general purpose, all-position rutile-type covered electrode. The fast freeze slag characteristic makes this electrode ideally suited for welding sheet metal out of position (vertical down).

- Include light metal fabrication, farm equipment, repair and the home hobbyist

THE **BLUESHIELD**™ ADVANTAGE

- All position.
- Fast freezing slag easily removed.
- Very good operator appeal, soft smooth arc.
- Can be used with either AC or DC current on a wide variety of power sources.

TYPICAL WELDING PARAMETERS



- Either AC or DC can be used, DC electrode negative preferred.
- A stringer or weave type welding technique may be used.
- Overhead fillet welds are generally made using stringer beads.

Diameter		Amperage Range	Optimum Current
mm	in		
2.5	3/32	50 – 85	70
3.2	1/8	75 – 130	115
4.0	5/32	110 – 170	150
5.0	3/16	150 – 250	210

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	P	S	Mn	Si	V	Al	Cu
0.09	0.03	0.03	0.01	-	-	0.31	0.37	0.01	-	-

TYPICAL MECHANICAL PROPERTIES

	As Welded	
Tensile Strength	504 MPa	73.1 ksi
Yield Strength	436 MPa	63.2 ksi
Elongation in 40 mm – 1.5 in	29 %	29 %

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-30971306
3.2	1/8	350	14	4 x 5	4 x 11	BLU-30971308
4.0	5/32	350	14	4 x 5	4 x 11	BLU-30971310
5.0	3/16	350	14	4 x 5	4 x 11	BLU-30971312