



BLUESHIELD™ LA 7018 RCR

Low-Hydrogen Electrode

STANDARDS

CSA W48-01-M/W48-06, Class E4918-G-H8
 AWS A5.5, Class E7018-G-H8

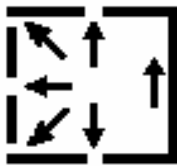
DESCRIPTION & APPLICATIONS

BLUESHIELD™ LA 7018 RCR is a basic low hydrogen-welding electrode developed for the repair and fabrication of ocean going vessels. It is also well suited for the overlay and weld repair of carbon steel batch digester's in the pulp and paper industry. The weld deposit chemistry is such that it resists corrosion in these type of environments.

THE BLUESHIELD™ ADVANTAGE

- Low hydrogen weld deposit
- Improved corrosion resistance for minimizing the risk of underbead cracking
- Stable arc
- Slag removal easily
- Bead contour is slightly convex with good side wall fusion

TYPICAL WELDING PARAMETERS



- All position.
- May be used with alternating current or direct current electrode positive (DCEP).
- Maintain a short arc to prevent the introduction of atmospheric gases into the weld puddle.
- In all positions, use a straightforward progression, weaving no more than 2 1/2 electrode diameters.
- Use on dry base metal.

Diameter		Amperage Range	Optimum Current
mm	in		
3.2	1/8	100 – 160	130
4.0	5/32	135 – 220	175

TYPICAL CHEMISTRY

C	Mn	Si	Ni	Cu	S	P
0.05	0.85	0.25	0.60	0.60	0.010	0.010

TYPICAL MECHANICAL PROPERTIES

	As Welded	
Tensile Strength	530 MPa	77 ksi
Yield Strength	480 MPa	70 ksi
Elongation in 40 mm – 1.5 in	25 %	25 %
Impact (Charpy V-notch) Test Temperature Energy	-20°C 100 J	-0°F 74 ft-lb

PACKAGING

Diameter		Length		Packaging		Stock Number
mm	in	mm	in	kg	lb	
3.2	1/8	350	14	4 x 5	4 x11	BLU-32971408
4.0	5/32	350	14	4 x 5	4 x11	BLU-32971410