



BLUESHIELD™ LA 7024

Mild Steel Electrode

STANDARDS

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

DESCRIPTION & APPLICATIONS

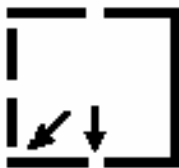
It is heavily-coated rutile-type mild steel electrode for flat position welding. This electrode is ideally suited for high-speed fillet weld applications. It is also used where high deposition rates are required but concern for weld metal toughness is not critical.

- Typically include light metal fabrication, farm equipment, repair, and the home hobbyist.

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.
- Very good operator appeal, soft smooth arc, minimal spatter with good slag removal.
- Can be used with either AC or DC current on a wide variety of power sources.

TYPICAL WELDING PARAMETERS



- Either AC or DC electrode negative current can be used.
- A stringer or weave type welding technique may be used.
- Optimum operating characteristics are achieved with a short arc length.

Diameter		Amperage Range	Optimum Current
mm	in		
2.5	3/32	90 – 135	105
3.2	1/8	140 – 180	170
4.0	5/32	175 – 240	220
5.0	3/16	215 – 300	270
6.0	1/4	290 – 400	325

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	P	S	Mn	Si	V	Mn + Ni + Cr + Mo + V
0.07	0.04	0.03	0.01	0.012	0.01	0.67	0.35	0.01	0.76

TYPICAL MECHANICAL PROPERTIES

	Stress Relieved 1h @ 620°C (1148°F)	
Tensile Strength	514 MPa	74.5 ksi
Yield Strength	447 MPa	64.8 ksi
Elongation in 40 mm – 1.5 in	23.1 %	23.1 %

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-30972406
3.2	1/8	350	14	4 x 5	4 x 11	BLU-30972408
4.0	5/32	350	14	4 x 5	4 x 11	BLU-30972410
4.0	5/32	450	18	4 x 4.5	4 x 10	BLU-30972411
5.0	3/16	450	18	4 x 4.5	4 x 10	BLU-30972412
6.0	1/4	450	18	4 x 4.5	4 x 10	BLU-30972416