



# BLUESHIELD™ LA 8018-B2

## Low Alloy Steel Electrode

### STANDARDS

CSA W48-01-M/W48-06, Class E5518-B2  
AWS A5.5, Class E8018-B2

### DESCRIPTION & APPLICATIONS

- It is a basic low hydrogen type covered electrode with chromium and molybdenum added in the covering for welding ½ Cr - ½ Mo, 1 Cr - ½ Mo, 1¼ Cr - ½ Mo steels.
- Pressure piping and boiler work
- ASTM A, 387, P11, P12 materials

### THE **BLUESHIELD**™ ADVANTAGE

- Smooth stable arc
- Easy slag removal
- User friendly
- Low hydrogen weld deposit

### TYPICAL WELDING PARAMETERS



- As with all basic type electrodes, as short an arc as possible should be maintained using either direct current electrode positive (DCEP) or alternating current.
- Stringer beads are preferred to weaving.
- Attention must be paid at the beginning of a bead to obtain full coverage with slag in order to prevent porosity.
- Preheating is governed by the hardenability and/or thickness of the steel being welded.

Diameter		Amperage Range	Optimum Current
mm	in		
2.5	3/32	75 – 115	100
3.2	1/8	90 – 160	130
4.0	5/32	130 – 220	175
5.0	3/16	160 – 315	250

### TYPICAL CHEMISTRY

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Fe	V	Cu	Ti
0.07	1.42	–	0.50	0.009	0.014	0.78	0.65	–	–	–	–	–

### TYPICAL MECHANICAL PROPERTIES

	As Welded	
Tensile Strength	580 MPa	84 ksi
Yield Strength	480 MPa	70 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-32975006
3.2	1/8	350	14	4 x 5	4 x 11	BLU-32975008
4.0	5/32	350	14	4 x 5	4 x 11	BLU-32975010
5.0	3/16	350	14	4 x 5	4 x 11	BLU-32975012