



BLUESHIELD™ LA 8018-C1

Low Alloy Steel Electrode

STANDARDS

CSA W48-01-M/W48-06, Class E5518-C1
AWS A5.5, Class E8018-C1

DESCRIPTION & APPLICATIONS

It is a basic low hydrogen type covered electrode which yields a weld deposit containing a nominal 2½ % nickel content or in application which require good low temperature impact resistance. Used in the welding of nickel bearing steels where low temperature toughness of the weld deposit is important.

- Offshore welding, highstrength steels

THE *BLUESHIELD*™ ADVANTAGE

- Low temperature toughness of the weld deposit
- Smooth stable arc
- Easy slag removal
- User friendly

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.

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	Cu	Ti	Fe	Al
0.05	–	2.44	–	0.01	0.01	1.14	0.41	–	–	–	–

TYPICAL MECHANICAL PROPERTIES

	Stress Relieved 1h @ 620°C (1148°F)	
Tensile Strength	590 MPa	86 ksi
Yield Strength	505 MPa	73 ksi
Elongation in 40 mm – 1.5 in	28 %	28 %
Impact (Charpy V-notch) Test Temperature Energy	-60 °C 75 J	-75 °F 55 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-32973906
3.2	1/8	350	14	4 x 5	4 x 11	BLU-32973908
4.0	5/32	350	14	4 x 5	4 x 11	BLU-32973910
5.0	3/16	350	14	4 x 5	4 x 11	BLU-32973912