



BLUESHIELD™ LA 8018-C2

Low Alloy Steel Electrode

STANDARDS

CSA W48-01-M/W48-06, Class E5518-C2
AWS A5.5, Class E8018-C2

DESCRIPTION & APPLICATIONS

It is a basic low hydrogen type covered electrode with nickel added in the covering. It is recommended for welding of the 2 to 4 % nickel steels or steels designed for low temperature service environments.

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	Ta	V	Cu	Ti
0.05	0.05	3.38	0.02	0.009	0.014	1.12	0.37	–	–	–	–	–

TYPICAL MECHANICAL PROPERTIES

	Stress Relieved 1h @ 620°C (1148°F)	
Tensile Strength	590 MPa	86 ksi
Yield Strength	530 MPa	77 ksi
Elongation in 40 mm – 1.5 in	32 %	32 %
Impact (Charpy V-notch) Test Temperature Energy	-75°C 28 J	-100°F 21 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-32974006
3.2	1/8	350	14	4 x 5	4 x 11	BLU-32974008
4.0	5/32	350	14	4 x 5	4 x 11	BLU-32974010
5.0	3/16	350	14	4 x 5	4 x 11	BLU-32974012