



# BLUESHIELD™ LA 8018-C3

## Low Alloy Steel Electrode

### STANDARDS

CSA W48-01-M/W48-06, Class E5518-C3  
AWS A5.5, Class E8018-C3

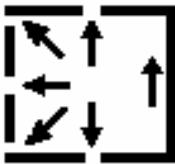
### DESCRIPTION & APPLICATIONS

It is a basic type low hydrogen covered electrode with nickel added in the covering. This electrode is used to weld high tensile strength steels in the 483 MPa (70 ksi) to 552 MPa (80 ksi) range, especially where notch toughness is required to temperature as low as -40°C (-40°F).

### 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
6.0	1/4	280 – 380	310

### TYPICAL CHEMISTRY

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Ta	V	Cu	Ti
0.05	0.03	0.96	0.017	0.01	0.01	0.72	0.30	–	–	–	–	–

### TYPICAL MECHANICAL PROPERTIES

	As Welded	
<b>Tensile Strength</b>	590 MPa	86 ksi
<b>Yield Strength</b>	500 MPa	73 ksi
<b>Elongation in 40 mm – 1.5 in</b>	30 %	30 %
<b>Impact (Charpy V-notch) Test Temperature Energy</b>	-40°C 100 J	-40°F 74 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-32973806
3.2	1/8	350	14	4 x 5	4 x 11	BLU-32973808
4.0	5/32	350	14	4 x 5	4 x 11	BLU-32973810
5.0	3/16	350	14	4 x 5	4 x 11	BLU-32973812
6.0	1/4	450	18	4 x 5	4 x 11	BLU-32973816