



BLUESHIELD™ LA 8018-W

Low Alloy Steel Electrode

STANDARDS

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

DESCRIPTION & APPLICATIONS

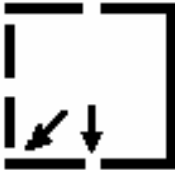
It is a heavily coated basic low hydrogen electrode containing a high percentage of iron powder in the covering. It is designed specifically for high speed flat and horizontal fillet welding. It is used primarily on heavy weldments of mild, low alloy or hard to weld steels. Speed and deposition rate are higher than those attained with E4919/E7018 electrodes. Fillet welds are equal-legged, concave, with no sag or undercut. The spatter is negligible and slag is self-peeling in most applications. It is used where a low hydrogen weld deposit required coupled with high deposition rates.

- Typical uses are production welding, shipbuilding and structural steel fabrication.

THE BLUESHIELD™ ADVANTAGE

- Higher deposition rates.
- Very easy slag removal.
- Excellent bead appearance.
- Minimal spatter.

TYPICAL WELDING PARAMETERS



- Flat and horizontal positions.
- Used on either AC or DC current, electrode positive.
- In order to reduce the possibility of starting porosity, strike the electrode ahead of the crater of the previously finished weld bead and quickly move back into the crater while shortening the arc length.
- Maintain as short an arc as possible.

Diameter		Amperage Range	Optimum Current
mm	in		
3.2	1/8	110 – 160	130
4.0	5/32	150 – 220	175
5.0	3/16	225 – 305	250

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Ta	V	Cu	Ti
0.06	0.63	0.75	0.02	0.016	0.009	1.07	0.43	–	–	0.02	0.54	0.02

TYPICAL MECHANICAL PROPERTIES

	As Welded	
Tensile Strength	580 MPa	84 ksi
Yield Strength	500 MPa	73 ksi
Elongation in 40 mm – 1.5 in	26 %	26 %
Impact (Charpy V-notch) Test Temperature Energy	-20°C 92 J	-0°F 68 ft-lb

PACKAGING

Diameter		Length		Packaging		Item Number
mm	in	mm	in	kg	lb	
3.2	1/8	350	14	4 x 5	4 x 11	BLU-32975208
4.0	5/32	350	14	4 x 5	4 x 11	BLU-32975210
5.0	3/16	350	14	4 x 5	4 x 11	BLU-32975212