BLUESHIELD™ LA 9018-B3

Low Alloy Steel Electrode

STANDARDS

CSA W48-01-M/W48-06, Class E6218-B3
AWS A5.5, Class E9018-B3

DESCRIPTION & APPLICATIONS

It is a basic low hydrogen type covered electrode with addition of chromium and molybdenum in the covering for welding 2¼ Cr - ½ Mo class of steels.

- Oil or gas sector, pressure vessel, boiler works

THE *BLUESHIELD*™ ADVANTAGE

- 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.
- 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	2.32	–	1.02	0.014	0.015	0.76	0.64	–	–	–	–	–

TYPICAL MECHANICAL PROPERTIES

	Stress Relieved 1h @ 690°C (1274°F)	
Tensile Strength	675 MPa	98 ksi
Yield Strength	605 MPa	88 ksi
Elongation in 40 mm – 1.5 in	23 %	23 %

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-32976006
3.2	1/8	350	14	4 x 5	4 x 11	BLU-32976008
4.0	5/32	350	14	4 x 5	4 x 11	BLU-32976010
5.0	3/16	350	14	4 x 5	4 x 11	BLU-32976012

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