



# BLUESHIELD™ LA 9018-M

## Low Alloy Steel Electrode

### STANDARDS

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

### DESCRIPTION & APPLICATIONS

- It is a basic low hydrogen type covered electrode with nickel and molybdenum added in the covering for welding high tensile quenched and tempered steels.

### THE *BLUESHIELD*™ ADVANTAGE

- Smooth stable arc
- Good 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		
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
0.05	0.06	1.64	0.24	0.016	0.010	1.13	0.27	–	–	–	–	–

### TYPICAL MECHANICAL PROPERTIES

	As Welded	
	<b>Tensile Strength</b>	663 MPa
<b>Yield Strength</b>	580 MPa	84 ksi
<b>Elongation in 40 mm – 1.5 in</b>	27 %	27 %
<b>Impact (Charpy V-notch) Test Temperature Energy</b>	-50°C 75 J	-58°F 55 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-32975508
4.0	5/32	350	14	4 x 5	4 x 11	BLU-32975510
5.0	3/16	350	14	4 x 5	4 x 11	BLU-32975512