BLUESHIELD™ LA 11018-M

Low Alloy Steel Electrode

STANDARDS

CSA W48-01-M/W48-06, Class E7618-M
AWS A5.5, Class E11018-M

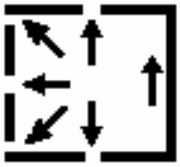
DESCRIPTION & APPLICATIONS

It is a high strength low alloy basic (low hydrogen) type covered electrode with manganese, chromium, nickel and molybdenum added in the covering. Weld metal equals or exceeds the 760 MPa (110 ksi) tensile strength of steels such as T-1 and others in the category of quenched and tempered steels.

THE *BLUESHIELD*™ ADVANTAGE

- Excellent low temperature impact properties
- 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		
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	Fe	V	Cu	Ti
0.07	0.23	1.74	0.36	0.020	0.011	1.71	0.40	–	–	0.01	–	–

TYPICAL MECHANICAL PROPERTIES

	As Welded	
Tensile Strength	790 MPa	115 ksi
Yield Strength	710 MPa	103 ksi
Elongation in 40 mm – 1.5 in	22 %	22 %
Impact (Charpy V-notch) **Test Temperature** **Energy**	 -50°C 74 J	 -58°F 54 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-32971006
3.2	1/8	350	14	4 x 5	4 x 11	BLU-32971008
4.0	5/32	350	14	4 x 5	4 x 11	BLU-32971010
5.0	3/16	350	14	4 x 5	4 x 11	BLU-32971012
6.0	1/4	450	18	4 x 5	4 x 11	BLU-32971016

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