## Blueshield Low-Alloy Electrodes

| NAME | AWS CLASS | CSA/CWB CLASS | POSITION | TYPE | APPLICATION | DIAMETER mm | DIAMETER in | PACKAGING kg | PACKAGING lb | ITEM NUMBER |
|---|---|---|---|---|---|---|---|---|---|---|
| **LA 7018-A1** | E7018-A1 | E4918-A1 | All | Basic DC+/AC | 1/2% molybdenum electrodes. Boilers and pressure vessel work, low-alloy with stress relief requirement. | 2.5 | 3/32 | 4 x 2.5 | 5.5 | **BLU-32973006** |
| | | | | | | 3.2<br>4.0<br>5.0 | 1/8<br>5/32<br>3/16 | 4 x 5 | 11 | **BLU-32973008**<br>**BLU-32973010**<br>**BLU-32973012** |
| **LA 8018-C1** | E8018-C1 | E5518-C1 | All | Basic DC+/AC | 2 1/4% nickel electrodes. Weld metal toughness down to -60ºC (-76ºF). | 2.5 | 3/32 | 4 x 2.5 | 5.5 | **BLU-32973906** |
| | | | | | | 3.2<br>4.0<br>5.0 | 1/8<br>5/32<br>3/16 | 4 x 5 | 11 | **BLU-32973908**<br>**BLU-32973910**<br>**BLU-32973912** |
| **LA 8018-C2** | E8018-C2 | E5518-C2 | All | Basic DC+/AC | 3% nickel electrodes. Weld metal toughness down to -75ºC (-103ºF). | 2.5 | 3/32 | 4 x 2.5 | 5.5 | **BLU-32974006** |
| | | | | | | 3.2<br>4.0<br>5.0 | 1/8<br>5/32<br>3/16 | 4 x 5 | 11 | **BLU-32974008**<br>**BLU-32974010**<br>**BLU-32974012** |
| **LA 8018-C3** | E8018-C3 | E5518-C3 | All | Basic DC+/AC | 1% nickel electrodes. Weld metal toughness down to -40ºC (-40ºF). | 2.5 | 3/32 | 4 x 2.5 | 5.5 | **BLU-32973806** |
| | | | | | | 3.2<br>4.0<br>5.0<br>6.0 | 1/8<br>5/32<br>3/16<br>1/4 | 4 x 5 | 11 | **BLU-32973808**<br>**BLU-32973810**<br>**BLU-32973812**<br>**BLU-32973816** |
| **LA 8018-B2** | E8018-B2 | E5518-B2 | All | Basic DC+/AC | 1 1/4Cr-1/2Mo electrodes for boilers and pressure piping and vessels (A387, P11, P12). | 2.5 | 3/32 | 4 x 2.5 | 5.5 | **BLU-32975006** |
| | | | | | | 3.2<br>4.0<br>5.0 | 1/8<br>5/32<br>3/16 | 4 x 5 | 11 | **BLU-32975008**<br>**BLU-32975010**<br>**BLU-32975012** |
| **LA 9018-B3** | E9018-B3 | E6218-B3 | All | Basic DC+/AC | 2 1/4Cr-1Mo electrodes for boilers, pressure piping and vessels (A387, P22). | 2.5 | 3/32 | 4 x 2.5 | 5.5 | **BLU-32976006** |
| | | | | | | 3.2<br>4.0<br>5.0 | 1/8<br>5/32<br>3/16 | 4 x 5 | 11 | **BLU-32976008**<br>**BLU-32976010**<br>**BLU-32976012** |
| **LA 9018-M** | E9018-M | E6218-M | All | Basic DC+/AC | High-tensile strengths steels. Quenched and tempered steel. | 3.2<br>4.0<br>5.0 | 1/8<br>5/32<br>3/16 | 4 x 5 | 11 | **BLU-32975508**<br>**BLU-32975510**<br>**BLU-32975512** |
| **LA 10018-M** | E10018-M | E6918-M | All | Basic DC+/AC | Welding steel with 710 MPa (100 ksi) tensile strength. | 3.2<br>4.0<br>5.0 | 1/8<br>5/32<br>3/16 | 4 x 5 | 11 | **BLU-32977508**<br>**BLU-32977510**<br>**BLU-32977512** |
| **LA 10018-D2** | E10018-D2 | E6918-D2 | All | Basic DC+/AC | High-tensile strength steels. Manganese-moly castings. Armour plates. | 2.5 | 3/32 | 4 x 2.5 | 5.5 | **BLU-32977006** |
| | | | | | | 3.2<br>4.0<br>5.0 | 1/8<br>5/32<br>3/16 | 4 x 5 | 11 | **BLU-32977008**<br>**BLU-32977010**<br>**BLU-32977012** |
| **LA 11018-M** | E11018-M | E7618-M | All | Basic DC+/AC | Welding steel with 760 MPa (110 ksi) tensile strength (T1 steel). | 2.5 | 3/32 | 4 x 2.5 | 5.5 | **BLU-32971006** |
| | | | | | | 3.2<br>4.0<br>5.0<br>6.0 | 1/8<br>5/32<br>3/16<br>1/4 | 4 x 5 | 11 | **BLU-32971008**<br>**BLU-32971010**<br>**BLU-32971012**<br>**BLU-32971016** |
| **LA 12018-M** | E12018-M | E8318-M | All | Basic DC+/AC | Welding steel with 830 MPa (120 ksi) tensile strength. | 3.2<br>4.0<br>5.0<br>6.0 | 1/8<br>5/32<br>3/16<br>1/4 | 4 x 5 | 11 | **BLU-32978008**<br>**BLU-32978010**<br>**BLU-32978012**<br>**BLU-32978016** |

*Low-alloy electrode length: 2.5 mm = 300 mm (12")*
*3.2 mm, 4.0 mm, 5.0 mm = 350 mm (14")*
*6.0 mm = 450 mm (18")*

*NOTE: Blueshield electrodes may meet code requirements other than those listed.*
*Please consult a representative for a complete listing of the code requirements for our electrodes.*





SMAW - Shielded-Metal Arc Welding

FILLER METALS

*Welding: the science of joining by fusion of steel.* Air Liquide has mastered welding for decades and offers a complete line of advanced stick electrodes for maintenance and repair (MNR), hardfacing and many other applications where high quality welding technologies are required. If it can be welded, our Blueshield MNR products will meet the challenge.

## Blueshield MNR - Specialty Welding Electrodes for Maintenance and Repair

| ALLOY GROUP | BLUESHIELD MNR | APPLICATION | POSITION | POLARITY | DIAMETER mm | DIAMETER in | PACKAGING kg | PACKAGING lb | | ITEM NUMBER |
|---|---|---|---|---|---|---|---|---|---|---|
| **Mild Steel** | **4 x 4** | Mild steel electrode for general maintenance and adverse conditions. Easily welds galvanized, painted, rusted or contaminated steels in service. For maximum penetration and digging action on ornamental iron, steel furniture, heavy and farm machinery parts. | All | DC +/–, AC | 2.5<br>3.2 | 3/32<br>1/8 | 0.45 | 1 | Tube | **BLU-53111025**<br>**BLU-53111032** |
| | | | | | 2.5<br>3.2<br>4.0 | 3/32<br>1/8<br>5/32 | 5 | 11 | Heavy plastic box | **BLU-53111525**<br>**BLU-53111532**<br>**BLU-53111540** |
| | **UNIVERSAL** | High speed welding on thin gauge, clean or new steel components. Universal is a versatile, general-purpose electrode for maintenance and fabrication. Welds all positions: flat, vertical up and down, and overhead at same amperage setting. | All | DC +/–, AC | 1.6<br>2.5<br>3.2 | 0.062<br>3/32<br>1/8 | 0.45 | 1 | Tube | **BLU-53113016**<br>**BLU-53113025**<br>**BLU-53113032** |
| | | | | | 2.5<br>3.2<br>4.0 | 3/32<br>1/8<br>5/32 | 5 | 11 | Heavy plastic box | **BLU-53113525**<br>**BLU-53113532**<br>**BLU-53113540** |
| **Low Alloy Steel** | **CHINOOK** | Perfect for all position welding of fine-grained structural and construction steels. Excellent mechanical properties and perfect for X-Ray work. Unique, stable spray-type arc. Excellent on root passes and positional welding. | All | DC +, AC | 2.5<br>3.2<br>4.0 | 3/32<br>1/8<br>5/32 | 5 | 11 | Heavy plastic box | **BLU-53116525**<br>**BLU-53116532**<br>**BLU-53116540** |
| | **STRIKER** | Extra low hydrogen & moisture resistant "18" type electrode. Never miss a weld start or tack! Welding minimum 70 000 psi tensile steel such as boiler, pipe, shipbuilding, construction, structural and cast steels. Great choice for welder appeal and weldability. | All | DC +, AC | 2.5<br>3.2 | 3/32<br>1/8 | 0.45 | 1 | Tube | **BLU-53118025**<br>**BLU-53118032** |
| | | | | | 2.5<br>3.2<br>4.0 | 3/32<br>1/8<br>5/32 | 5 | 11 | Heavy plastic box | **BLU-53118525**<br>**BLU-53118532**<br>**BLU-53118540** |
| **High Alloy Steel** | **REBEL** | High manganese stainless for "difficult to weld", high-strength, dissimilar steels. Good resistance to corrosion and cavitation damage (hydro turbines and pumps). Use as build up buffer layers for maximum impact resistance prior to hardfacing. Welds 14% manganese steels, alloyed, structural and heat treatable steels. | All | DC +, AC | 2.5<br>3.2<br>4.0 | 3/32<br>1/8<br>5/32 | 5 | 11 | Heavy plastic box | **BLU-53207525**<br>**BLU-53207532**<br>**BLU-53207540** |
| | **XTREME** | Exceptional strength and crack resistance. The essential electrode for welding all types of steels. For tools, dies, spring steel and any dissimilar steel combinations. For underlay and hardfacing of worn parts. For broken bolt removal and welding unknown steel. | All | DC +, AC | 1.6<br>2.5<br>3.2 | 0.062<br>3/32<br>1/8 | 0.45 | 1 | Tube | **BLU-53212016**<br>**BLU-53212025**<br>**BLU-53212032** |
| | | | | | 2.5<br>3.2<br>4.0 | 3/32<br>1/8<br>5/32 | 5 | 11 | Heavy plastic box | **BLU-53212525**<br>**BLU-53212532**<br>**BLU-53212540** |
| **Cutting and Gouging** | **ERASER** | Gouge, bevel or cut all metals including stainless steels, aluminums and copper. Eraser uses the power of the electrical arc and a special coating to remove and "erase" metal. | All | DC –, AC | 2.5<br>3.2<br>4.0<br>5.0 | 3/32<br>1/8<br>5/32<br>3/16 | 2.5 | 5 | Heavy plastic box | **BLU-53262325**<br>**BLU-53262332**<br>**BLU-53262340**<br>**BLU-53262350** |