BLUESHIELD™ LA 6010

Mild Steel Electrode

Standards	CSA W48, Class E4310 AWS A5.1/ASME SFA 5.1, Class E6010

Description & Applications

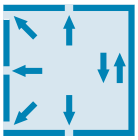
This all position electrode is used for producing very high quality welds. It has a cellulosic covering which produces a forceful, deep penetrating arc and a thin friable easily removed slag. BLUESHIELD LA 6010 yields welds that possess excellent mechanical properties. As it can be used in all positions, it finds wide usage in structural work, pressure vessels, ship-building and pipeline welding and is sometimes used on galvanized steel.

- It is ideally suited for root/hot pass welding pipe.
- Also suitable for maintenance work on dirty or rusty material.

The BLUESHIELD Advantage

- Maintains a forceful deep penetrating arc throughout the entire length of electrode.
- Weld puddle easily controlled. - Excellent strike and re-strike.
- Stable arc characteristics combined with good wetting action and fast freezing weld puddle.

Typical Welding Parameters



- Use only direct current electrode positive.
- Maintain a short to medium arc length.
- Use a slight whipping motion to control bead sag on out-of-position welds.
- Stringer, bead, or weave technique can also be used.
- To maximize the penetration, use a short arc length with the electrode inclined 20° in the direction of travel.

DIAMETER mm	DIAMETER in	AMPERAGE RANGE	OPTIMUM CURRENT
2.5	3/32	50 – 85	75
3.2	1/8	80 – 140	115
4.0	5/32	110 – 170	140
5.0	3/16	130 – 215	180

Typical Chemistry

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Ta	V	Cu	Ti
0.16	0.06	0.08	0.01	–	–	0.45	0.18	–	–	0.01	–	–

Typical Mechanical Properties*

	AS WELDED	
TENSILE STRENGTH	574 MPa	74.5 ksi
YIELD STRENGTH	424 MPa	61.5 ksi
ELONGATION	25.2 %	25.2 %
IMPACT (Charpy V-notch) TEST TEMPERATURE ENERGY	 -30°C 49 J	 -20°F 37 ft-lb

**Actual welding positions and procedures can impact results.*

Packaging

DIAMETER mm	DIAMETER in	LENGTH mm	LENGTH in	PACKAGING kg	PACKAGING lb	ITEM NUMBER
2.5	3/32	300	12	4 x 2.5	4 x 5.5	**BLU-30971106**
3.2	1/8	350	14	4 x 5	4 x 11	**BLU-30971108**
4.0	5/32	350	14	4 x 5	4 x 11	**BLU-30971110**
5.0	3/16	350	14	4 x 5	4 x 11	**BLU-30971112**

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