

Filler Metals





For companies looking to make their mark, BlueShield electrodes provide the best possible weld quality. We have a complete line of mild-steel, low-hydrogen and low-alloy electrodes available. Leader in the Canadian market, the BlueShield line meets high-quality standards.

BlueShield Mild-Steel Electrodes

NAME	AWS CLASS	CSA/CWB CLASS	POSITION	TYPE	APPLICATION	DIAMETER		PACKAGING		ITEM NUMBER
						mm	in	kg	lb	
LA 6010	E6010	E4310	All (Vertical Down)	Cellulosic DC+	Forceful and penetrating arc for structural steel, pipe, boiler and pressure vessels.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-30971106
						3.2	1/8	4 x 5	4 x 11	BLU-30971108
						4.0	5/32			BLU-30971110
						5.0	3/16			BLU-30971112
LA ULTRA 11	E6011	E4311	All	Cellulosic AC/DC+	Maintenance and repair work on dirty or rusty material. Ship and farm repair.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-30970106
						3.2	1/8	4 x 5	4 x 11	BLU-30970108
						4.0	5/32			BLU-30970110
						5.0	3/16			BLU-30970112
						6.0	1/4			BLU-30970116*
LA 6013	E6013	E4313	All	Rutile AC/DC-/+	General purpose. Thinner gauge materials vertically down. Fast freezing, used to bridge gaps.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-30971306
						3.2	1/8	4 x 5	4 x 11	BLU-30971308
						4.0	5/32			BLU-30971310
						5.0	3/16			BLU-30971312
LA 7014	E7014	E4914	All	Rutile AC/DC-/+	General purpose, high-speed, iron powder electrodes. Ornamental iron sheet metal "farmer's rod".	2.5	3/32	4 x 2.5	4 x 5.5	BLU-30971406
						3.2	1/8	4 x 5	4 x 11	BLU-30971408
						4.0	5/32			BLU-30971410
						5.0	3/16			BLU-30971412
LA 7024	E7024	E4924	Flat and horizontal	Rutile AC/DC-	General-purpose, high-speed, heavily-coated iron powder electrodes. Storage tank. Sheet plate and structural-metal work.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-30972406
						3.2	1/8	4 x 5	4 x 11	BLU-30972408
						4.0	5/32			BLU-30972410
						4.0	5/32	4 x 4.5	4 x 10	BLU-30972411*
						5.0	3/16			BLU-30972412*
6.0	1/4	BLU-30972416*								
LA 24-HD	E7024	E4924	Flat and horizontal	Rutile AC/DC-	High-deposition (HD) and high-efficiency version of LA 7024.	4.0	5/32	4 x 4.5	4 x 10	BLU-30972420*
						5.0	3/16			BLU-30972422*

Mild-steel 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")

*Electrode length = 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

Our high-quality products enable us to stake our claim as a market leader that delivers premium-grade electrodes. During welding and radiographic tests, the superior performance of Blueshield electrodes is outstanding and sets the benchmark in the Canadian industry.



Blueshield Low-Hydrogen Electrodes

NAME	AWS CLASS	CSA/CWB CLASS	POSITION	TYPE	APPLICATION	DIAMETER		PACKAGING		ITEM NUMBER
						mm	in	kg	lb	
LA EXCELARC 18	E7018	E4918-H8	All	Basic AC/DC+	Extremely user-friendly general-purpose AC/DC low-hydrogen electrode. Can be used with low OCV AC welders.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-32972306
						3.2 4.0	1/8 5/32	4 x 5	4 x 11	BLU-32972308 BLU-32972310
LA 7018	E7018-1	E4918-1-H4	All	Basic DC+/AC	LA 7018 is an industry standard Code quality 7018-1 with impact values down to -46°C (-50°F). Structural steels, boilers and pressure vessels.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-32971706
						3.2	1/8	4 x 5	4 x 11	BLU-32971708
						4.0	5/32			BLU-32971710
						4.0	5/32			BLU-32971711*
						5.0	3/16			BLU-32971712
6.0	1/4	BLU-32971716								
LA 18 LMP	E7018-1	E4918-1-H4	All	Basic DC+/AC Low moisture pickup	Low-moisture pick-up (LMP) version of LA 7018. Application with stringent control of the weld hydrogen level.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-32972706
						3.2	1/8	4 x 5	4 x 11	BLU-32972708
						4.0	5/32			BLU-32972710
						5.0	3/16			BLU-32972712
LA 18 PLUS	E7018-1	E4918-1-H4	All	Basic DC+/AC	Includes the benefits of LA 7018 with improved mechanical properties for demanding low temperature applications.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-32972106
						3.2	1/8	4 x 5	4 x 11	BLU-32972108
						4.0	5/32			BLU-32972110
						5.0	3/16			BLU-32972112
						6.0	1/4			BLU-32972116
LA 18 PLUS LMP	E7018-1	E4918-1-H4	All	Basic DC+/AC Low moisture pickup	Premium-code quality E7018-1 for difficult-to-weld steels for offshore fabrication, boilers and pressure vessels.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-32972906
						3.2	1/8	4 x 5	4 x 11	BLU-32972908
						4.0 5.0	5/32 3/16			BLU-32972910 BLU-32972912
NUCLEAR LA 7018	E7018-1	E4918-1-H4	All	Basic DC+/AC	Certified for welding nuclear power plant. ASME Section III Nuclear power plant component.	2.5	3/32	4 x 2.5	4 x 5.5	BLU-32979006
						3.2	1/8	4 x 5	4 x 11	BLU-32979008
						4.0	5/32			BLU-32979010
						5.0	3/16			BLU-32979012
LA 7028	E7028	E4928	Flat/ Horizontal	Basic DC+/AC	High-deposition and high-speed, low-hydrogen electrodes with good mechanical values.	3.2	1/8	4 x 5	4 x 11	BLU-32972808 BLU-32972810
						4.0	5/32			
						5.0	3/16	4 x 4.5	4 x 10	BLU-32972812
LA 7018 RCR	E7018-G	E4918-G	All	Basic DC+/AC	Unique corrosion resistant E7018 type electrode. Designed for repair and fabrication of ocean vessels, pulp and paper corrosion repair, and overlay on batch digesters.	3.2 4.0	1/8 5/32	4 x 5	11	BLU-32971408 BLU-32971410

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

*Electrode length = 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

Blueshield Low-Alloy Electrodes

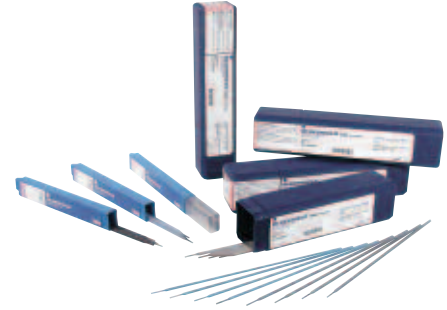
NAME	AWS CLASS	CSA/CWB CLASS	POSITION	TYPE	APPLICATION	DIAMETER		PACKAGING		ITEM NUMBER				
						mm	in	kg	lb					
LA 7018-A1	E7018-A1	E4918-A1	All	Basic DC+/AC	1/2% molybdenum electrodes. Boilers and pressure vessel work, low-alloy with stress relief requirement.	2.5	3/32	4 x 2.5	5.5	BLU-32973006				
						3.2	1/8	4 x 5	11	BLU-32973008				
						4.0	5/32			BLU-32973010				
						5.0	3/16		BLU-32973012					
LA 8018-W	E8018-W	E5518-W	All	Basic DC+/AC	Weathering steel such as "Cor-ten", "Stelcoloy G".	3.2	1/8	4 x 5	11	BLU-32975208				
						4.0	5/32			BLU-32975210				
											5.0	3/16		BLU-32975212
LA 8018-C1	E8018-C1	E5518-C1	All	Basic DC+/AC	2 1/4% nickel electrodes. Weld metal toughness down to -60°C (-76°F).	2.5	3/32	4 x 2.5	5.5	BLU-32973906				
						3.2	1/8	4 x 5	11	BLU-32973908				
						4.0	5/32			BLU-32973910				
						5.0	3/16		BLU-32973912					
LA 8018-C2	E8018-C2	E5518-C2	All	Basic DC+/AC	3% nickel electrodes. Weld metal toughness down to -75°C (-103°F).	2.5	3/32	4 x 2.5	5.5	BLU-32974006				
						3.2	1/8	4 x 5	11	BLU-32974008				
						4.0	5/32			BLU-32974010				
						5.0	3/16		BLU-32974012					
LA 8018-C3	E8018-C3	E5518-C3	All	Basic DC+/AC	1% nickel electrodes. Weld metal toughness down to -40°C (-40°F).	2.5	3/32	4 x 2.5	5.5	BLU-32973806				
						3.2	1/8			4 x 5	11	BLU-32973808		
						4.0	5/32	BLU-32973810						
						5.0	3/16	BLU-32973812						
										6.0	1/4			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	1/8	4 x 5	11	BLU-32975008				
						4.0	5/32			BLU-32975010				
						5.0	3/16		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	1/8	4 x 5	11	BLU-32976008				
						4.0	5/32			BLU-32976010				
						5.0	3/16		BLU-32976012					
LA 9018-M	E9018-M	E6218-M	All	Basic DC+/AC	High-tensile strengths steels. Quenched and tempered steel.	3.2	1/8	4 x 5	11	BLU-32975508				
						4.0	5/32			BLU-32975510				
										5.0	3/16			BLU-32975512
LA 10018-M	E10018-M	E6918-M	All	Basic DC+/AC	Welding steel with 710 MPa (100 ksi) tensile strength.	3.2	1/8	4 x 5	11	BLU-32977508				
						4.0	5/32			BLU-32977510				
										5.0	3/16			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	1/8	4 x 5	11	BLU-32977008				
						4.0	5/32			BLU-32977010				
						5.0	3/16		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	1/8	4 x 5	11	BLU-32971008				
						4.0	5/32			BLU-32971010				
										5.0	3/16			BLU-32971012
						6.0	1/4		BLU-32971016					
LA 12018-M	E12018-M	E8318-M	All	Basic DC+/AC	Welding steel with 830 MPa (120 ksi) tensile strength.	3.2	1/8	4 x 5	11	BLU-32978008				
						4.0	5/32			BLU-32978010				
										5.0	3/16			BLU-32978012
										6.0	1/4			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

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		PACKAGING			ITEM NUMBER
					mm	in	kg	lb		
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	3/32	0.45	1	Tube	BLU-53111025 BLU-53111032
					3.2	1/8				
	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	2.5	3/32	5	11	Heavy plastic box	BLU-53111525 BLU-53111532 BLU-53111540
					3.2	1/8				
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	3/32	5	11	Heavy plastic box	BLU-53116525 BLU-53116532 BLU-53116540
					3.2	1/8				
	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	3/32	0.45	1	Tube	BLU-53118025 BLU-53118032
					3.2	1/8				
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	3/32	5	11	Heavy plastic box	BLU-53207525 BLU-53207532 BLU-53207540
					3.2	1/8				
	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	0.062	0.45	1	Tube	BLU-53212016 BLU-53212025 BLU-53212032
					2.5	3/32				
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	3/32	2.5	5	Heavy plastic box	BLU-53262325 BLU-53262332 BLU-53262340 BLU-53262350
					3.2	1/8				
					4.0	5/32				
					5.0	3/16				

SMAW - Shielded-Metal Arc Welding

Blueshield MNR - Specialty Welding Electrodes for Maintenance and Repair (continued)

ALLOY GROUP	BLUESHIELD MNR	APPLICATION	POSITION	POLARITY	DIAMETER		PACKAGING			ITEM NUMBER
					mm	in	kg	lb		
Cast Iron	CAST 55	A 55% nickel cast iron but with actual nickel content increased to 60%. Cast 55 is "barium free" for joining dirty and contaminated cast irons. Welds a wide variety of ductile, nodular and malleable cast irons. Extra nickel offers crack resistance and maximum machinability. Strong arc penetrates surface contaminants.	All	DC +, AC	2.5 3.2 4.0	3/32 1/8 5/32	5	11	Heavy plastic box	BLU-53455525 BLU-53455532 BLU-53455540
	TRI-CAST	Copper clad "tri-metal" cast iron nickel-based electrode. Iron-nickel-copper chemistry. Proprietary deposit chemistry yields a unique combination of softness, ductility and tensile strength. Higher welding speed creates extremely small heat affected zone and low heat input.	All	DC +, AC	2.5 3.2	3/32 1/8	0.45	1	Tube	BLU-53460025 BLU-53460032
					2.5 3.2 4.0	3/32 1/8 5/32	5	11	Heavy plastic box	BLU-53460525 BLU-53460532 BLU-53460540
CAST 99	99% nickel cast iron electrode with 100% non-conductive flux coating. Very soft machinable welds, porosity free and excellent weldability. Cast 99 is especially suited for welding in deep recesses or close access due to the non-conductive flux coating.	All	DC +, AC	2.5 3.2 4.0	3/32 1/8 5/32	5	11	Heavy plastic box	BLU-53499525 BLU-53499532 BLU-53499540	
Aluminum	LITE	Coated aluminum electrode for arc welding and brazing of aluminum alloys. 5% silicon aluminum electrode. Welds aluminums alloyed with copper, silicon and magnesium. Excellent for joining dissimilar grades of aluminum.	Flat, Horizontal	DC +	2.5 3.2	3/32 1/8	0.45	1	Tube	BLU-53543025 BLU-53543032
					2.5 3.2	3/32 1/8	2.5	5.5	Heavy plastic box "Vacuum pack"	BLU-53543525 BLU-53543532
Silver Brazing	SILVER 45	Silver-based flux-coated rod for low temperature brazing. Super active flux-coated "cadmium free" silver brazing alloy with 45% silver. Joins many types of metals and dissimilar materials. Special "fast flow" coating for maximum de-oxidation and protection of the weld.	—	Flame	1.6 2.5	0.062 3/32	0.45	1	Tube	BLU-53545016 BLU-53545025
Hardfacing Impact & Heavy Impact Build Up	BUILDER 38	38 Rockwell "C" electrode for impact resistant build-up on steels or prior to hardfacing. Offers superior toughness, compression and impact resistance. For tractor shoes, links, rollers, sprocket and idlers, crane & mine wheels and brake drums, shafts, gears, drive sprocket, track pads, mill hammer parts, buckets, etc.	All	DC +/-, AC	3.2 4.0 5.0	1/8 5/32 3/16	5	11	Heavy plastic box	BLU-53738532 BLU-53738540 BLU-53738550
	BUILDER MN	Manganese (Mn) alloyed electrode for heavy impact resistant or build-up prior to hardfacing. Builder MN offers outstanding toughness, compression and impact resistance. Deposit hardens under impact loading from 2-5 times the initial hardness. Joining and surfacing of wear plates and parts subjected to impact wear. For crushing rolls, jaws and concaves; rail equipment, switches, railways couplers, crossing and frogs; construction equipment, manganese steel, shovel buckets, impact hammer, bucket, milling hammer, crusher jaws, dredge pump shells, armor plating, etc.	All	DC +, AC	3.2 4.0 5.0	1/8 5/32 3/16	5	11	Heavy plastic box	BLU-53748532 BLU-53748540 BLU-53748550

SMAW - Shielded-Metal Arc Welding

Blueshield MNR - Specialty Welding Electrodes for Maintenance and Repair (continued)

ALLOY GROUP	BLUESHIELD MNR	APPLICATION	POSITION	POLARITY	DIAMETER		PACKAGING			ITEM NUMBER
					mm	in	kg	lb		
Hardfacing	HARD 58	58 Rockwell "C" general hardfacing electrode for combined abrasion and moderate impact. Can be used as under layer. Hardfacing of mining, rock and earth moving equipment, shovels, buckets, crawler shoes, bulldozer and scraper blades, crusher rolls, bucket teeth and lips, mixer blade, mill hammer, cutting edge, gyratory crusher, bucket liner, jaws, plowing implements; dipper lips, dredge pump, pump casing, etc.	Flat, Horizontal	DC +, AC	3.2	1/8	0.45	1	Tube	BLU-53758032 BLU-53758040
		4.0			5/32					
Abrasion + Impact & Metal-Metal	HARD 60	60 Rockwell "C" hardfacing electrode for moderate impact and moderate abrasion offering high deposition rate. Especially suited for metal to metal wear applications involving steel, manganese steel and cast iron. Hardfacing of mining equipment, shovels, buckets, crawler shoes, plowing implements; bulldozer blades, crawler tractor shoes, links, rollers and idlers, crane & mine car wheels, shafts, gears, drive sprocket, tracks, etc.	Flat, Horizontal	DC +/-, AC	3.2	1/8	5	11	Heavy plastic box	BLU-53760532 BLU-53760540
				4.0	5/32					
Hardfacing	KROME 62	62 Rockwell "C" contains large amounts of chromium carbide. Surfacing against severe abrasive wear and moderate impact. Krome 62 offers smooth overlays and excellent weldability. Hardfacing of wear plates; shovel teeth; mechanized shovel buckets; bulldozer blades, mining equipment, road-building machinery, agricultural tools, earth moving equipment in abrasive soil, conveyer screw and chains, mixer, pipeline elbows, send chute, bucket lips and teeth, crushing hammer, roll crusher, steel mill guides, punch rolls, valves, pump casing and impellers, etc.	Flat, Horizontal	DC +, AC	2.5	3/32	5	11	Heavy plastic box	BLU-53762525 BLU-53762532 BLU-53762540 BLU-53762550
		3.2			1/8					
Maximum Abrasion & Abrasion Temperature	KROME 68	Maximum hardness 68 Rockwell "C" deposits enriched with Niobium (Nb) and Chromium (Cr) carbides. Ultimate combination of abrasion resistance and high temperature hardness retention. Hardfacing of wear plates, shovel teeth, buckets, bulldozer blades, iron and steel making industry; ash plows, coke crusher, screw conveyer, rake teeth in furnaces, mineral crushers; screens, production of construction materials and various minerals; quarries, cement plants, agriculture grain threshers, valves, exhaust fan, agitator finger, mill guides, mixes blades, bucket lips, asphalt mixer, crusher hammer, etc.	Flat, Horizontal	DC +/-, AC	3.2	1/8	5	11	Heavy plastic box	BLU-53768532 BLU-53768540 BLU-53768550
				4.0	5/32					
					5.0	3/16				

SMAW - Shielded-Metal Arc Welding



Blueshield gouging carbon electrodes are designed especially for the air carbon-arc metal removal process.

Blueshield gouging electrodes offer:

- Long electrode life
- Excellent arc stability
- Superior metal removal rates
- Groove uniformity
- Numerous sizes

New Blueshield Pro hollow-core gouging electrodes

Blueshield Gouging Carbon Electrodes

Use Blueshield carbon gouging electrodes with any type of gouging torches connected to a DC power supply and compressed air source.

Applications

- Edge preparation for groove joints (especially J- and U-grooves)
- Remove discontinuities from weld deposits
- Remove entire welds when structural repairs or modifications are necessary

Blueshield carbon gouging electrodes contain a precisely formulated blend of carbon and graphite that produces very efficient metal removal performance.

The Blueshield Pro carbon gouging electrodes' unique hollow design allows the electric current to be directed to and concentrated on the outside diameter of the rod. This allows for very efficient removal of metal, resulting in even higher productivity.



DC Copperclad Pointed Electrodes

A standard all-purpose gouging electrode. Controlled copper coating improves conductivity providing more efficient, cooler, operation and helps maintain electrode diameter at the point of the arc. When using pointed gouging carbons, the user will have about three inches of stub loss.

DC Copperclad Jointed Electrodes

Eliminates stub loss and provides continuous electrode feed especially for semi-automatic and automatic torches. Machined at each end to provide male and female fittings.

ITEM NUMBER	DESCRIPTION	QUANTITY	ELECTRODE SIZE	MIN AMP	MAX AMP	K4000 MODEL	K2000 MODEL
BLU-28977512	DC Copperclad pointed electrode	50 / pkg	4.8 mm (3/16") x 305 mm (12")	200	250	X	X
BLU-28977516	DC Copperclad pointed electrode	50 / pkg	6.4 mm (1/4") x 305 mm (12")	300	400	X	X
BLU-28977520	DC Copperclad pointed electrode	50 / pkg	7.9 mm (5/16") x 305 mm (12")	350	450	X	
BLU-28977524	DC Copperclad pointed electrode	50 / pkg	9.5 mm (3/8") x 305 mm (12")	450	600	X	
BLU-28979512	Blueshield Pro DC Copperclad electrode	50 / pkg	4.8 mm (3/16") x 305 mm (12")	-	-	X	X
BLU-28979516	Blueshield Pro DC Copperclad electrode	50 / pkg	6.4 mm (1/4") x 305 mm (12")	275	325	X	X
BLU-28979520	Blueshield Pro DC Copperclad electrode	50 / pkg	7.9 mm (5/16") x 305 mm (12")	-	-	X	X
BLU-28979524	Blueshield Pro DC Copperclad electrode	50 / pkg	9.5 mm (3/8") x 305 mm (12")	-	-	X	X
BLU-28978532	DC Copperclad jointed electrode	100 / pkg	12.7 mm (1/2") x 430 mm (17")	800	1000	X	

Helpful Hints

When calculating electrode consumption, the following information may be helpful:

- For every inch of electrode consumed, the user will get 8" of groove when making a gouge that is equal in depth to the diameter of the carbon. The gouged width will be about 1/8" wider than the diameter of the carbon electrode being used.

Safety Reminders

- Use a welding helmet (shade 11 and up) such as the Weldline Chameleon.
- Use additional skin protection products such as Blueshield gloves & garments.
- Wear ear protection against noise and to protect ears from sparks.
- Avoid inhaling breathing smoke and fumes.
- Remove all combustibles and flammables from work area.
- Never substitute oxygen for compressed air.

GMAW - Gas-Metal Arc Welding

Whether you are a production, MIG welder or home hobbyist, we have MIG wire packages to cover your welding needs. We have invested countless hours in research, development and testing to ensure you get the arc performance, consistent feedability and productivity that the industry has come to expect.



Blueshield Solid Wires, small packaging

NAME	AWS CLASS	CSA/CWB CLASS	POSITION	TYPE	APPLICATION	DIAMETER		PACKAGING			ITEM NUMBER		
						mm	in*	kg	lb				
LA S-6	ER70S-6	ER49S-6 CAN/CSA ISO 14341 B-G49A3CG6	All-position welding using short-circuit or pulse-spray arc transfer	Lightly copper- coated	Welding of low-carbon steel plates, tubing, piping, structural members, steel castings, pressure vessels, etc. Also commonly used to weld dirty or rusty materials with minimal pre-cleaning.	0.6	0.023	0.9	2	Spool	BLU-38978323 BLU-38978330 BLU-38978335 BLU-38978345		
						0.8	0.030						
						0.9	0.035						
						1.2	0.045						
						0.6	0.023	5	11	Spool	BLU-38977823 BLU-38977830 BLU-38977835 BLU-38977845	0.8	0.030
												0.9	0.035
												1.2	0.045
												0.8	0.030
												0.8	0.030
						0.9	0.035						
						1.14	0.045						
						1.32	0.052						
1.6	0.062												
LA S-3	ER70S-3	ER49S-3 CAN/CSA ISO 14341 B-G49A2CG3	All-position welding using short-circuit or pulse-spray arc transfer	Lightly copper- coated	Welding of low-carbon steel plates commonly found in the automotive, piping and structural steel market segments. Also used where a weld deposit with little or no silicate islands are required.	0.9	0.035	20	44	Spool	BLU-38978135 BLU-38978145 BLU-38978152 BLU-38978162		
						1.14	0.045						
						1.32	0.052						
						1.6	0.062						

* Approximate diameter equivalent.

**“Blueshield: the quality
you want for your welding work”**





If enhanced productivity is your aim, we have a variety of bulk packaging options from which to choose. Whether your preference is large spools or drums, we have the right product to suit your welding needs. Our state-of-the-art bulk-wire packaging system provides a “tangle-free” weld, and is relied on by some of the largest automotive welding wire users in North America. This packaging system enhances productivity through superior weld quality.

BlueShield Solid Wires, large packaging

NAME	AWS CLASS*	CSA/CWB CLASS*	POSITION	TYPE	APPLICATION	DIAMETER		PACKAGING			ITEM NUMBER	
						mm	in**	kg	lb			
LA S-3	ER70S-3	ER-49S-3 CAN/CSA ISO 14341 B-G49A2CG3	All-position welding using short-circuit or pulse-spray arc transfer	Lightly copper- coated	Welding of low-carbon steel plate commonly found in the automotive, piping and structural steel market segments. Also used where a weld deposit with little or no silicate islands is required.	0.9	0.035	150	330	Reel		BLU-38979135 BLU-38979140 BLU-38979145 BLU-38979152 BLU-38979162
						1.0	0.040					
						1.14	0.045					
						1.32	0.052					
						1.6	0.062					
						0.9	0.035	450	990	Reel		BLU-38979635 BLU-38979645 BLU-38979652 BLU-38979662
						1.14	0.045					
						1.32	0.052					
						1.6	0.062					
0.9	0.035	750	1650	Reel		BLU-38979635AR BLU-38979645AR BLU-38979652AR BLU-38979662AR						
1.14	0.045											
1.32	0.052											
1.6	0.062											
STRAIGHT WELD LA S-3	ER70S-3	ER49S-3 CAN/CSA ISO 14341 B-G49A2CG3	All-position welding using short-circuit or pulse-spray arc transfer	Lightly copper- coated	Welding of low-carbon steel plate commonly found in the automotive, piping and structural steel market segments. Also used where a weld deposit with little or no silicate islands is required.	0.9	0.035	226.8	500	Drum		BLU-38977135 BLU-38977140 BLU-38977145 BLU-38977152
						1.0	0.040					
						1.14	0.045					
						1.32	0.052					
						0.9	0.035	453.6	1000	Drum		BLU-38977135AD BLU-38977140AD BLU-38977145AD BLU-38977152AD
						1.0	0.040					
1.32	0.052											
LA S-6	ER70S-6	ER49S-6 CAN/CSA ISO 14341 B-G49A3CG6	All-position welding using short-circuit or pulse-spray arc transfer	Lightly copper- coated	Welding of low-carbon steel plate, tubing, piping, structural members, steel castings, pressure vessels, etc. Also commonly used to weld dirty or rusty materials with minimal pre-cleaning.	0.9	0.035	150	330	Reel		BLU-38973935 BLU-38973940 BLU-38973945 BLU-38973952 BLU-38973962
						1.0	0.040					
						1.14	0.045					
						1.32	0.052					
						1.6	0.062					
						0.9	0.035	450	990	Reel		BLU-38971035 BLU-38971040 BLU-38971045 BLU-38971052 BLU-38971062
						1.0	0.040					
						1.14	0.045					
						1.32	0.052					
0.9	0.035	750	1650	Reel		BLU-38971035AR BLU-38971040AR BLU-38971045AR BLU-38971052AR BLU-38971062AR						
1.0	0.040											
1.14	0.045											
1.32	0.052											
STRAIGHT WELD LA S-6	ER70S-6	ER49S-6 CAN/CSA ISO 14341 B-G49A3CG6	All-position welding using short-circuit or pulse-spray arc transfer	Lightly copper- coated	Welding of low-carbon steel plate, tubing, piping, structural members, steel castings, pressure vessels, etc. Also commonly used to weld dirty or rusty materials with minimal pre-cleaning.	0.9	0.035	226.8	500	Drum		BLU-38977435 BLU-38977440 BLU-38977445 BLU-38977452
						1.0	0.040					
						1.14	0.045					
						1.32	0.052					
						0.9	0.035	453.6	1000	Drum		BLU-38977435AD BLU-38977440AD BLU-38977445AD BLU-38977452AD
						1.0	0.040					
1.32	0.052											

* Some products are also naval-approved. Contact your local representative for more information. ** Approximate diameter equivalent