



Standards

CSA W48, Class E4313
AWS A5.1/ASME SFA 5.1, Class E6013

Description & Applications

It is an extremely versatile, user friendly, general purpose, all-position rutile-type covered electrode. The fast freeze slag characteristic makes this electrode ideally suited for welding sheet metal out of position (**vertical down**).

- Typical applications include light metal fabrication, farm equipment, repair and the home hobbyist.

The BLUESHIELD™ Advantage

- All position.
- Fast freezing slag easily removed.
- Very good operator appeal, soft smooth arc.
- Can be used with either AC or DC current on a wide variety of power sources.

Typical Welding Parameters

- Either AC or DC can be used, DC electrode negative preferred.
- A stringer or weave type welding technique may be used.
- Overhead fillet welds are generally made using stringer beads.



DIAMETER		AMPERAGE RANGE	OPTIMUM CURRENT
mm	in		
2.5	3/32	50 – 85	70
3.2	1/8	75 – 130	115
4.0	5/32	110 – 170	150

Typical Chemistry

C	Cr	Ni	Mo	P	S	Mn	Si	V	Al	Cu
0.09	0.03	0.03	0.01	–	–	0.31	0.37	0.01	–	–

Typical Mechanical Properties*

	AS WELDED	
TENSILE STRENGTH	504 MPa	73.1 ksi
YIELD STRENGTH	436 MPa	63.2 ksi
ELONGATION	29 %	29 %

* Actual welding positions and procedures can impact results.

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	A0274540
3.2	1/8	350	14	4 x 5	4 x 11	A0274543
4.0	5/32	350	14	4 x 5	4 x 11	A0274546