



Standards

CSA W48, Class E4914
AWS A5.1/ASME SFA 5.1, Class E7014

Description & Applications

It is a rutile based, all-position, high-speed welding electrode operating on AC or DC current. It is used as an all-purpose welding electrode to weld a variety of steels including low-to-medium carbon steels.

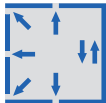
- Typical applications include the home hobbyist and farm maintenance and repair.

The BLUESHIELD™ Advantage

- Ease of operation with excellent strike and re-strike characteristics.
- Iron powder in the coating increases deposition rates and efficiencies resulting in higher welding speeds.

Typical Welding Parameters

- Designed to be used with AC or DC current.
- With DC current, electrode negative is usually preferred.
- Can be used with either an open arc or drag technique.



DIAMETER		AMPERAGE RANGE	OPTIMUM CURRENT
mm	in		
2.5	3/32	75 – 95	80
3.2	1/8	115 – 150	130
4.0	5/32	125 – 200	175

Typical Chemistry

C	Cr	Ni	Mo	P	S	Mn	Si	V
0.09	0.03	0.03	0.01	0.014	0.011	0.45	0.36	0.01

Typical Mechanical Properties*

	AS WELDED	
TENSILE STRENGTH	535 MPa	76 ksi
YIELD STRENGTH	458 MPa	66 ksi
ELONGATION	26 %	26 %

* 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	A0274550
3.2	1/8	350	14	4 x 5	4 x 11	A0274553
4.0	5/32	350	14	4 x 5	4 x 11	A0274556