



Standards

CSA W48, Class E4924
AWS A5.1/ASME SFA 5.1, Class E7024

Description & Applications

It is heavily-coated rutile-type mild steel electrode for flat position welding. This electrode is ideally suited for high-speed fillet weld applications. It is also used where high deposition rates are required but concern for weld metal toughness is not critical.

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

The BLUESHIELD™ Advantage

- Versatility lends itself well to a variety of user skill levels and applications.
- Flexibility can be used with limited input AC/DC type welding power sources.
- Very good operator appeal, soft smooth arc, minimal spatter with good slag removal.
- Can be used with either AC or DC current on a wide variety of power sources.

Typical Welding Parameters

- Either AC or DC electrode negative current can be used.
- A stringer or weave type welding technique may be used.
- Optimum operating characteristics are achieved using a drag technique or short arc length.



DIAMETER		AMPERAGE RANGE	OPTIMUM CURRENT
mm	in		
2.5	3/32	90 – 135	105
3.2	1/8	140 – 180	170
4.0	5/32	175 – 240	220
5.0	3/16	215 – 300	270
6.0	1/4	290 – 400	325

Typical Chemistry

C	Cr	Ni	Mo	P	S	Mn	Si	V	Mn + Ni + Cr + Mo + V
0.07	0.04	0.03	0.01	0.012	0.01	0.67	0.35	0.01	0.76

Typical Mechanical Properties*

	AS WELDED
TENSILE STRENGTH	514 MPa / 74.5 ksi
YIELD STRENGTH	447 MPa / 64.8 ksi
ELONGATION	23.1 %

* 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	A0274558
3.2	1/8	350	14	4 x 5	4 x 11	A0274559
4.0	5/32	350	14	4 x 5	4 x 11	A0274561
4.0	5/32	450	18	4 x 4.5	4 x 10	A0274560
5.0	3/16	450	18	4 x 4.5	4 x 10	A0274563
6.0	1/4	450	18	4 x 4.5	4 x 10	A0274564