



Standards

CSA W48, Class E4928-H8
AWS A5.1/ASME SFA 5.1, Class E7028-H8

Description & Applications

It is a heavily coated basic low hydrogen electrode containing a high percentage of iron powder in the covering. It is designed specifically for high speed flat and horizontal fillet welding. It is used primarily on heavy weldments of mild, low alloy or hard to weld steels. Speed and deposition rate are higher than those attained with E4918/7018 electrodes. It is used where a low hydrogen weld are deposits required coupled with high deposition rates.

- Typical uses are production welding, shipbuilding and structural steel fabrication.

The BLUESHIELD™ Advantage

- Higher deposition rates.
- Very easy slag removal.
- Excellent bead appearance.
- Minimal spatter.

Typical Welding Parameters

- Flat and horizontal positions.
- Used on either AC or DC current, electrode positive.
- In order to reduce the possibility of starting porosity, strike the electrode ahead of the crater of the previously finished weld bead and quickly move back into the crater while shortening the arc length.
- Maintain as short an arc as possible.



DIAMETER		AMPERAGE RANGE	OPTIMUM CURRENT
mm	in		
3.2	1/8	130 – 175	160
4.0	5/32	140 – 250	210
5.0	3/16	210 – 335	275

Typical Chemistry

C	Cr	Ni	Mo	P	S	Mn	Si	V	Mn + Ni + Cr + Mo + V
0.05	0.05	0.07	0.02	0.02	0.02	0.97	0.46	0.01	1.12

Typical Mechanical Properties*

	AS WELDED	
TENSILE STRENGTH	553 MPa	80 ksi
YIELD STRENGTH	465 MPa	67 ksi
ELONGATION	31 %	31 %
IMPACT (Charpy V-notch) TEST TEMPERATURE ENERGY	-20°C 52 J	0°F 39 ft-lb

* Actual welding positions and procedures can impact results.

Packaging

DIAMETER		LENGTH		PACKAGING		ITEM NUMBER
mm	in	mm	in	kg	lb	
2.5	1/8	350	14	4 x 5	4 x 11	A0274404
4.0	5/32	350	14	4 x 5	4 x 11	A0274405
5.0	3/16	450	18	4 x 4.5	4 x 10	A0274406