



Standards

CSA W48, Class E4311
AWS A5.1/ASME SFA 5.1, Class E6011

Description & Applications

It is a good mild steel, general purpose, all-position cellulosic-type covered electrode. Cellulose in the coating produces an exceptionally stable, forceful penetrating arc. This electrode is ideally suited for maintenance work where dirty or rusty materials are often found. It is also used where LA 6010 is required, but where only AC current is available.

- Typical applications include shipyards, general metal fabrication, farm equipment, sheet metal, and repair.

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.
- Aggressive arc action allows this electrode to perform extremely well in harsh environments.
- Its ability to be used on AC current makes it handy in reducing the effects of magnetic arc blow.
- Yields maximum travel speeds on sheet metal applications.

Typical Welding Parameters

- Either AC or DC electrode positive current can be used.
- A stringer or weave type welding technique may be used.
- Overhead fillet welds are generally made using stringer beads.
- Maintain a short-to-medium arc length.



DIAMETER		AMPERAGE RANGE	OPTIMUM CURRENT
mm	in		
2.5	3/32	50 – 85	70
3.2	1/8	80 – 130	115
4.0	5/32	110 – 160	140
5.0	3/16	130 – 190	180
6.0	1/4	200 – 300	225

Typical Chemistry

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Ta	V	Cu	Ti
0.14	0.03	0.03	0.01	–	–	0.59	0.28	–	–	0.01	–	–

Typical Mechanical Properties*

	AS WELDED	
TENSILE STRENGTH	548 MPa	79.5 ksi
YIELD STRENGTH	462 MPa	67 ksi
ELONGATION	30 %	30 %
IMPACT (Charpy V-notch) TEST TEMPERATURE ENERGY	-30°C 59 J	-20°F 44 ft-lb

* 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	A0274565
3.2	1/8	350	14	4 x 5	4 x 11	A0274567
4.0	5/32	350	14	4 x 5	4 x 11	A0274569
5.0	3/16	350	14	4 x 5	4 x 11	A0274570
6.0	1/4	450	18	4 x 5	4 x 11	A0274571