BLUESHIELD™ LA 8018-C2

Low Alloy Steel Electrode

Standards	AWS A5.5/ASME SFA 5.5, Class E8018-C2-H4

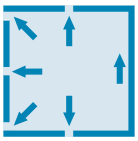
Description & Applications

It is a basic low hydrogen type covered electrode with nickel added in the covering. It is recommended for welding of the 2 to 4% nickel steels or steels designed for low temperature service environments.

The BLUESHIELD Advantage

- Smooth stable arc.
- Easy slag removal.
- User friendly.
- Low hydrogen weld deposit.

Typical Welding Parameters



- As with all basic type electrodes, as short an arc as possible should be maintained using either direct current electrode positive (DCEP) or alternating current.
- Stringer beads are preferred to weaving.
- Attention must be paid at the beginning of a bead to obtain full coverage with slag in order to prevent porosity.
- Preheating is governed by the hardenability and/or thickness of the steel being welded.

DIAMETER mm	DIAMETER in	AMPERAGE RANGE	OPTIMUM CURRENT
2.5	3/32	75 – 115	100
3.2	1/8	90 – 160	130
4.0	5/32	130 – 220	175
5.0	3/16	160 – 315	250

Typical Chemistry

C	Cr	Ni	Mo	P	S	Mn	Si	Nb	Ta	V	Cu	Ti
0.05	0.05	3.38	0.02	0.009	0.014	1.12	0.37	–	–	–	–	–

Typical Mechanical Properties*

	STRESS RELIEVED 1H @ 620°C (1148°F)	
TENSILE STRENGTH	590 MPa	86 ksi
YIELD STRENGTH	530 MPa	77 ksi
ELONGATION	32 %	32 %
IMPACT (Charpy V-notch) TEST TEMPERATURE ENERGY	 -75°C 28 J	 -100°F 21 ft-lb

**Actual welding positions and procedures can impact results.*

Packaging

DIAMETER mm	DIAMETER in	LENGTH mm	LENGTH in	PACKAGING kg	PACKAGING lb	ITEM NUMBER
2.5	3/32	300	12	4 x 2.5	4 x 5.5	**BLU-32974006**
3.2	1/8	350	14	4 x 5	4 x 11	**BLU-32974008**
4.0	5/32	350	14	4 x 5	4 x 11	**BLU-32974010**
5.0	3/16	350	14	4 x 5	4 x 11	**BLU-32974012**

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