



BLUESHIELD™ LA T9 LF

Carbon Steel

STANDARDS

CSA W48-01/W48-06, Class E492T-9-H8
 AWS A5.20-95/ASME SFA 5.20, Class E70T-1-H8, E70T-9-H8

DESCRIPTION & APPLICATIONS

- A general-purpose single-or multi-pass, flat/horizontal position flux-cored wire designed to yield lower fume generation (emissions) with mechanical properties down to -30°C (-20°F) when using CO₂ shielding gases
- Welding corresponding steel grades: A36, A285, A515 GR.70 and A516 Gr.70
- Welding structural steel, bridge construction, rolling stock, construction equipment and general carbon steel fabrication

THE **BLUESHIELD™** ADVANTAGE

- Lower fume emissions – safer work environment
- Deep penetrating arc – reduces lack of fusion problems
- Versatility – ease of use in a variety of applications

TYPICAL WELDING PARAMETERS



Diameter		Volts V	Amps A	Wire feed speed ± 5%		Gas	Flow		Electrode Extension mm - in
mm	in			cm/min	in/min		l/min	cfh	
1.2	0.045	25-30	130-300	356-1397	140-550	CO ₂	20	45	16 – 5/8
1.6	1/16	28-32	280-400	635-1168	250-460		20	45	19 – 3/4
2.0	5/64	29-34	325-500	457-890	180-350		20	45	25 – 1
2.4	3/32	30-36	400-550	318-648	125-255		20	45	25 – 1

RECOMMENDED SHIELDING GASES: CO₂ is preferred

TYPICAL FUME GENERATION*: 0.80 – 1.20 g/min

TYPICAL DIFFUSABLE HYDROGEN*: 8 ml/100 g

TYPICAL CHEMISTRY

Weight %	C	Mn	Si	P	S	Ni
CO ₂	0.03	1.55	0.50	0.013	0.011	-

TYPICAL MECHANICAL PROPERTIES*

	As Welded
	CO ₂
Tensile Strength Mpa (ksi)	593 (86)
Yield Strength Mpa (ksi)	538 (78)
Elongation in 50 mm – 2 in (%)	25
KV (Average) @ -30°C (-20°F)	37 J (27 ft-lb)

* Actual welding procedure and conditions can impact results

PACKAGING

Diameter		Packaging			Item Number
mm	in	kg	lb		
1.2	0.045	15	33	Spool	BLU-37962673
1.6	1/16				BLU-37962675
1.6	1/16	27.2	60	Coil	BLU-37962635
2.0	5/64				BLU-37962636
2.4	3/32				BLU-37962637
1.6	1/16	280	616	Reel	BLU-37962645
2.0	5/64				BLU-37962646
2.4	3/32				BLU-37962647
1.6	1/16	226.8	500	Drum	BLU-37962655
2.4	3/32				BLU-37962657