



BLUESHIELD™ LA T9 PLUS

Carbon Steel

STANDARDS

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

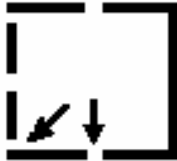
DESCRIPTION & APPLICATIONS

- A highly efficient single-or multi-pass, flat/horizontal position flux-cored wire designed to yield weld-metal mechanical properties down to -30°C (-20°F) when using, CO₂ or Ar/CO₂ shielding gas mixtures containing up to 80% argon
- Welding mild and medium carbon steels
- Welding corresponding steel grades: A36, A53, A106, A108 and A109
- Welding structural members, rolling stock, construction equipment and general carbon steel fabrication

THE BLUESHIELD™ ADVANTAGE

- Minimal spatter levels – easy cleanup
- 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	24-30	130-300	356-1397	140-550	BLUESHIELD™ 8 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. BLUESHIELD™ 8 can be used as alternate shielding gases

TYPICAL DIFFUSABLE HYDROGEN*:

8 ml/100 g

TYPICAL CHEMISTRY

Weight %	C	Mn	Si	P	S	Ni
BLUESHIELD™ 8	0.07	1.52	0.61	0.01	0.007	-
CO ₂	0.06	1.46	0.58	0.01	0.008	-

TYPICAL MECHANICAL PROPERTIES*

	As Welded	
	BLUESHIELD™ 8	CO ₂
Tensile Strength MPa (ksi)	649 (94.1)	604 (87.6)
Yield Strength MPa (ksi)	559 (81.1)	511 (74.1)
Elongation in 50 mm – 2 in (%)	24	26
Impact (Charpy V-Notch) @ -30°C (-20°F)	40 J (30 ft-lb)	44 J (32 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-37963373
1.6	1/6				BLU-37972015
1.6	1/6	27.2	60	Coil	BLU-37972034
2.0	5/64				BLU-37972035
2.4	3/32				BLU-37972036
1.6	1/6				BLU-37972009
2.0	5/64	280	616	Reel	BLU-37972008
2.4	3/32				BLU-37972003
1.6	1/6	226.8	500	Drum	BLU-37963355
2.4	3/32				BLU-37963357