



BLUESHIELD™ LA T9

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

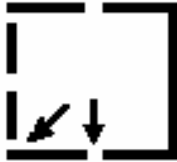
DESCRIPTION & APPLICATIONS

- A general-purpose 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, Ar/CO₂ or ARCAL™ 211 shielding gases
- Welding mild-and medium-carbon steels
- Welding corresponding steel grades: A36, A285, A515 GR.70 and A516 Gr.70
- Welding structural steels, bridge construction, rolling stock, construction equipment and general carbon steel fabrication

THE BLUESHIELD™ ADVANTAGE

- High level of deoxidizers – reduces risk of porosity
- 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	ARCAL™ 211 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: BLUESHIELD™ 8 or CO₂ is preferred. ARCAL™ 211 can be used as alternate shielding gases

TYPICAL DIFFUSABLE HYDROGEN*: 8 ml/100 g

TYPICAL CHEMISTRY

Weight %	C	Mn	Si	P	S	Ni
ARCAL™ 211	0.06	1.56	0.64	0.011	0.008	-
BLUESHIELD™ 8	0.06	1.46	0.56	0.011	0.007	-
CO ₂	0.06	1.39	0.45	0.012	0.008	-

TYPICAL MECHANICAL PROPERTIES*

	As Welded		
	ARCAL™ 211	BLUESHIELD™ 8	CO ₂
Tensile Strength MPa (ksi)	634 (92)	634 (91.9)	570 (82.6)
Yield Strength MPa (ksi)	541 (78.4)	548 (79.5)	479 (69.4)
Elongation in 50 mm – 2 in (%)	25	24	25
Impact (Charpy V-notch) @ -30°C (-20°F)	35 J (26 ft-lb)	32 J (24 ft-lb)	38 J (28 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-37960823
1.6	1/16				BLU-37971415
1.6	1/16	27.2	60	Coil	BLU-37971434
2.0	5/64				BLU-37971435
2.4	3/32				BLU-37971436
1.6	1/16	280	616	Reel	BLU-37971409
2.0	5/64				BLU-37971401
2.4	3/32				BLU-37971403
1.6	1/16	226.8	500	Drum	BLU-37960855
2.4	3/32				BLU-37960857