

Flux

Classification

Flux 781	EN 760 :	S A ZS 1 87 AC H5	
Flux/Wire	AWS A5.17 / A5.23		EN 756 : TR
781 / L-61	F7A0-EM12K		S 4T 2 ZS S2Si
781 / L50M (LNS 133U)			S 4T 2 ZS S3Si
781 / LNS 140A			S 4T 2 ZS S2Mo

General description

Active flux for limited pass welding
 Very high speed on sheet metal
 Good impact in two-run technique
 High speed fillet weld with very good bead profile
 Shiny and smooth appearance

Approvals

Wire grade	BV	ABS	LRS	DNV	RINA	TÜV
L50M (LNS 133U)	A4YT	4Y400T	3YT	3YT	3YT	
L-60						X
L-61						X

Chemical composition (w%), typical, all weld metal

Wire grade	C	Mn	Si	P	S	Mo
L-61	0.05	1.3	0.9	0.03	<0.02	
L50M (LNS 133U)	0.06	1.6	1	0.03	<0.02	
LNS 140A (L-70)	0.06	1.3	0.9	0.03	<0.02	0.4

Mechanical properties, typical, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Impact ISO-V(J) -20°C
L-61	TR	> 420	> 540	50
L50M (LNS 133U)	TR	> 450	> 560	60
LNS 140A (L-70)	TR	> 490	> 580	65

TR: two-run

781: rev. EN 23

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request

Suggestions for use

Wire	Characteristics	Applications
L-61	High speeds on clean plate	Single pass or limited passes
L50M (LNS 133U)	Very high speeds	Best results with clean plates and high Si/Mn wires
LNS 140A	Good impact toughness	

Materials to be welded

STEEL / STANDARD	TYPE	Limited passes		
		L61	L50M (LNS133U)	LNS140A (L-70)
Ship plates				
	A to D, AH32 to DH40	x	x	x
	A to E, AH32 to EH40			x
General Structural steel				
EN 10025 part 6	500 & 550 A	x	x	x
	500 & 550 A & AL			x
EN 10025 part 3/part 4	S275 to S460 N/M	x	x	x
	S275 to S460 all qualities			x
EN 10149	S315 to S600 MC & NC	x	x	x
EN 10025 part 2	S185 to S360 all qualities	x	x	x
Boiler & pressure vessel steel				
EN 10028	P235 to P460, (GH, N NH, M, ML1)	x	x	x
	P235 to P460 all qualities			x
EN 10207	P235 to P275 S	x	x	x
A36-601 & NF A36-605	A37 to A52 (CP, AP)	x	x	x
	A37 to A52 (CP, AP, FP)			x

Flux characteristics

Current type	DC / AC
Basicity (Boniszewski)	0,7
Solidification speed	fast, fluid slag
Density (kg/dm ³)	1,5
Grain size	1-16

Packaging and available sizes

Unit	Net weight (kg)
Bag	25
Sahara ReadyBag™ (SRB)	25
Steel drum	250