

Flux

Classification

Flux 888	EN 760 :	S A FB 1 66 AC H5
Flux/Wire	AWS A5.17 / A5.23	EN 756 : MR
888/L-61 (LNS 129)	F7A8-EM12K	S 38 6 FB S2Si
888/L50M (LNS 133U)	F7A6/F7P8-EH12K	S 42 6 FB S3Si
888/ LNS 140A	F8A4-EA2-A2	S 46 4 FB S2Mo
888/ L-70	F8A4-EA1-A2	S 46 4 FB S2Mo
888/LNS 160	F7A8/P8-ENi1-Ni1	
888/LNS 162	F8A8/F7P8-ENi2-Ni2	
888/LNS 164 (LA84)	F10A4/F9P6-EF3-F3	S 50 4 FB S3Ni1Mo
888/LNS 165 (LA85)	F8A6/F7P8-ENi5-Ni5	S 50 4 FB Sz
888/LNS 150 (LA92)	F7P6-EB2-B2	S 50 2 FB CrMo1
888/LNS 151 (LA93)	F8P6-EBR3-B3R H4	
888/LA100	F10A4-EM2-M2	S 50 4 FB S3Ni1,5Mo

General description

Basic flux designed for carbon and low alloy steels

Easy slag removal in deep groove

Robust mechanical properties including CTOD values

Bruscato factor typically below 10 ppm with LNS150 & LNS151 wires

Excellent in multi arc configurations

Only available in Sahara ReadyBag™

Approvals

Wire grade	TUV
L-61	x

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

Wire grade	C	Mn	Si	P	S	Ni	Mo	Cr	Bruscato factor
L-61	0.08	1.05	0.37	<0.02	<0.015				
L50M (LNS 133U)	0.07	1.45	0.55	<0.02	<0.015				
LNS 140A (L-70)	0.07	1.0	0.35	<0.02	<0.015		0.4		
LNS 160	0.07	1.2	0.4	<0.02	<0.015	0.95			
LNS 162	0.07	1.1	0.4	<0.02	<0.015	2.1			
LNS 164	0.08	1.7	0.5	<0.02	<0.01	0.9	0.5		
LNS 165	0.06	1.50	0.5	<0.02	<0.015	0.97	0.2		
LNS 150	0.069	0.90	0.5	<0.02	<0.015		0.56	1.34	<10 ppm
LNS 151	0.062	0.85	0.3	<0.02	<0.015		0.93	2.15	<10 ppm
LA100	0.06	1.60	0.7	<0.02	<0.015	1.8	0.42	0.08	

Mechanical properties, typical, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)			
					-30°C	-40°C	-50°C	-60°C
L-61	AW	415	515	31		135		125
L50M (LNS 133U)	AW	480	580	29				70
	SR	430	550	31		105		65
LNS 160	AW	470	550	26		115		
	SR	410	510	27		160		120
LNS 162	AW	500	580	25		100		55
	SR	440	550	25		160		120
LNS 164 (LA84)	AW	650	750	21		65		30
	SR	610	700	23		65		30
LNS 165 (LA85)	AW	530	620	26		70		40
	SR	495	595	27				70
LNS 150 (LA92)	SR	420	580	26		150	115	110
LNS 151 (LA93)	SR	530	645	23		125	70	50
LA100	AW	680	760	25		50		

AW : As welded - SR: Stress relieved

888: 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

Boiler and pressure vessels
Off-shore applications
Wind towers
Structural fabrications

Materials to be welded

STEEL / STANDARD	TYPE	Multirun																
		L61		L50M (LNS133U)		LNS164		LNS165		LNS150		LNS151		LNS160		LNS 162		LA100
		AW-60°	AW-60°	SR-60°	AW-40°	AW-40°	SR-60°	SR-50°	SR-50°	AW	SR	AW	SR	AW	SR	AW-40°		
Ship plates																		
	A to E	x	x	x														
	AH(32),DH(36), EH(36)	x	x	x	x	x	x					x	x	x	x			
General Structural steel																		
EN 10025 part 2	S185, S235, S275	x	x	x														
	S355	x	x	x	x	x	x					x	x	x	x			
Cast steel																		
EN 10213-2	GP240R	x	x	x														
Pipe material																		
EN 10208-2	L210, L240, L290	x	x	x														
	L360	x	x	x	x	x	x					x	x	x	x			
	L415			x	x	x	x											
	L445, L480				x	x	x											
EN 10216-1/10217-1	P235, P275	x	x	x														
	P355	x	x	x	x	x	x					x	x	x	x			
Boiler & pressure vessel steel																		
EN 10028-1	P235GH, P265GH, P295GH	x	x	x														
EN 10028-2	16 Mo 3						x	x									x	
(Elevated temperature steel)	13CrMo 4-5								x	x								
	10CrMo 9-10								x	x								
EN 10028-4/10222-3	11MnNi5-3, 13MnNi6-3						x	x				x	x	x	x		x	
Fine grained steel																		
EN 10025 part 3/part 4	S275	x	x	x														
	S355	x	x	x	x	x	x					x	x	x	x			
	S420		x		x	x	x							x	x			
	S460				x	x	x											
High yield strength steel																		
EN 10025 part 6	S460, S500				x	x	x					x	x	x	x			

Flux characteristics

Current type	AC/DC (+/-)
Basicity (Boniszewski)	2,6
Density (kg/dm ³)	1,2
Grain size	2-20

Packaging and available sizes

Unit	Net weight (kg)
Sahara ReadyBag™ (SRB)	25

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