

Flux

Classification

Flux 960	EN 760 :	S A AB 1 66 AC H5	
Flux/Wire	AWS A5.17	EN 756 : MR	EN 756 : TR
960 / L-61	F7A2-EM12K	S 38 2 AB S2Si	S 3T 2 AB S2Si
960 / L50M (LNS 133U)	F7A2-EH12K	S 38 2 AB S3Si	S 3T 2 AB S3Si
960 / LNS 163	F7A4-EG	S 42 4 AB S2Ni1Cu	

General description

General purpose neutral flux

Attractive as the "one-flux" in the shop

Very good results in semi-automatic submerged arc welding

Very good operating characteristics (deslagging - wash in - aspect)

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

Wire grade	C	Mn	Si	P	S
L-61	0.07	1.3	0.4	<0.030	<0.025
L50M (LNS 133U)	0.07	1.6	0.6	<0.030	<0.025

Mechanical properties, typical, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
					-20°C	-40°C
L-61	AW	420	510	28	50	
L50M (LNS 133U)	AW	430	530	28	70	
LNS 163	AW	460	540	27		55

AW : As welded

960: rev. EN 23

Suggestions for use

Wire	Characteristics	Applications
L50M (LNS133U)	For dirty plates	Fillet welds
L-61	General purpose	Butt welds (single pass and multi-run)

Materials to be welded

STEEL / STANDARD	TYPE	Multirun		Two-run	
		L61	L50M (LNS133U)	L61	L50M (LNS133U)
Ship plates					
	A to E	x	x	x	x
	AH(32),DH(36), EH(36)	x	x	x	x
General Structural steel					
EN 10025 part 2	S185, S235, S275	x	x	x	x
	S355	x	x	x	x
Cast steel					
EN 10213-2	GP240R	x	x	x	x
Pipe material					
EN 10208-2	L210, L240, L290	x	x	x	x
	L360	x	x	x	x
	L415		x		
API 5LX	X42, X46	x	x	x	x
	X52	x	x	x	x
	X56, X60		x		
EN 10216-1/10217-1	P235, P275	x	x	x	x
	P355	x	x	x	x
Boiler & pressure vessel steel					
EN 10028-1	P235GH, P265GH, P295GH	x	x	x	x
	P355GH	x	x	x	x
Fine grained steel					
EN 10025 part 3/part 4	S275	x	x	x	x
	S355	x	x	x	x
	S420		x		

Flux characteristics

Current type	DC (+/-); AC
Basicity (Boniszewski)	1
Solidification speed	high
Density (kg/dm ³)	1,4
Grain size	1-16

Packaging and available sizes

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