

Flux

Classification

Flux 980	EN 760 :	S A AR/AB 1 57 AC H5	
Flux/Wire	AWS A5.17	EN 756 : MR	EN 756 : TR
980/L-61	F7A2-EM12K	S 38 2 AR / AB S2Si	S 3T 2 AR/AB S2Si
980/L50M (LNS133U)	F7A2-EH12K	S 38 2 AR / AB S3Si	S 4T 2 AR/AB S3Si

General description

Outstanding slag removal, also in narrow grooves

Multi purpose flux

Suitable for semi-automatic submerged arc welding

Attractive as the "one-flux" in the shop

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

Wire grade	C	Mn	Si	P	S
L-61	0.06	1.5	0.3	<0.020	<0.020
L50M (LNS 133U)	0.06	1.9	0.4	<0.020	<0.020

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
L-61	AW	420	520	29	50
L50M (LNS 133U)	AW	460	550	29	60

AW : As welded

980: rev. EN 23

Suggestions for use

Wire	Applications
L-61	Lower cost combination
L50M (LNS133U)	For the best operating characteristics For the best impact values in multi-pass (AW or SR)

Materials to be welded

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

Flux characteristics

Current type	DC (+/-) ; AC
Basicity (Boniszewski)	0,6
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