

Flux (Pipemill)

Classification

Flux P223	EN 760 :	S A AB 1 67 AC H5
Flux/Wire	AWS A5.17 / A5.23	EN 756 : TR
P223 / L-61	F7A4-EM12K	S 4T 2 AB S2Si
P223 / L50M (LNS133U)	F7A5-EH12K	S 4T 2 AB S3Si
P223 / LNS 140A	F8A4-EA2-A2	S 4T 4 AB S2Mo

General description

Aluminate basic agglomerated flux

Good impact values in two-run and multi-run technique

Low hydrogen content

Very suitable for longitudinal and spiral pipe welding

Usable up to 3 wire systems

Chemical composition (w%)

Wire grade	C	Mn	Si	P	S	Mo	Ni
L-61	0.08	1.0	0.2	<0.02	<0.015		
L50M (LNS 133U)	0.07	1.4	0.3	<0.02	<0.015		
LNS 140A (L-70)	0.08	0.9	0.2	0.03	<0.025	0.4	
LNS 160	0.07	1.0	0.1	0.02	0.015		1
LNS 162	0.08	1.0	0.1	0.02	0.015		2
LNS 165 (LA85)	0.07	1.3	0.2	0.02	0.015	0.2	0.9
LNS T55	0.08	1.7	0.7	<0.015	<0.015		

Remark: the chemical composition from butt welds in pipe depends on the chemical composition of base material.

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	-40°C
L-61	TR	450	550	60	
L50M (LNS 133U)	TR	470	570	80	
LNS 140A (L-70)	TR	500	600		60

TR: two-run

P223: rev. EN 21

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

Single/ multi wire welding
Longitudinal and spiral pipe welding

Materials to be welded

STEEL / STANDARD	TYPE	Two-run
		LNS140A (L-70) AW
General Structural steel		
EN 10025 part 6	S200A	x
EN 10025 part 3/part 4	S275 to 460 N, NL, M & ML	x
EN10149	S315 to S500MC & NC	x
EN 10025 part 2	S185, S235, S275, S355	x
Pipe material		
API 5LX	X 42 to X70	x
Boiler & pressure vessel steel		
EN 10028-1	P235 to P460 all qualities	x
EN 10207	P235 to P275 S & SL	x
A36-601 & NF A36-605	A37 to A52 CP, AP & FP	x
EN 10222	P285 & P420 all qualities	x
Offshore plates		
A36-212	PF 24 to PF 36 all qualities	x

Flux characteristics

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

Packaging and available sizes

Unit	Net weight (kg)
Bag	25
Sahara ReadyBag™ (SRB)	25
Big Bag	500
Big Bag	600
Big Bag	1000