

## Flux

### Classification

Flux 761	EN 760:	A CS/MS 1 88 AC H5	
Flux/wire	AWS A5.17 / A5.23	EN 756 : MR	EN 756 : TR
761 / L60	F7A2-EL12	S 38 2 MS S1	
761 / L61	F7A2-EM12K	S 42 2 MS S2Si	S 4T 0 MS S2Si
761 / L70 (LNS140A)	F9A0-EA1-G	S 50 0 MS S2Mo	S 4T 2 MS S2Mo

### General description

High current capacity

Active flux for limited pass welding

High restraint cracking resistant

Suitable for rusty/dirty plates (at high current)

Applicable for low quality steels

Note: Use another flux for thin plates and multi-pass welding of thick plates (without particular caution)

### Approvals

Wire grade	ABS	BV	CRS	CTL	DB	DNV	PRS	GL	LR	RINA	RMRS	TüV	UDT
L-60					x							x	x
L-61	x		x	x		x	x	x	x	x	x	x	x
L-70 (LNS 140A)	x	x		x		x	x	x	x	x	x	x	

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

Wire grade	C	Mn	Si	P	S	Mo
L61	0.05	1.8	0.9	<0,03	<0,025	
L70 (LNS 140A)	0.05	1.6	0.65	<0,03	<0,025	0.4

### Mechanical properties, all weld metal

Wire grade	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Impact ISO-V(J)	
				0°C	-20°C
L60	MR	380	500	80	50
L61	MR	440	530	100	50
	TR	>420	>520	50	
L70 (LNS 140A)	MR	480	600	80	40
	TR	>420	>520	100	50

MR : multi run

TR : two run

## Suggestions for use

Wire	Characteristics	Applications
L60	Lowest cost combination	Flat fillet, large throat
L61	Reliable properties	Butt joints in two passes, in medium and thick plates
L70	For good impact toughness as welded TR could be selected	Flux backing, modified series arc-welding Low quality steels

## Materials to be welded

	MR		L70 / LNS 140A	TR		L70 / LNS 140A
	L60	L61		L60	L61	
A to D, A (H) 32 to D(H) 36	x	x				x
A 32 to AH36	x	x	x	x	x	x
500 A						x
S275 to S420, N,M	x	x				x
S315 to S420, MC	x	x	x	x	x	x
S315 to S420, NC	x	x				x
S460, MC & NC						x
S185 to S355, E295 to E360, JR(G1 & G2), JO	x	x	x	x	x	x
S185 to S355, E295 to E360, J2 (G3&G4)	x	x				x
P235 to P420, GH	x	x	x	x	x	x
P235 to P420, GH N, NH, M, Q & QH	x	x				x
P235 to P460, GH, N, NH, M, Q & QH	x	x				x
P500, GH, N, NH, M, Q & QH						x
P235 S, P265 S	x	x				x
A37 to A52, CP	x	x	x	x	x	x
A37 to A52, CP, AP	x	x				x

## Flux characteristics

Max current, one wire (A)	800
Current type	DC (+,-) / AC
Basicity (Boniszewski)	1
Solidification speed	Low, slag vicious
Density (kg/dm <sup>3</sup> )	1.2
Grain	1 - 16

## Packaging

Unit	Net weight (kg)
Bag	25
Steel drum	250
Big Bag	1000