Flux

Classification

Flux 782	EN 760 :	A AR/AB 98 AC H5	
Flux/wire	AWS A5.17 / A5.23	EN 756 : TR	EN 756 : MR
782 / LNS135	F7AZ-EM12	S 4T Z AR/AB S2	
782 / L61	F7AZ-EM12K	S 4T 0 AR/AB S2Si	S 46 0 AR/AB S2Si
782 / L60		S 4T A AR/AB S1	S 42 A AR/AB S1
782 / L50M		S 5T 2 AR/AB S3Si	S 50 0 AR/AB S3Si
782 LNS 140A		S 5T 2 AR/AB S2Mo	S 46 0 AR/AB S2Mo

General description

Active flux for limited pass welding
Good bead shape with optimum wetting
High speed on thin plates
Mono & multi-electrode welding

Approvals

Wire grade	BV	ABS	LRS	DNV	RINA
L50M (LNS133U)	3YT+	4Y400T	4YT	4Y40T	3YT

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

Lincoln wire	C	Mn	Si	P	S	Mo
LNS135	0.07	1.15	0.7	<0.030	<0.025	-
L61	0.07	1.15	0.8	<0.030	<0.025	-
L60	0.07	1	0.6	<0.030	<0.025	-
L50M (LNS133U)	0.06	1.7	1	<0.030	<0.025	-
L70 (LNS140A)	0.07	1.2	0.7	<0.030	<0.025	0.4

SAW

Mechanical properties, all weld metal

Wire grade	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)
LNS135	TR	> 520	
L60	TR	> 520	40J to 0°c
L61	TR	> 520	50J to 0°c
L50M (LNS133U)	TR	>600	55J to -20°c
L70 (LNS140A)	TR	>600	63J to -20°c

* TR : thickness 20, S355 plate grade

LINCOLN ELECTRIC

FX 782

Suggestions for use

Wire	Characteristics :	Applications
LNS135	Lowest cost combination	Fillet weld, lap joint
L61	Excellent properties	- truck wheels
L50M	very high speeds	- gas bottles
		- Tube to fin fillet weld
		- Boiler tubes

Materials to be welded

	LNS135	L50M (LNS133U)	L61	L70 (LNS140A)
A, AH32 to AH40		x	x	
S315 à S460 MC	x	x	x	
S185 à S355 JR quality(G1 & G2)	x	x	x	
S185 à S355 JR quality((G1 & G2), J0		x	x	
E295 à E360	x	x	x	
P235 to 275 GH		x	x	
P355 to P460 M		x	x	
A37 to A52 CP		x	x	
15Mo3,16Mo3,17Mo3,14Mo6				x

Flux characteristics

Max current, one wire (A)	800
Currrent type	DC (+,-) / AC
Basicity (Boniszewski)	0.4
Solidification speed	high speed
Density (kg/dm3)	1.4
Grain	1 - 1,6

Packaging

Unit	Net weight (kg)
Bag	25

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