

Flux

Classification

Flux 8500	EN 760 :	A FB1 54 AC H5	
Flux/wire	AWS A5.17 & A5.23	EN756 MR	EN756 TR
8500 / L61	F7A6-EM12K	S 38 4 FB S2Si	S 4T 0 FB S2Si
8500 / L50M (LNS133U)	F7A6-EH12K	S 42 6 FB S3Si	S 4T 2 FB S3Si
8500 / L70 (LNS140A)	F8A6-EA1-A2	S 46 4 FB S2Mo	S 4T 4 FB S2Mo
8500 / LNS140TB			S 4T 4 FB SO

General description

Basic flux designed for the welding of carbon and low alloy steels

Excellent welding characteristics over a wide range of welding procedures

Superior mechanical properties

- Readily meets impact requirements at -50°C
- Impact properties are consistent throughout the weld joint, including the cap location
- Excellent CTOD values

Approvals

Wire grade	BV	ABS	LR	DNV	GL	RINA	UDT
L61			x				
L50M (LNS133U)	x	x	x	x			x
L70 (LNS 140A)		x			x	x	
LNS140TB	x						

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

Lincoln wire	C	Mn	Si	P	S	Mo	B	Ti
L61	0.07	0.9	0.2	0.03	0.025			
L50M (LNS133U)	0.07	1.4	0.3	0.03	0.025			
L70 (LNS140A)	0.07	0.9	0.1	0.03	0.025	0.4		
LNS 140TB	0.06	1.2	0.2	0.03	0.025	0.4	0.005	0.02

Mechanical properties, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Impact ISO-V(J)	
				-20°C	-60°C
L61	MR	430	510	150	100
L50M (LNS133U)	MR	440	540		140
	TR	> 420	> 520	100	
L70 (LNS140A)	MR	440	540		100
	TR	> 420	> 520		100
LNS140TB	TR	> 420	> 520		50

MR : multi run

TR : two run

FX 8500: rev. EN 15

Suggestions for use

Characteristics :	Applications
Off-shore and on-shore applications	Suitable for semi narrow gap welding
Nuclear components	Low temp. equipment
High purity weld metal and high toughness	Highly restraint constructions
Long stick-out welding	Single- and multi-wire systems

Materials to be welded

	MR	TR		
	L61	L50M (LNS133U)	L70 (LNS140A)	LNS140TB
A to E	x	x	x	x
AH 32 to FH40	x	x	x	x
500 all qualities				x
S275 to S420 all qualities	x	x	x	x
S460 all qualities			x	x
S315 to S420 all qualities	x	x	x	x
S460 to S650 all qualities				x
S185 to S355 all qualities	x	x	x	x
E295	x	x	x	x
E335 & E360				x
P235 to P420 all qualities	x	x	x	x
P460 all qualities				x
P235 to P275 all qualities	x	x	x	x
A37 to A52 all qualities	x	x	x	x

Flux characteristics

Max current, one wire (A)	800
Current type	DC (+, -) / AC
Basicity (Boniszewski)	2.8
Solidification speed	neutral
Density (kg/dm ³)	1.3
Grain	2 - 20

Packaging

Unit	Net weight (kg)
Bag	25