

Flux

Classification

Flux 860	EN 760 :	A AB1 56 AC H5	
Flux/wire	AWS A5.17 & A5.23	EN756 : TR	EN756 : 2 passes
860 / L60	F6A2-EL12	S 35 2 AB S1	
860 / LNS135	F6A2-EM12	S 35 2 AB S2	S 3T 0 AB S2
860 / L61	F7A2-EM12K	S 38 2 AB S2Si	S 3T 0 AB S2Si
860 / L70 (LNS140A)	F7A2-EA1-A2	S 42 2 AB S2Mo	S 4T 2 AB S2Mo

General description

Multi purpose neutral agglomerated flux
Good impact values in both multi-run (with L60/L61/L50M)
and two-run (with wire L-70) technique
High restraint cracking resistant
Very good results in multi-run with flux cored wire LNS T55

Approvals

Wire grade	LR	BV	ABS	DNV	GL	Controlas	TUV	DB	UDT	DWI	RMRS	RINA
L60							x		x			
LNS 135	x			x	x		x	x	x			
L61	x	x	x	x	x	x	x	x	x	x	x	x
L50M (LNS133U)		x				x			x			
L70 (LNS 140A)	x	x		x	x		x		x			

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

Lincoln wire	C	Mn	Si	P	S	Mo
L60	0.05	1.0	0.2	<0.030	<0.020	
LNS135	0.06	1.3	0.25	<0.030	<0.020	
L61	0.07	1.3	0.4	<0.030	<0.020	
L50M (LNS133U)	0.07	1.7	0.5	<0.030	<0.020	
L70 (LNS140A)	0.07	1.3	0.25	<0.030	<0.020	0.4

Mechanical properties, all weld metal

Wire grade	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Impact ISO-V(J)	
			0°C	-20°C
L60	360	480	80	50
LNS135	390	490	100	50
L61	430	510	100	50
L50M (LNS133U)	460	530	120	80
L70 (LNS140A)	520	570	80	50

Suggestions for use

Wire	Characteristics :
L60 & LNS135	Low yield strength steel
L61	Yield strength steel
L50M (LNS133U)	Yield strength steel < 460 N/mm ² and good impact toughness at -20 °C
LNS 140A (L-70)	High yield strength steel and good impact toughness in two run applications

Materials to be welded

	L61	L50M (LNS133U)
A to E	x	x
AH 32 to DH32	x	x
AH 36 to DH36		x
AH 40 to DH40		
S275&S355 (N & M)	x	x
S275&S355 (N & M)	x	x
S275 to S420N		
S275 to S420 M		
S275 to S460N		
S275 to S460 M		
S315 & S355 MC & NC	x	x
S315 & S355 MC & NC	x	x
S315 to S420 MC & NC		
S315 to S460 MC & NC		
S315 to S500 MC & NC		
S185 & S275 JR(G1 & G2), JO, J2 (G3&G4)	x	x
S185 to S355 JR(G1 & G2), JO, J2 (G3&G4)		
E295		x
P235 to 275 GH, NH & NH1	x	x
P235 to P355 GH, NH , NH1 & M		x
P355 to P420 M		
P355 to P460 M		
P235 S & P265 S	x	x
A37 to A48 CP, AP	x	x
A37 to A52 CP, AP		

Flux characteristics

Max current, one wire (A)	700
Current type	DC (+,-) / AC
Basicity (Boniszewski)	1.1
Solidification speed	high
Density (kg/dm ³)	1.4
Grain	1 - 16

Packaging

Unit	Net weight (kg)
Bag	25