

Flux

Classification

Flux 888	EN760 :	S A FB 1 66 AC H5
Wire	AWS A5.17-97/A5.23-97	EN756-95:MR
888 / L61 (LNS129)	F7A8-EM12K	S 38 6 FB S2Si
888 / L50M	F7A8/F6P8-EH12K	S 42 6 FB S3Si
888 / LNS164	F10A4EF1*-EF3	S 50 4 FB S3NiMo
888 / LNS165	F8A6/F7P8-ENi5-Ni5	S 50 4 FB S0
888 / LA92	F9A4/F7P6-EB2-B2	S 50 2 FB CrMo1
888 / LA93	F8P6-EB3-B3	
888 / LA100	F10A6/F10P2-EM2-M2	S 50 4 FB S3Ni1,5Mo

General description

- Basic flux designed for the welding of carbon and low alloyed steels
- Easier slag removal in deep groove
- Robust mechanical properties
- Suited for step cooling applications
- H4 hydrogen level as per AWS A4.3-93

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

Wire grade	C	MN	Si	P	S	Ni	Mo	Cr	Bruscato factor
L61	0.08	1.05	0.37	<0,02	<0,015				
L50M (LNS133U)	0.07	1.46	0.54	<0,02	<0,015				
LNS164	0,08	1,7	0,5	<0,02	<0,010	0,90	0,5		
LNS165	0.06	1.47	0.49	<0,02	<0,015	0,97	0,2		
LA92	0.069	0.91	0.49	<0,02	<0,010		0.56	1.34	<1,1
LA93	0.062	0.86	0.31	<0,02	<0,010		0.93	2.15	<1,1
LA100	0.06	1.62	0.7	<0,02	<0,010	1.8	0.42	0.08	

Mechanical properties, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation %	Impact ISO-(VJ)			
					-30°C	-40°C	-50°C	-60°C
L61	AW	415	515	31		180		125
L50M (LNS133U)	AW	480	580	29				80
	SR	430	550	31		150		130
LS164	AW	650	750	21		65		30
	SR	630	720	23	60			
LNS165	AW	530	620	26		60		40
	SR	495	595	27				70
LA92	AW	600	700	24		47	30	
	SR	500	605	26		150	117	113
LA93	SR	530	645	23		125	70	50
	AW	680	760	25		85	60	
LA100	AW	680	750	25		52	50	30
	SR	680	750	25				

Suggestions for use

Applications
 Boiler and pressure vessel
 Offshore application
 Wind towers
 Shipbuildings
 Structural fabrication

Materials to be welded

	L61	L50M (LNS133U)	SR - MR60°	LNS164	LNS165	SR - MR60°	LA100	SR - MR20°
	AW - MR60°	AW - MR60°		AW - MR40°	AW - MR60°		AW - MR40°	
A to E	X	X	X					
AH 32, DH36, H(36)	X	X	X					
S185, S235S, S275	X	X	X					
S355	X	X	X	X	X	X		
GP240R	X	X	X					
L210, L240, L290	X	X	X					
L360	X	X	X	X	X	X		
L415		X		X	X	X		
L445, L480				X	X	X		
X42, X46	X	X	X					
X52	X	X	X	X	X	X		
X56, X60		X		X	X	X		
X65, X70				X	X	X		
X42	X	X	X					
X52	X	X	X	X	X	X		
X63		X		X	X	X		
P235, P275	X	X	X					
P355	X	X	X	X	X			
P235GH, P265GH	X	X	X					
P295GH	X	X	X					
S275	X	X	X					
S355	X	X	X	X	X	X		
S420		X		X	X	X		
S460				X	X	X		
16 Mo 3					X	X	X	X
S460, S500				X	X	X		
11MnNi5-3					X	X	X	X
13MnNi6-3								

Flux characteristics

Max current, one wire (A)	1000
Current type	DC (+, -) / AC
Basicity (Boniszewski)	2.6
Density (kg/dm ³)	1.2
Grain	2 - 20

Packaging

Unit	Net weight (kg)
Bag	25