Flux

Classification

Flux 980	EN 760 :	A AR/AB1 57 AC H5	
Flux / Wire	AWS A5.17	EN756 MR	EN756 TR
980 / L61	F7A2-EM12K	S 38 2 AR / AB S2Si	S 3T 2 AR/AB S2 Si
980 / L50M (LNS133U)	F7A2-EH12K	S 38 2 AR / AB S3Si	S 4T 2 AR/AB S3 Si

General description

Neutral flux
Outstanding slag removal, also in narrow grooves
Multi purpose flux
Suitable for semi-automatic submerged arc welding
Attractive as the “one-flux” in the shop

Approvals

Wire grade	BV	Controlas	DB	UDT
L61		x		
L50M (LNS133U)	x	x	x	x

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

Wire grade	C	Mn	Si	P	S
L61	0.06	1.5	0.3	<0.030	<0.020
L50M (LNS133U)	0.06	1.9	0.4	<0.030	<0.020

Mechanical properties, all weld metal

Wire grade	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Impact ISO-V(J) -20°C
L61	420	520	60
L50M (LNS133U)	460	550	60

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Suggestions for use

Wire	Applications
L50M	For the best operating characteristics For the best impact values in multi-pass (AW of SR)

Materials to be welded

	L50M (LNS133U)	L61
A & D	x	x
AH32 to DH40	x	x
S275 to S420 (N& M)	x	x
S275 to S460 (N& M)	x	
S315 to S420 (MC & NC)	x	x
S315 to S460 (MC & NC)	x	
S185 to S355 all qualities	x	x
P235 to P420 (GH, N, NH, ML1)	x	x
P235 to P460 (GH, N, NH, ML1)	x	
P235 to P275 S	x	x
A37 to A52 CP & AP	x	x

Flux characteristics

Max current, one wire (A)	800
Currrent type	DC (+/-), AC
Basicity (Boniszewski)	0.65
Solidification speed	HIGH
Density (kg/dm3)	1.4
Grain	1 - 16

Packaging

Unit	Net weight (kg)
Bag	25