

## Flux

### Classification

Flux 995N	EN 760 :	A AB1 67 AC H5
Flux / Wire	AWS A5.23	EN756 TR
995N / L70 (LNS140A)		S 4T 2 AB S2Mo
995N / LNS140TB	F9A2-EG-G	S 5T 5 AB S0

### General description

Application in arctic grade pipe steels up to 40mm wall thickness  
 Designed for longitudinal and spiral welded pipe lines with multiple  
 Outstanding welding characteristics and bead profile  
 Higher usable travel speeds (up to 3.5 m/min) in 5 wire systems  
 Superior mechanical properties due to lower N in weld metal  
 Very low hydrogen in the weld deposit  $H_{DM} < 5 \text{ ml/100g}$ )

### Approvals

Wire grade	UDT
L-70 (LNS140A)	x
LNS140TB	x

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

Wire grade	C	Mn	Si	P	S	Mo	Ti	B
L70 (LNS140A)	0.07	1.5	0.3	<0.025	<0.025	0.2	-	-
LNS140TB	0.06	1.6	0.3	<0.025	<0.025	0.2	0.015	0.002

### Mechanical properties, all weld metal

Wire grade	Tensile strength	Impact ISO-V(J)		
	(N/mm <sup>2</sup> )	-20°C	-40°C	-60°C
L70 (LNS140A)	> 520		60	
LNS140TB	> 600		115	60

## Suggestions for use

One run on every side in one- or multi wire systems for high welding speed in spiral weld seams

## Materials to be welded

	L70 (LNS140A)	LNS140TB
A to E	x	x
AH32 to FH40	x	x
500 to 550 A & AL	x	x
S275 to S460 all qualities	x	x
S315 to S650 all qualities	x	x
S185 to S355 all qualities	x	x
E295 to E360	x	x
P235 to P460G all qualities	x	x
P235 to P275	x	x
A37 to A52 all qualities	x	x
PF24 to PF 36 all qualities	x	x
P265 to P460 all qualities	x	x
X42 to X80	x	x

## Flux characteristics

Max current, one wire (A)	5000
Current type	DC (+/-), AC
Basicity (Boniszewski)	1.3
Solidification speed	high
Density (kg/dm <sup>3</sup> )	1
Grain	2 - 20

## Packaging

Unit	Net weight (kg)
Bag	25
Bigbag	500
Bigbag	600