

Flux

Classification

Flux P240	EN 760 :	A FB1 55 AC H5
Flux / Wire	AWS A5.17 & A5.23	EN756 : MR
P240 / L50M (LNS133U)	F7A/P8-EH12K	S 42 6 FB S3Si
P240 / L70 (LNS140A)	F7A/P4-EA1-A2	S 46 4 FB S2Mo
P240 / LNS160	F7A/P10-ENi1-Ni1	S 46 6 FB S2Ni1*
P240 / LNS162	F7A/P10-ENi2-Ni2	S 46 6 FB S2Ni2*
P240 / LNS165	F8A/P8-EG-G	S 50 6 FB S0

General description

Highly basic fluoride agglomerated flux

Reliable good impact toughness, very suitable for offshore constructions

Consistently good CTOD values with CMn and Ni-alloyed wires

Very low hydrogen content $H_{DM} < 5\text{ml}/100\text{g}$

Extra moisture resistant

Very suitable for single/multi wire welding and long stick out welding

Approvals

Wire grade	LR	BV	ABS	DNV	GL	Controlas	TUV	DB	UDT
L50M (LNS133U)	x	x	x	x	x	x	x	x	x
L70 (LNS 140A)									x
LNS160	x	x	x	x	x	x	x		x
LNS162	x	x	x	x	x	x	x		x
LNS165	x			x					x

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

Wire grade	C	Mn	Si	S	P	Ni	Mo
L50M / LNS133U	0.08	1.6	0.35	< 0.015	< 0.020		
LNS160	0.08	1	0.25	< 0.015	< 0.020	1	
LNS162	0.08	1	0.25	< 0.015	< 0.020	2.2	
LNS165	0.08	1.3	0.35	< 0.015	< 0.020	0.9	0.15

Mechanical properties, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Impact ISO-V(J) -60°C
L50M (LNS133U)	BS	460	560	40
	TT	420	540	40
LNS160	BS	470	550	80
	TT	430	490	100
LNS162	BS	480	560	100
	TT	460	530	140
LNS165	BS	520	600	60
	TT	510	580	60

Suggestions for use

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

Materials to be welded

		L50M (LNS133U)	LNS160	LNS162	LNS165
Ship plates	A to E, AH32 to EH40	x	x	x	x
General structural steel					
NF EN 10137 (A 36-204)	500 A & AL				x
NF EN10113 (A35-502)	S275 to S460 all qualities	x	x	x	x
NF EN 10149 (A36-231)	S315 to S460 MC & NC	x	x	x	x
	S315 to S500 MC & NC				x
NF EN 10025 (A35-501)	S185 to E360 all qualities	x	x	x	x
Boiler & pressure vessel steel					
NF EN 10028 (A 36-205)	P235 to P460 all qualities	x	x	x	x
NF EN 10207 (A36-220)	P235 to P275 all qualities	x	x	x	x
NF A36-601 & NF A36-605	A37 to A52 all qualities	x	x	x	x
Steel for dangerous material transportation					
NF A 36-215	P265 to P460 all qualities	x	x	x	x
Low temperature steel					
	P285 to P420 all qualities	x	x	x	x

Flux characteristics

Max current, one wire (A)	700
Current type	DC (+,-) / AC
Basicity (Boniszewski)	3
Density (kg/dm ³)	1.1
Grain	2 - 20

Packaging

Unit	Net weight (kg)
Bag	25