

Flux

Classification

Flux 781	EN 760:	A ZS1 87 AC H5	
Flux/Wire	AWS A5.17 / A5.23	EN 756 : MR	EN 756 : TR
781 / L61	F7A0-EM12K		S 4T 2 ZS S2Si
781 / L50M (LNS133U)			S 4T 2 ZS S3Si
781 / L70 (LNS140A)			S 4T 2 ZS S2Mo

General description

Active flux for limited pass welding

High speed on sheet metal

Good impact in two-pass technique

Approvals

Wire grade	BV	ABS	LR	DNV	RINA	TUV	UDT
L61						x	x
L50M (LNS133U)	x	x	x	x	x		x

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

Wire grade	C	Mn	Si	P	S	Mo
L61	0.05	1.3	0.9	0.03	0.02	
L50M (LNS133U)	0.06	1.6	1	0.03	0.02	
L70 (LNS140A)	0.06	1.3	0.9	0.03	0.02	0.4

Mechanical properties, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Impact ISO-V(J) -20°C
L61	TR	> 420	> 520	50
L50M (LNS133U)	TR	> 420	> 520	50
L70 (LNS140A)	TR	> 420	> 520	50

MR : multi run

TR : two run

Suggestions for use

Wire	Characteristics	Applications
L61	high speed on clean plate	Mainly single pass or limited pass
L50M (LNS133U)	very high speeds	High speed on clean plate (tandem up to 12mm thickness)
L70 (LNS140A)	good impact	Good impact with single pass and two run with wire L-70

Materials to be welded

	L61	L50M (LNS133U)	L70 (LNS140A)
A to D, AH32 to DH40	x	x	x
A to E, AH32 to EH40			x
500 & 550 A	x	x	x
500 & 550 A & AL			x
S275 to S460 N/M	x	x	x
S275 to S460 all qualities			x
S315 to S600 MC & NC	x	x	x
S185 to S360 all qualities	x	x	x
P235 to P460 (GH, N NH, M, ML1)	x	x	x
P235 to P460 all qualities			x
P235 to P275 S	x	x	x
A37 to A52 (CP, AP)	x	x	x
A37 to A52 (CP, AP, FP)			x

Flux characteristics

Max current, one wire (A)	700
Current type	DC (+,-) / AC
Basicity (Boniszewski)	0.7
Solidification speed	fast, very fluid slag
Density (kg/dm ³)	1.5
Grain	1 - 16

Packaging

Unit	Net weight (kg)
Bag	25
Steel drum	250