

Flux

Classification

Flux 960	EN 760 :	A AB1 66 AC H5	
Flux / wire	AWS A5.17	EN756 : MR	EN756 : TR
960 / L61	F7A2-EM12K	S 38 0 AB S2Si	S 3T 0 AB S2Si
960 / L50M (LNS133U)	F7A2-EH12K	S 38 0 AB S3Si	S 3T 0 AB S3Si

General description

General purpose neutral flux

Attractive as the "one-flux" in the shop

Very good results in semi-automatic submerged arc welding

Very good operating characteristics (deslagging - wash in - aspect)

Approvals

Wire grade	UDT
L61	+
L50M (LNS133U)	+

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

Wire grade	C	Mn	Si	P	S
L61	0.07	1.3	0.4	<0.030	<0.025
L50M (LNS133U)	0.07	1.6	0.6	<0.030	<0.025

Mechanical properties, all weld metal

Wire grade	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Impact ISO-V(J) 0°C
L61	420	510	60
L50M (LNS133U)	430	530	60

Suggestions for use

Wire	Characteristics :	Applications
L50M	For dirty plates	Fillet welds
L61	General purpose	Butt welds (single pass and multi-run)

Materials to be welded

	L61	L50M (LNS 133U)
A, D	x	x
AH32 to DH36	x	x
S275 to S355 N & M	x	x
S275 to S420 N & M	x	x
S315 to S355 MC & NC	x	x
S315 to S420 MC & NC	x	x
S185 to S355 all qualities	x	x
E295 to E360	x	x
P235 to P355 GH, NH, M & Q	x	x
P235 to P420 GH, NH, M & Q	x	x
P235 S to P275 S	x	x
A37 to A52 CP & AP	x	x

Flux characteristics

Max current, one wire (A)	800
Current type	DC (+/-) AC
Basicity (Boniszewski)	1.1
Solidification speed	high
Density (kg/dm ³)	1.4
Grain	1 - 16

Packaging

Unit	Net weight (kg)
Bag	25