

Flux

Classification

Flux 998N	EN 760 :	A AB1 67 AC H51
Flux / Wire	AWS A5.23	EN756 TR
998N / L70 (LNS 140A)		S 4T 2 AB S2Mo
998N / LNS 140TB	F9A2-EG-G	S 5T 5 AB S0

General description

998N is a neutral, agglomerated flux intended for the double submerged arc welding (DSW) of longitudinal seam pipe with a wall thickness greater than 7mm. It can be used with up to 5 arcs. When welded in conjunction with LNS 140TB wire, it provides excellent CVN impact toughness even at very low temperature (-60°C)

Approvals

Wire grade	Controlas	UDT
LNS165	x	x

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

Wire grade	C	Mn	Si	P	S	Ni	Mo
LNS160	0.07	1.0	0.1	0.02	0.015	1	
LNS162	0.08	1.0	0.1	0.02	0.015	2	
LNS165	0.07	1.3	0.2	0.02	0.015	0.9	0.2

Mechanical properties, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Impact ISO-V(J)	
				-40°C	-60°C
LNS160	BS	430	510	150	50
	TT	400	510	150	50
LNS162	BS	470	560	150	100
	TT	450	530	150	100
LNS165	BS	530	600	130	50
	TT	480	580	130	50

Materials to be welded

	LN160	LNS162	LNS165
A to E, AH 32 to FH 40	x	x	x
500 A & AL			x
S275 to S420 all qualities	x	x	x
S275 to S460 all qualities		x	x
S315 to S420 MC & NC	x	x	x
S500 & S550 MC & NC			x
S185 to S355 all qualities	x	x	x
E295 & E335	x	x	x
S235 & S355	x	x	x
P235 to P355 all qualities	x	x	x
P460 all qualities			x
P235 to P275 all qualities	x	x	x
A 37 to A52 all qualities	x	x	x
PF 24 to PF36 all qualities	x	x	x
P265 to P440 all qualities	x	x	x
P285 to P420 NH & QH	x	x	x

Flux characteristics

Max current, one wire (A)	800
Current type	DC (+/-), AC
Basicity (Boniszewski)	2.8
Solidification speed	neutral
Density (kg/dm ³)	1.3
Grain	2 - 20

Packaging

Unit	Net weight (kg)
Bag	25
Big bag	1000