

Flux

Classification

Flux P223	EN 760 :	A AB1 67 AC H5	EN756 : TR
Flux / Wire	AWS A5.17 & A5.23	EN756 : MR	S 4T 2 AB S2Si
P223 / L61	F7A4-EM12K	S 38 4 AB S2Si	S 4T 2 AB S3Si
P223 / L50M (LNS133U)	F7A5-EH12K	S 42 4 AB S3Si	S 4T 4 AB S2Mo
P223 / L70 (LNS140A)	F8A4-EA1-A2	S 46 4 AB S2Mo	S 4T 5 AB S0
P223 / LNS140TB			

General description

High quality basic agglomerated flux
 Good impact toughness in two run and multi-run technique
 Very low hydrogen content
 Extra moisture resistant
 Very suitable for longitudinal and spiral pipe welding

Approvals

Wire grade	UDT
LNS135	+
L61	+
L70 / LNS 140A	+

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

Wire grade	C	Mn	Si	P	S	Mo	Ni
L61	0.07	1.4	0.4	<0.030	<0.020		
LNS135	0.07	1.4	0.25	<0.030	<0.020		
L70 (LNS140A)	0.07	1.3	0.3	<0.030	<0.020	0.5	
L50M (LNS133U)	0.07	1.9	0.4	<0.030	<0.020		
LNS160	0.07	1.4	0.25	<0.030	<0.020		1.2

Mechanical properties, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Impact ISO-V(J)	
				-20°C	-40°C
L61	TR			60	
L50M (LNS133U)	MR	480	580		80
L50M (LNS133U)	TR			80	
L70 (LNS140A)	MR	540	620	100	
L70 (LNS140A)	TR				50
LNS140TB	TR				50

TR : two run

Suggestions for use

Single/ multi wire welding
Longitudinal and spiral pipe welding

Materials to be welded

	Multi-run		Two run		
	L61	L50M (LNS133U)	L70 (LNS140A)	L70 (LNS140A)	LNS140TB
A to D	x	x	x		
AH32 to DH40	x	x	x		
500 A			x	x	x
S275 to 355 N & M	x	x	x		
S275 to 420 N, NL, M & ML	x	x	x		
S275 to 460 N, NL, M & ML		x	x	x	x
S315 & S355 MC & NC	x	x	x		
S315 to S420MC & NC	x	x	x		
S315 to S460MC & NC		x	x		
S315 to S500MC & NC			x	x	x
S185 to S355 All qualities	x	x	x	x	x
P235 to P355 GH, N, NH,Q & M	x	x	x		
P235 to P420 all qualities	x	x	x		
P235 to P460 all qualities		x	x	x	x
P235 to P275 S	x	x	x		
P235 to P275 S & SL		x	x	x	x
A37 to A52 CP & AP	x	x	x		
A37 to A52 CP, AP & FP	x	x	x	x	x
PF 24 to PF 36 - 4	x	x	x		
PF 24 to PF 36 all qualities	x	x	x	x	x
P265 to P400 NJ2, NGJ2	x	x	x		
P265 to P440 All qualities	x	x	x		
P265 to P460 all qualities		x	x	x	x
X 42 to X80				x	x
P285 & P355 NH	x	x	x		
P285 & P420 all qualities	x	x	x	x	x

Flux characteristics

Max current, one wire (A)	700
Current type	DC (+,-) / AC
Basicity (Boniszewski)	1.6
Solidification speed	high
Density (kg/dm ³)	1.2
Grain	1 - 16

Packaging

Unit	Net weight (kg)
Bag	25