

CLASSIFICATION

Flux	Flux/wire		
ISO 14174 S A ZS 1 87 AC H5		AWS A5.17 / A5.23	ISO 14171-A : TR
	781 / L-60	F7A0-EL12	
	781 / L-61	F7A0-EM12K	S 4T 0 ZS S2Si
	781 / L-50M (LNS 133U)		S 4T 2 ZS S3Si
	761 / LNS 140A		S 4T 2 ZS S2Mo

GENERAL DESCRIPTION

Active flux for limited pass welding
 Very high speed on sheet metal
 Good impact in two-run technique
 High speed fillet weld with very good bead profile
 Shiny and smooth appearance

APPROVALS

Wire grade	BV	ABS	LRS	DNV	RINA	TÜV
L-50M (LNS 133U)	A3Y40T	3Y400T	3Y40T	3Y40T	3Y40T	✓
L-60						✓
L-61						✓

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Wire grade	C	Mn	Si	P	S	Mo
L-61	0.05	1.3	0.9	<0.03	<0.02	
L-50M (LNS 133U)	0.06	1.6	1.0	<0.03	<0.02	
LNS 140A (L-70)	0.06	1.3	0.9	<0.03	<0.02	0.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength [N/mm ²]	Tensile strength [N/mm ²]	Impact ISO-V(J)
				-20°C
L-61	TR	>420	>540	50
L-50M(LNS 133U)	TR	>450	>560	60
LNS 140A (L-70)	TR	>490	>580	65

* MR : Multirun - TR : Two-run

781: rev. C-EN25-01/02/16

781

EXAMPLES OF MATERIALS TO BE WELDED

Code	Type/ Steel grades	Limited passes		
		L-60	L-61	LNS 140A
Ship plates				
	A to D, AH32 to DH40	✓	✓	✓
	A to E, AH32 to EH40			✓
General structural steels				
EN 10025 part 6	500 & 500 A	✓	✓	✓
	500 & 550 A & AL			✓
EN 10025 part 3/part 4	S275 to S460 N/M	✓	✓	✓
	S275 to S460 all qualities			✓
EN 10149	S315 to S600 MC & NC	✓	✓	✓
EN 10025 part 2	S185 to S360 all qualities	✓	✓	✓
Boiler & pressure vessel steels				
EN 10028	P235 to P460, [GH, N NH, M, ML1]	✓	✓	✓
	P235 to P460 all qualities			✓
EN 10207	P235 to P275 S	✓	✓	✓
A36-601 & NF A36-605	A37 to A52 [CP, AP]	✓	✓	✓
	A37 to A52 [CP, AP, FP]			✓

FLUX CHARACTERISTICS

Current type	DC/AC
Basicity (Boniszewski)	0.7
Solidification speed	Fast, fluid slag
Density (kg/dm ³)	1.5
Grain size (ISO 14174)	1 -16

SUGGESTIONS FOR USE

Wire	Characteristics
L-60	High speeds on clean plate
L-61	Very high speeds

PACKAGING AND AVAILABLE SIZES

Unit	Net weight (kg)
Bag	25
Sahara ReadyBag™ (SRB)	25
Metal drum	250