

960

CLASSIFICATION

Flux	Flux/wire			
ISO 14174		AWS A5.17 / A5.23	ISO 14171-A : MR	ISO 14171-A : TR
S A AB 1 66 AC H5	960 / L-61	F7A2-EM12K	S 38 2 AB S2Si	S 3T 2 AB S2Si
	960 / L-50M (LNS133 U)	F7A2-EH12K	S 38 2 AB S3Si	S 3T 2 AB S3Si
	960 / LNS 163	F7A4-EG-G	S 42 4 AB S2Ni1Cu	

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)

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

Wire grade	C	Mn	Si	P	S
L-61	0.07	1.3	0.4	<0.03	<0.025
L-50M(LNS 133U)	0.07	1.6	0.6	<0.03	<0.025

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
					-20°C	-40°C
L-61	AW	420	510	28	50	
L-50M(LNS 133U)	AW	430	530	28	70	
LNS 163	AW	460	540	27		55

* AW : As welded

960: rev. EN 24

MATERIALS TO BE WELDED

Code	Type / Steel grades	Multirun		Two-run	
		L-61	L-50M (LNS 133U)	L-61	L-50M (LNS 133U)
Ship plates					
	A to E	✓	✓	✓	✓
	AH(32),DH(36), EH(36)	✓	✓	✓	✓
General structural steel					
EN 10025 part 2	S185, S235, S275	✓	✓	✓	✓
	S355	✓	✓	✓	✓
Cast steel					
EN 10213-2	GP240R	✓	✓	✓	✓
Pipe materials					
EN 10208-2	L210, L240, L290	✓	✓	✓	✓
	L360	✓	✓	✓	✓
	L415		✓		
API 5LX	X42, X46	✓	✓	✓	✓
	X52	✓	✓	✓	✓
	X56, X60		✓		
EN 10216-1/10217-1	P235, P275	✓	✓	✓	✓
	P355	✓	✓	✓	✓
Boiler & pressure vessel steel					
EN 10028-1	P235GH, P265GH, P295GH	✓	✓	✓	✓
	P355GH	✓	✓	✓	✓
Fine grained steels					
EN 10025 part 3/part 4	S275	✓	✓	✓	✓
	S355	✓	✓	✓	✓
	S420		✓		

FLUX CHARACTERISTICS

Current type	DC / AC
Basicity (Boniszewski)	1.0
Solidification speed	high
Density (kg/dm ³)	1.4
Grain size (ISO 14174)	1 -16

SUGGESTIONS FOR USE

Wire	Characteristics
L-61	General purpose
L-50M(LNS 133U)	For dirty plates

Applications

Butt welds (single pass and multi-run)
Fillet welds

PACKAGING AND AVAILABLE SIZES

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