

# Lincolnweld® 780

## Key Features

- Industry standard for submerged arc welding applications
- Fast freezing slag for easy removal and minimised spilling on circumferential welds
- Excellent bead shape and slag removal
- Good resistance to moisture contamination for reduced porosity
- Product also available in a fine grain and coarse formula
- Fine grain formula preferably used on high speed fillet welds application

## Conformances

AS/NZS ISO 14174: SA AR/AB 178 AC H5

## Recommended Wires

### Mild Steel:

Lincolnweld® L-50, L-60, L-61

## Typical Applications

- Single pass welding of mild steel
- Roundabouts with minimal spillage
- Horizontal position welding

## Product Information

**Current type:** DC/AC

**Basicity (Boniszewski):** 0.7

**Solidification speed:** High

**Density (kg/dm<sup>3</sup>):** 1.4

**Grain size (ISO 14174):** 780 : 1 - 20 / 780-CG :  
2 - 20 / 780-FG: 1 - 16

## Packaging

Package Type	Weight Kg	Part Number
Plastic Bag	25	FX780-25SRB
Steel Drum	250	111781

## Typical Test Results

Flux / Wire Combination	Weld Condition	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ °C		AWS Classification A5.17/A5.23
L-50	As Welded	520	600	27	65	-18	F7A0-EM13K
L-60	As Welded	440	520	30	88	-18	F7A0-EL12
L-61	As Welded	530	600	27	46	-29	F7A2-EM12K