P240

TOP FEATURES

- Fully basic agglomerated submerged-arc welding flux for multiple pass welding
- Excellent impact toughness properties
- Low carbon burn-off
- Recommended with Long stick-out process

CLASSIFICATION

Flux	EN ISO 14174: S A FB 1 55 AC H5

Flux/wire	EN ISO 14171-A: MR	AWS A5.17 / A5.23
P240 / L-61	S 42 4 FB S2Si	F7A6-EM12K
P240 / L-50M	S 46 6 FB S3Si	F7A8/P8-EH12K
P240 / LNS 160	S 46 6 FB S2Ni1*	F7A10/P10-ENi1-Ni1
P240 / LNS 162	S 46 6 FB S2Ni2*	F7A10/P10-ENi2-Ni2
P240 / LNS 164 (LA-84)	S 55 6 FB S3Ni1Mo0.5	F9A8/F9P8-EF3-F3
P240 / LNS 165 (LA-85)	S 50 6 FB S3Ni1Mo0.2	F8A8/P8-ENi5-Ni5
P240 / LNS 168	S 69 4 FB S3NiCr2.5Mo	F10A5-EM2-M2

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

Wire grade	C	Mn	Si	P	S	Mo	Ni	Cr
L-61	0.08	1.0	0.35	< 0.010	< 0.010	-	-	-
L-50M	0.08	1.6	0.35	< 0.020	< 0.015	-	-	-
LNS 160	0.08	1.0	0.25	< 0.020	< 0.015	-	0.9	-
LNS 162	0.08	1.0	0.25	< 0.020	< 0.015	-	2.0	-
LNS 164	0.08	1.5	0.25	< 0.020	< 0.015	0.45	0.9	-
LNS 165	0.08	1.3	0.35	< 0.020	< 0.015	0.15	0.9	-
LNS 168	0.08	1.5	0.4	< 0.015	< 0.015	0.4	2.4	0.3

- = not specified

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)			
					-20°C	-40°C	-50°C	-60°C
L-61	AW	440	530	30	115	75	60	-
L-50M	AW	460	560	28	-	110	90	70
L-50M	SR	400	540	28	-	120	110	90
LNS 160	AW	470	550	28	-	-	-	80
LNS 160	SR	430	490	32	-	-	-	100
LNS 162	AW	480	560	26	-	-	-	100
LNS 162	SR	460	530	30	-	-	-	140
LNS 164	AW	640	720	26	-	90	-	50
LNS 164	SR	590	680	28	-	100	80	60
LNS 165	AW	510	600	25	-	100	-	70
LNS 165	SR	490	580	24	-	110	-	70
LNS 168	AW	720	800	20	-	-	55	-

AW = As welded; SR = Stress relieved

- = not specified

FLUX CHARACTERISTICS

Current type	DC/AC
Basicity (Boniszewski)	3.1
Density (kg/dm³)	1.1
Grain size (EN ISO 14174)	2 - 20

AVAILABLE SIZES AND PACKAGING INFORMATION

Packaging	Weight (kg)	Item number
SRB BAG	25.0	FXP240-25SRB

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.