

Lincolnweld® L-50®

AWS EM13K • Mild Steel Solid Electrode

Conformances

AWS A5.17/A5.17M: 1997 EM13K
 MIL-E-23765/1D & 1E: MIL-70S-3
 EN 756: SZ

Recommended Fluxes

Lincolnweld® 760®, 761®, 780®, 781®, 860®, 865™, 880M®, 882™, 888™, 8500™, 960®, 980™, P223™

Key Features

- ▶ A low carbon, medium manganese, medium silicon wire
- ▶ Pair it with Lincolnweld® 980™ flux for the best flux/wire combination when semiautomatic submerged arc welding

DIAMETERS / PACKAGING

Diameter in. (mm)	60 lb (27.2 kg) Coil	600 lb (272 kg) Speed Feed® Drum	1000 lb (453 kg) Speed Feed® Drum	1000 lb (453 kg) Accu-Trak® Drum	2200 lb (998 kg) Speed Feed® Stem
1/16 (1.6)	ED011317	ED011316		ED029083	
5/64 (2.0)	ED011335		ED011334		
3/32 (2.4)	ED011328		ED011327		
1/8 (3.2)	ED011323		ED011322		ED033481
5/32 (4.0)	ED011332		ED011331		ED032997

WIRE COMPOSITION⁽¹⁾ - As Required per AWS A5.17/A5.17M:1997

	%C	%Mn	%Si	%S	%P	%Cu
Lincolnweld® L-50®	0.06-0.16	0.90-1.40	0.35-0.75	0.030	0.030	0.35

Lincolnweld® L-56®

AWS EH11K • Mild Steel Solid Electrode

Conformances

AWS A5.17/A5.17M: 1997 EH11K
 MIL-E-23765/1D & 1E: MIL-70S-6
 EN 756: EN 756 – SZ

Recommended Fluxes

Lincolnweld® 860®, 880M®, 882™, 888™, 8500™, P223™

Key Features

- ▶ A low carbon, high manganese, very high silicon wire
- ▶ Can be used with Lincolnweld® 800 series fluxes for welds requiring 480 MPa (70 ksi) tensile strength in stress relieved conditions

DIAMETERS / PACKAGING

Diameter in. (mm)	60 lb (27.2 kg) Coil	Accu-Trak® Drum		1000 lb (453 kg) Speed Feed® Reel	1000 lb (453 kg) Speed Feed® Drum	2200 lb (998 kg) Speed Feed® Stem
		500 lb (227 kg)	1000 lb (453 kg)			
1/16 (1.6)	ED011666	ED029225	ED029085			
5/64 (2.0)	ED011678			EDS01631		
3/32 (2.4)	ED011674				ED030425	
1/8 (3.2)	ED011671				ED030426	ED032998
5/32 (4.0)	EDS11677				ED028264	ED032999

WIRE COMPOSITION⁽¹⁾ - As Required per AWS A5.17/A5.17M:1997

	%C	%Mn	%Si	%S	%P	%Cu
Lincolnweld® L-56®	0.06-0.15	1.40-1.85	0.80-1.15	0.030	0.030	0.35

⁽¹⁾Single values are maximums.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

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.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

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