

# Lincolnweld® 980

## Key Features

- Combines many of the features of the 700 and 800 series fluxes and is ideal for semiautomatic submerged arc welding
- Exceptional resistance to flash-through and porosity caused by arc blow in a variety of applications
- Especially high productivity when used with Lincolnweld® LC-72 wire

## Conformances

AS/NZS ISO 14174: S A AR/AB 1

## Recommended Wires

### Mild Steel:

Lincolnweld® L-50, L-61, LC-72

### Low Alloy Steel:

Lincolnweld® LAC-Ni2, LA-75

## Typical Applications

- Semi-automatic, single and multiple pass submerged arc welding
- General purpose fabrication
- Fillet welds

## Product Information

Current type: DC / AC

Basicity (Boniszewski): 0.6

Solidification speed: high

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

## Packaging

Package Type	Weight Kg	Part Number
Bag	22.7	ED027861

## 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	430	540	31	43	-29	F7A2-EM13K-H8
L-61	As Welded	430	530	31	37	-29	F7A2-EM12K-H8
LC-72	As Welded	450	540	28	43	-29	F7A2-EC1-H8
LA-75	As Welded	510	600	28	61	-29	F7A2-ENi1K-Ni1-H8
LAC-Ni2	As Welded	540	630	25	110	-29	F8A2-ECNi2-Ni2-H8