

Lincolnweld® 781

Key Features

- Features fast follow characteristics that allow for uniform welds at high speeds without undercut or voids
- Recommended for high speed, limited pass welding on clean plate and sheet steel
- Good impact in two-run technique
- Good wetting action

Conformances

AS/NZS ISO 14174: SA ZS 1 87 AC H5

Recommended Wires

Mild Steel:

Lincolnweld® L-50, L-60, L-61

Low Alloy Steel:

Lincolnweld® L-70

Typical Applications

- Single pass welding – on clean plate and sheet metal up to 48 mm in thickness
- Hot water tanks, metal buildings and other applications requiring high speed welds

Product Information

Current type: DC/AC

Basicity (Boniszewski): 0.7

Solidification speed: Fast, fluid slag

Density (kg/dm³): 1.5

Grain size (ISO 14174): 1 -16

Packaging

Package Type	Weight Kg	Part Number
SRB	25	FX781-25SRB

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	530	610	29	38	-18	F7A0-EM13K
L-60	As Welded	460	550	29	42	-18	F7A0-EL12
L-61	As Welded	530	610	28	31	-18	F7A0-EM12K
L-70	As Welded	590	660	25	35	-18	F9A0-EA1-G