Lincolnweld® 880M

Key Features

- A basic flux which features industry proven results in multiple pass applications
- Recommended for welding with solid mild steel and low alloy electrodes, as well as Lincoln Electric's LAC series of low alloy flux-cored electrodes
- Good deep groove slag removal
- Excellent choice for single arc AC submerged arc welding

Typical Applications

- Tandem arc applications for offshore fabrication
- Joints requiring 480 MPa tensile strength after stress relief when used with L-S3, or LA-71

Conformances

AS/NZS ISO 14174: S A FB 1

Product Information

Basicity Index: 3.3

Density: 1.2 g/cm^3

Recommended Wires

Mild Steel:

Lincolnweld® LA-71, L-S3

Low Alloy Steel:

Lincolnweld® LA-85, LA-90, LA-92, LA-100, LAC-Ni2

Packaging

Package Type	Weight Kg	Part Number
Plastic bag	22.7	ED031853

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-S3	As Welded	400	510	32	264	-51	F7A6-EH12K-H8
LA-71	As Welded	480	570	29	143	-62	F7A8-EM14K-H8
LA-71	Stress Relieved	430	550	31	164	-62	F7P8-EM14K-H8
LA-85	As Welded	520	610	24	57	-51	F7A6-ENi5-Ni5-H8
LA-85	Stress Relieved	490	590	27	145	-62	F7P8-ENi5-Ni5-H8
LA-90	As Welded	580	680	26	68	-51	F9A6-EA3K-A3-H8
LA-90	Stress Relieved	520	630	28	145	-62	F8P8-EA3K-A3-H8
LA-92	Stress Relieved	460	570	28	178	-29	F7P2-EB2R-B2-H8
LA-100	As Welded	680	730	25	129	-51	F9A6-EM2-M2-H8
LAC-Ni2	As Welded	510	600	22	77	-73	F7A10-ECNi2-Ni2-H8
LAC-Ni2	Stress Relieved	480	570	28	103	-73	F7P10-ECNi2-Ni2-H8