

Lincolnweld® 960

Key Features

- Low cost, general purpose flux designed to weld butt joints and both single and multiple pass fillets
- Recommended for automatic and semi-automatic submerged arc welding
- A versatile, cost-effective flux that can be used with many alloy systems

Typical Applications

- Single and multiple pass welding
- Fillet and butt welds with unlimited plate thickness
- Can weld steel with heavy scale or rust when used with Lincolnweld® L-50 wire
- Wind towers

Conformances

AS/NZS ISO 14174: SA AB 1 66 AC H5

Product Information

Current type: DC/AC
Basicity [Boniszewski]: 1.0
Density (kg/dm³): 1.4
Grain size [ISO 14174]: 1-16
Solidification speed: High

Recommended Wires

Mild Steel:

Lincolnweld® L-50, LA-56, L-61, LA-71

Low Alloy Steel:

Lincolnweld® LA-75, LA-85

Packaging

Package Type	Weight Kg	Part Number
Plastic Bag	25	FX960-25SRB
Steel Drum	250	111835
Big Bag	1000	FX960-1T

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	460	570	27	58	-29	F7A2-EM13K
L-56	As Welded	460	590	29	65	-29	F7A2-EH11K
L-61	As Welded	420	520	32	125	-29	F7A2-EM12K
LA-71	As Welded	460	570	29	44	-29	F7A2-EM14K
LA-71	Stress Relieved	420	540	31	89	-29	F7P2-EM14K
LA-75	As Welded	480	600	30	76	-29	F8A2-ENi1K-Ni1
LA-75	Stress Relieved	420	550	29	53	-51	F7P6-ENi1K-Ni1
LA-85	As Welded	520	640	24	57	-29	F8A2-ENi5-G
LA-85	Stress Relieved	500	610	25	39	-46	F7P5-ENi5-G