

780

TOP FEATURES

- Fast freezing slag for easy removal and minimized spilling on circumferential welds.
- Excellent bead shape and slag removal.
- Good resistance to moisture contamination for reduced porosity.
- Also available in fine and coarse grain versions.

CLASSIFICATION

Flux	EN ISO 14174: S A AR/AB 1 78 AC H5		
Flux/wire	EN ISO 14171-A: MR	EN ISO 14171-A: TR	AWS A5.17 / A5.23
780 / L-60	S 42 0 AR/AB S1	S 4T 0 AR/AB S1	F7A0-EL12
780 / L-61	S 42 0 AR/AB S2Si	S 4T 2 AR/AB S2Si	F7A2-EM12K
780 / LNS 140A		S 4T 2 AR/AB S2Mo	F8A2-EA2-G
780 / L-70		S 4T 2 AR/AB S2Mo	F8A2-EA1-G

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Wire grade	C	Mn	Si	P	S	Mo
L-60	0.07	1.4	0.6	<0.03	<0.025	
L-61	0.07	1.6	0.7	<0.03	<0.025	
LNS 140A (L-70)	0.07	1.6	0.6	<0.03	<0.025	0.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) 0°C	-20°C
L-60	MR	>420	510	28	50	
L-61	TR	>420	>540	28		50
LNS 140A (L-70)	TR	>420	>550	25		60

* MR = Multi-Run; TR = Two-Run

FLUX CHARACTERISTICS

Current type	DC(+/-)/AC
Basicity (Boniszewski)	0.7
Solidification speed	High
Density (kg/dm ³)	1.4
Grain size (EN ISO 14174)	780: 1-20 / 780-CG: 2-20 / 780-FG: 1-16

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
PE BAG	25.0	110562, 110579
SRB BAG	25.0	FX780-25SRB
DRUM	250.0	111781

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

Safety Data Sheets (SDS) are available here:



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