

# Lincolnweld® 8500

## Key Features

- Capable of providing impact properties necessary for thick weld joints from root to cap pass
- Operates well on AC and multiple arcs with good resistance to nitrogen porosity
- Capable of producing weld deposits with impact properties exceeding 27J at -62°C
- CTOD data is available for this flux with many alloy systems

## Conformances

AS/NZS ISO 14174: SA FB 1 54 AC H5

## Recommended Wires

### Mild Steel:

Lincolnweld® L-56, L-61, L-53, LA-71

### Low Alloy Steel:

Lincolnweld® LA-85, LA-90, LA-92, LNS162

## Typical Applications

- Pressure vessels
- Multiple pass welding
- Single and multiple arc welding
- Fabrication of offshore drilling platforms

## Product Information

Current type: DC/AC

Basicity (Boniszewski): 2.8

Solidification speed: Medium

Density (kg/dm<sup>3</sup>): 1.3

Grain size (ISO 14174): 2 - 20

## Packaging

Package Type	Weight Kg	Part Number
Plastic Bag	25	FX8500-25SRB

## 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-56	As Welded	470	570	31	132	-62	F7A8-EH11K
L-56	Stress Relieved	430	540	33	151	-62	F7P8-EH11K
L-61	As Welded	400	480	31	168	-51	F7A6-EM12K
L-53	As Welded	460	570	29	91	-51	F7A6-EH12K
LA-71	As Welded	450	550	30	155	-62	F7A8-EM14K
LA-71	Stress Relieved	420	520	32	220	-62	F7P8-EM14K
LA-85	As Welded	510	590	29	155	-62	F8A8-ENi5-Ni5
LA-85	Stress Relieved	500	590	28	134	-51	F7P6-ENi5-Ni5
LA-90	As Welded	670	590	24	84	-29	F9A2-EA3K-A3
LNS162	As Welded	470	560		50	-60	F7A8-ENi2-Ni2
LNS162	Stress Relieved	450	530		50	-60	F7P8-ENi2-Ni2
LA-92	Stress Relieved	550	640	26	209	-18	F8P0-EB2-B2