

Lincolnweld® 860

Key Features

- Industry standard for submerged arc welding applications
- Excellent operating characteristics in a variety of general welding applications
- High restraint cracking resistant

Conformances

AS/NZS ISO 14174: SA AB 1 56 AC H5

Recommended Wires

Mild Steel:

Lincolnweld® L-50, L-56, L-60, L-61, LA-71, L-S3

Low Alloy:

Lincolnweld® L-70, LA-75, LA-85

Typical Applications

- Pipe and double ending applications
- General purpose structural and multiple pass welds
- Storage tanks

Product Information

Current type: DC/AC

Basicity (Boniszewski): 1.1

Density (kg/dm³): 1.4

Grain size (ISO 14174): 1-16

Solidification speed: High

Packaging

Package Type	Weight Kg	Part Number
Plastic Bag	25	FX860-25SRB
SRB	25	FX860-25SRB
Steel Drum	250	111828

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	430	520	30	84	-29	F2A2-EM13K
L-56	As Welded	470	590	28	61	-29	F7A2-EH11K
L-60	As Welded	370	450	34	138	-29	F6A2-EL12
L-61	As Welded	410	500	31	58	-40	F7A4-EM12K
L-S3	As Welded	500	590	28	52	-29	F7A2-EH12K
LA-71	As Welded	450	540	30	110	-29	F7A2-EM14K
LA-71	Stress Relieved	400	520	32	119	-29	F7P2-EM14K
LA-70	As Welded	450	550	28	54	-29	F7A2-EA1-A2
LA-70	Stress Relieved	430	520	31	47	-29	F7P2-EA1-A2
LA-75	As Welded	460	550	32	107	-29	F7A2-ENi1K-Ni1
LA-75	Stress Relieved	410	540	30	99	-29	F7P2-ENi1K-Ni1
LA-85	As Welded	520	600	26	38	-40	E8A4-ENi5-Ni5