

CLASSIFICATION

Flux	Flux/wire			
ISO 14174		AWS A5.17 / A5.23	ISO 14171-A : MR	ISO 14171-A : TR
S A AR/AB 1 57 AC H5	980 / L-61	F7A2-EM12K	S 38 2 AR/AB S2Si	S 3T 2 AR/AB S2Si
	980 / L-50M (LNS 133U)	F7A2-EH12K	S 38 2 AR/AB S3Si	S 4T 2 AR/AB S3Si

GENERAL DESCRIPTION

Outstanding slag removal, also in narrow grooves
Multi purpose flux
Suitable for semi-automatic submerged arc welding
Attractive as the "one-flux" in the shop

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

Wire grade	C	Mn	Si	P	S
L-61	0.06	1.5	0.3	<0.02	<0.02
L-50M(LNS 133U)	0.07	1.7	0.4	<0.02	<0.02

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
					-20°C
L-61	MR	420	520	29	50
L-50M(LNS 133U)	MR	460	550	29	60

* MR : Multirun

EXAMPLES OF MATERIALS TO BE WELDED

Code	Type / Steel grades	Multirun	
		L-61	L-50M (LNS 133U)
Ship plates			
	A to E	✓	✓
	AH(32),DH(36), EH(36)	✓	✓
General structural steels			
EN 10025 part 2	S185, S235, S275	✓	✓
	S355	✓	✓
Cast steels			
EN 10213-2	GP240R	✓	✓
Pipe materials			
EN 10208-2	L210, L240, L290	✓	✓
	L360	✓	✓
	L415		✓
API 5LX	X42, X46	✓	✓
	X52	✓	✓
	X56, X60		✓
EN 10216-1/10217-1	P235, P275	✓	✓
	P355	✓	✓
Boiler & pressure vessel steels			
EN 10028-1	P235GH, P265GH, P295GH	✓	✓
	P355GH	✓	✓
Fine grained steels			
EN 10025 part 3/part 4	S275	✓	✓
	S355	✓	✓
	S420		✓

FLUX CHARACTERISTICS

Current type	DC / AC
Basicity (Boniszewski)	0.6
Solidification speed	high
Density (kg/dm³)	1.4
Grain size (ISO 14174)	1 -16

SUGGESTIONS FOR USE

Wire	Applications
L-61	Lower cost combination
L-50M(LNS 133U)	For the best operating characteristics
	For the best impact values in multi-pass

PACKAGING AND AVAILABLE SIZES

Unit	Net weight (kg)
Bag	25