Lincolnweld® 761

TOP FEATURES

- Manganese alloying and carbon reducing flux designed to provide superior crack resistance
- Slow freezing slag for a wide, flat weld
- Excellent resistance to cracking in single pass applications
- Also suitable as backing flux for one side welding

CLASSIFICATION

Flux	EN ISO 14174: S A CS/MS 1 88 AC EN H5

Flux/wire	EN ISO 14171-A: MR	EN ISO 14171-A: TR	AWS A5.17 / A5.23
761 / L-60	S 38 2 CS/MS S1		F7A2-EL12
761 / L-61	S 42 2 CS/MS S2Si	S 4T 0 CS/MS S2Si	F7A2-EM12K
761 / LNS 140A	S 46 0 CS/MS S2Mo	S 4T 2 CS/MS S2Mo	F8A0-EA2-G
761 / L-70	S 46 0 CS/MS S2Mo	S 4T 2 CS/MS S2Mo	F8A0-EA1-G

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

Wire grade	C	Mn	Si	P	S	Mo
L-60	0.05	1.5	0.7	<0.03	<0.025	-
L-61	0.07	1.7	0.9	<0.03	<0.025	-
LNS 140A (L-70)	0.06	1.7	0.8	<0.03	<0.025	0.4

- = not specified

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) 0°C	Impact ISO-V (J) -20°C
L-60	MR	380	500	28	80	50
L-61	MR	470	560	28	100	50
L-61	TR	>420	>540	-	65	-
LNS 140A (L-70)	MR	480	600	-	80	40
LNS 140A (L-70)	TR	>440	>540	-	100	55

MR = Multi-Run; TR = Two-Run

- = not specified

FLUX CHARACTERISTICS

Current type	DC(+/-)/AC
Basicity (Boniszewski)	0.8
Solidification speed	Low, viscous slag
Density (kg/dm³)	1.2
Grain size (EN ISO 14174)	1-16

AVAILABLE SIZES AND PACKAGING INFORMATION

Packaging	Weight (kg)	Item number
PE BAG	22.7	ED032765

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.