995N

TOP FEATURES

- A nitrogen limiting flux designed for seam welding of pipes
- Recommended for automatic single pass/2-run welding with up to five arcs
- Very high current capacity

CLASSIFICATION

Flux	EN ISO 14174: S A AB 1 67 AC H5

Flux/wire	EN ISO 14171-A: TR	AWS A5.23
995N / LNS 140A	S 4T 2 AB S2Mo	F7TA4G-EA2
995N / LNS 140TB	S 5T 5 AB S2MoTiB	F9TA6G-EA2TiB
995N / LNS 133TB	S 5T 4 AB SZ	F8TA5G-EG
995N / L61	S 3T 2 AB S2Si	F6TA2G-EM12K

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

Wire grade	Base material	C	Mn	Si	P	S	Mo	Ti	B	N
LNS 140A (L-70)	X65	0.07	1.45	0.3	<0.025	<0.025	0.2	-	-	0.005
LNS 140TB (LA-81)	X80	0.06	1.6	0.35	<0.025	<0.025	0.2	0.015	0.002	0.004
L61		0.12	0.94	0.20	<0.025	<0.025	-	-	-	-

Remark: the chemical composition from butt welds in pipe depends on the chemical composition of base material. Proced: tandem AC/AC application on X65 plate 12.7 mm thick.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)				Hardness
					-20°C	-40°C	-50°C	-60°C	
Procedure 1									
LNS 140A (L-70)	TR	580	680	30	95	65			230
LNS 140TB (LA-81)	TR	630	700	27	115	75	50		235
Procedure 2									
LNS 140TB (LA-81)	TR	600	720	25	100	65		45	220-235
Procedure 3									
LNS 133TB	TR	520	670	24		100	40		
L61	TR	400	550	30	>47				

Remark: the mechanical properties from butt welds in pipe depends on the chemical composition of base material. Procedure 1: tandem in 12.5mm X65; Procedure 2: multiwire weld (4/5 wires) in 19-25mm X65; Procedure 3: AWS test plate

* TR = Two-Run

FLUX CHARACTERISTICS

Current type	DC/AC
Basicity (Boniszewski)	1.3
Solidification speed	Medium
Density (kg/dm³)	1.0
Grain size (EN ISO 14174)	2 -20

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
SRB BAG	25.0	111220

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.

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