

# Lincolnweld® 761-Pipe™

EN 760 – S A MS 1; EN 760 – S A CS 1 • Flux for Seam Welding of Pipe

## Recommended Wires

For Mild Steel  
Lincolnweld® L-61®

For Low Alloy Steel  
Lincolnweld® L-70

## Key Features

- ▶ Features the chemical composition of 761 with a particle size optimized for seam welding
- ▶ Low-melting slag system produces wide flat welds with superior resistance to cracks and pockmarking
- ▶ Can handle up to 5 arcs or 5,000 amps

## Product Information

Basicity Index: 0.8  
Density: 1.2 g/cm<sup>3</sup>

## Typical Applications

- ▶ Single and multiple arc welding
- ▶ Longitudinal seam welding of API grade pipe
- ▶ Spiral seam welding of API grade or water pipe

## Packaging

50 lb (22.7 kg) Plastic Bag ED032797  
2600 lb (1179 kg) Bulk Bag ED032768

## FLUX COMPOSITION<sup>(1)</sup>

	%SiO <sub>2</sub>	%Mn <sub>x</sub> O <sub>y</sub>	%MgO	%CaF <sub>2</sub>	%NaO	%Al <sub>2</sub> O <sub>3</sub>	%TiO <sub>2</sub>	%FeO	% Metal Alloys
Lincolnweld® 761-Pipe™	45	19	22	5	2	2	2	1	6 max.

## AWS TEST RESULTS<sup>(1)</sup>

Flux/Wire Combination	Weld Condition	Yield Strength <sup>(2)</sup> MPa (ksi)	Tensile Strength MPa (ksi)	Elongation (%)	Charpy V-Notch J (ft•lbf) @ °C (°F)		AWS Classification (A5.17/A5.23)
L-61®	As-welded	490 (70)	580 (85)	28	54 (40)	-29 (-20)	F7A2-EM12K-H8
L-70	As-welded	550 (80)	640 (93)	24	58 (43)	-18 (0)	F9A0-EA1-G

<sup>(1)</sup>See test results disclaimer below. <sup>(2)</sup>Measured with 0.2% offset.  
NOTE: For the most up-to-date AWS certificates of conformance please visit [www.lincolnelectric.com](http://www.lincolnelectric.com)

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at [www.lincolnelectric.com](http://www.lincolnelectric.com)

### 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.

### CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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