

Lincolnweld 888

TOP FEATURES

- Designed for deep groove slag removal in critical applications
- Low H4 diffusible hydrogen levels
- Charpy V-Notch and CTOD test results available for most alloy systems

TYPICAL APPLICATIONS

- Excellent operation with multiple arcs
- Offshore
- Structural fabrication
- Shipbuilding

CLASSIFICATION

Flux	EN ISO 14174: S A FB 1 66 AC H5	
Flux/wire	EN ISO 14171-A: MR	AWS A5.17 / A5.23
888 / L-61	S 38 5 FB S2Si	F7A6-EM12K
888 / L-50M	S 42 6 FB S3Si	F7A8/F7P8-EH12K
888 / LNS 140A	S 46 4 FB S2Mo	F8A4-EA2-A2
888 / L-70	S 46 4 FB S2Mo	F8A4-EA1-A2
888 / LNS 160	S 42 5 FB S2Ni1*	F7A8/P8-ENi1-Ni1
888 / LNS 162	S 42 6 FB S2Ni2*	F7A8/F7P8-ENi2-Ni2
888 / LNS 164	S 50 4 FB S3Ni1Mo	F9A6/F9P4-EF3-F3
888 / LNS 165	S 50 4 FB S3Ni1Mo0.2	F8A6/F7P8-ENi5-Ni5
888 / LNS 150	S 50 2 FB CrMo1	F7P4-EB2R-B2
888 / LNS 151		F8P4-EB3R-B3

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

Wire grade	C	Mn	Si	P	S	Ni	Mo	Cr
L-61	0.08	1.05	0.37	<0.02	<0.015	-	-	-
L-50M (LNS 133U)	0.07	1.45	0.55	<0.02	<0.015	-	-	-
LNS 140A (L-70)	0.07	1.0	0.35	<0.02	<0.015	-	0.4	-
LNS 160	0.07	1.2	0.4	<0.02	<0.015	0.95	-	-
LNS 162	0.07	1.1	0.4	<0.02	<0.015	2.0	-	-
LNS 164	0.08	1.7	0.5	<0.02	<0.01	0.9	0.5	-
LNS 165	0.06	1.50	0.5	<0.02	<0.015	0.97	0.2	-
LNS 150	0.07	0.90	0.5	<0.02	<0.015	-	0.55	1.35
LNS 151	0.06	0.85	0.3	<0.02	<0.015	-	0.93	2.15

- = not specified

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)			
					-20°C	-40°C	-50°C	-60°C
L-61	AW	415	515	31	-	35	100	-
L-50M (LNS 133U)	AW	480	580	29	-	-	90	60
L-50M (LNS 133U)	SR	430	550	31	-	105	-	65
LNS 160	AW	470	550	26	-	115	-	-
LNS 160	SR	410	510	27	-	160	-	120
LNS 162	AW	500	580	25	-	100	-	55
LNS 162	SR	440	550	25	-	160	-	120
LNS 164	AW	650	750	21	-	65	-	30
LNS 164	SR	610	700	23	-	65	-	30
LNS 165	AW	530	620	26	-	70	-	40
LNS 165	SR	495	595	27	-	-	-	70
LNS 150	SR	420	580	26	100	-	-	-
LNS 151	SR	530	645	23	-	45	-	-

* AW = As welded; SR = Stress relieved

FLUX CHARACTERISTICS

Current type	AC/DC
Basicity (Boniszewski)	2.3
Solidification speed	High
Grain size (EN ISO 14174)	2 - 20

AVAILABLE SIZES AND PACKAGING INFORMATION

Packaging	Weight (kg)	Item number
PAPER BAG	22.7	ED031596

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.