

839

TOP FEATURES

- Suitable for mild steel, low alloy and standard stainless steel grades
- Excellent bead finishing appearance with stainless grades
- Suitable as the one flux workshop solution

CLASSIFICATION

| | |
|------------------|---------------------------------|
| Flux | EN ISO 14174: S A FB 1 66 AC H5 |
| Flux/wire | AWS A5.17 / A5.23 |
| 839/L60 | F6A2-EL12 |
| 839/LNS135 | F6A4-EM12 |
| 839/L-61 | F7A5-EM12K / F6P6-EM12K |
| 839/L-50M | F7A6-EH12K / F7P8-EH12K |
| 839/LNS140A | F7A4-EA2-A2 |
| 839/LNS164 | F9A0-EF3-F3 / F9P4EF3-F3 |

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

| Wire grade | C | Mn | Si | P | S | Mo | Ni |
|-----------------|------|------|-----|--------|-------|------|------|
| L-60 | 0.04 | 0.85 | 0.2 | <0.01 | <0.01 | | |
| LNS 135 | 0.05 | 1.2 | 0.2 | <0.015 | <0.01 | | |
| L-61 | 0.07 | 1.2 | 0.3 | <0.015 | <0.01 | | |
| L-50M | 0.07 | 1.7 | 0.3 | <0.015 | <0.01 | | |
| LNS 140A (L-70) | 0.06 | 1.2 | 0.2 | <0.015 | <0.01 | 0.45 | |
| LNS 164 | 0.07 | 1.7 | 0.3 | <0.015 | <0.01 | 0.45 | 0.80 |

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-60 | AW | 390 | 470 | 30 | 100 | | | |
| LNS 135 | AW | 410 | 490 | | 100 | 50 | | |
| L-61 | AW | 440 | 530 | 29 | 130 | 80 | | |
| L-61 | SR | 400 | 510 | 31 | | 115 | 65 | |
| L-50M (LNS 133U) | AW | 470 | 570 | 28 | | 100 | | |
| L-50M (LNS 133U) | SR | 415 | 520 | 29 | | 140 | | 110 |
| LNS 140A (L-70) | AW | 460 | 560 | 26 | | 80 | | |
| LNS 164 | AW | 650 | 710 | 20 | 50 | | | |
| LNS 164 | SR | 590 | 670 | 24 | 100 | 65 | | |

* AW = As welded; SR = Stress relieved

FLUX CHARACTERISTICS

| | |
|-------------------------------|--------|
| Current type | DC/AC |
| Basicity (Boniszewski) | 2.4 |
| Solidification speed | Medium |
| Density (kg/dm ³) | 1.2 |
| Grain size (ISO 14174) | 2 - 20 |

PACKAGING AND AVAILABLE SIZES

| Packaging | Weight (kg) | Item number |
|-----------|-------------|-------------|
| SRB BAG | 25.0 | FX839-25 |

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.