

761 / 761-CG

CLASSIFICATION

| Flux | Flux/wire | | | |
|----------------------|--------------------------|-------------------------|-------------------------|-------------------|
| ISO 14174 | AWS A5.17 / A5.23 | ISO 14171-A : MR | ISO 14171-A : TR | |
| S A CS/MS 1 88 AC H5 | 761 / L-60 | F7A2-EL12 | S 38 2 CS/MS S1 | |
| | 761 / L-61 | F7A2-EM12K | S 42 2 CS/MS S2Si | S 4T 0 CS/MS S2Si |
| | 761 / LNS 140A | F9A0-EA2-G | S 50 0 CS/MS S2Mo | S 4T 2 CS/MS S2Mo |
| | 761 / L-70 | F9A0-EA1-G | S 50 0 CS/MS S2Mo | S 4T 2 CS/MS S2Mo |

GENERAL DESCRIPTION

- High current capacity
- Active flux for limited pass welding
- High restraint cracking resistant
- Suitable for rusty/dirty plates (at high current)
- Applicable for low quality steels
- Coarse grain flux more suitable with the most rusty and dirty plates

APPROVALS

| Wire grade | ABS | BV | CRS | DNV | PRS | GL | LRS | RINA | RMRS | TÜV |
|-----------------|-------------|-------------|---------|-------------|-------------|-------------|-------------|-------------|-------------|-----|
| L-60 | | | | | | | | | | ✓ |
| LNS 135 | | | | | | | | | | ✓ |
| L-61 | 3YM/2YT | 3YM/2YT | 3YM/2YT | 2YT | 3YM/2YT | 3YM/2YT | 3YM/2YT | 3YM/2YT | 2YT | ✓ |
| LNS 140A (L-70) | 3Y40M/3Y40T | 3Y40M/3Y40T | | 3Y40M/3Y40T | 3Y40M/2Y40T | 3Y40M/3Y40T | 3Y40M/3Y40T | 3Y40M/3Y40T | 3Y40M/3Y40T | ✓ |

CHEMICAL COMPOSITION (W%), 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 | 0.08 | 1.7 | 0.9 | <0.03 | <0.025 | |
| LNS 140A (L-70) | 0.06 | 1.7 | 0.8 | <0.03 | <0.025 | 0.4 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| Wire grade | Condition* | Yield strength (N/mm ²) | Tensile strength (N/mm ²) | Elongation (%) | Impact ISO-V(J) | |
|-----------------|------------|--|--|-------------------|-----------------|-------|
| | | | | | 0°C | -20°C |
| L-60 | MR | 380 | 500 | 28 | 80 | 50 |
| L-61 | MR | 440 | 530 | 28 | 100 | 50 |
| | TR | >420 | >540 | | 65 | |
| LNS 140A (L-70) | MR | 480 | 600 | | 80 | 40 |
| | TR | >440 | >540 | | 100 | 55 |

* MR : Multirun - TR : Two-run

761/761-CG: rev. EN 24

761 / 761-CG

MATERIALS TO BE WELDED

| Code | Type/ Steel grades | Limited passes | | |
|---|---|----------------|------|-----------------|
| | | L-60 | L-61 | LNS 140A (L-70) |
| Ship plates | | | | |
| | A to D, A (H) 32 to D(H) 36 | ✓ | ✓ | ✓ |
| General structural steel | | | | |
| EN 10025 part 6 | 500 A | | | ✓ |
| EN 10025 part 3/part 4 | S275 to S420, N,M | ✓ | ✓ | ✓ |
| EN 10149 | S315 to S420, MC | ✓ | ✓ | ✓ |
| | S315 to S420, NC | ✓ | ✓ | ✓ |
| | S460, MC & NC | | | ✓ |
| EN 10025 part 2 | S185 to S355, E295 to E360, JR(G1 & G2), J0, J2 (G3&G4) | ✓ | ✓ | ✓ |
| Boiler & pressure vessel steel | | | | |
| EN 10028 | P235 to P420, GH N, NH, M, Q & QH | ✓ | ✓ | ✓ |
| | P235 to P460, GH, N, NH, M, Q & QH | ✓ | ✓ | ✓ |
| | P500, GH, N, NH, M, Q & QH, P235 S, P265 S | ✓ | ✓ | ✓ |
| | A37 to A52, CP, AP | ✓ | ✓ | ✓ |

FLUX CHARACTERISTICS

| | |
|-------------------------------|-------------------------------|
| Current type | DC/AC |
| Basicity (Boniszewski) | 0.8 |
| Solidification speed | Low, viscous slag |
| Density (kg/dm ³) | 1.2 |
| Grain size (ISO 14174) | 761 : 1 -16 / 761-CG : 1 - 20 |

SUGGESTIONS FOR USE

| Wire | Characteristics |
|-----------------|--|
| L-60 | To prevent defects from organic components |
| L-61 | Reliable properties |
| LNS 140A (L-70) | For good impact toughness in two-run as welded |

Applications

Flat fillet, large throat
 Butt joints in two passes, in medium and thick plates
 Flux backing, modified series arc welding

PACKAGING AND AVAILABLE SIZES

| Unit | Net weight (kg) |
|------------------------|-----------------|
| Bag | 25 |
| Sahara ReadyBag™ (SRB) | 25 |
| Steel drum | 250 |
| Big Bag | 500 / 1000 |