

## CLASSIFICATION

Flux	Flux/wire		
<b>ISO 14174</b>	<b>AWS A5.17 / A5.23</b>	<b>ISO 14171-A : MR</b>	
S A FB 1 66 AC H5	<b>888 / L-61</b>	F7A6-EM12K	S 38 5 FB S2Si
	<b>888 / L-50M (LNS 133U)</b>	F7A8/F6P8-EH12K	S 42 6 FB S3Si
	<b>888 / LNS 140A</b>	F8A4-EA2-A2	S 46 4 FB S2Mo
	<b>888 / L-70</b>	F8A4-EA1-A2	S 46 4 FB S2Mo
	<b>888 / LNS 160</b>	F7A8/P8-ENi1-Ni1	S 42 5 FB S2Ni1*
	<b>888 / LNS 162</b>	F7A8/F7P8-ENi2-Ni2	S 42 6 FB S2Ni2*
	<b>888 / LNS 164</b>	F9A6/F9P4-EF3-F3	S 50 4 FB S3Ni1Mo
	<b>888 / LNS 165</b>	F8A6/F7P8-ENi5-Ni5	S 50 4 FB Sz
	<b>888 / LNS 150</b>	F7P6-EB2-B2	S 50 2 FB CrMo1
	<b>888 / LNS 151</b>	F8P6-EB3-B3	
	<b>888 / LA-100</b>	F10A4-EM2-M2	S 50 4 FB SZ

## GENERAL DESCRIPTION

Basic flux designed for carbon and low alloy steels  
 Easy slag removal in deep groove  
 Robust mechanical properties including CTOD values  
 Bruscato factor typically below 12 ppm with LNS150 & LNS151 wires  
 Excellent in multi arc configurations  
 Only available in Sahara ReadyBag™

## APPROVALS

Wire grade	TÜV
L-61	✓

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Wire grade	C	Mn	Si	P	S	Ni	Mo	Cr	Bruscato factor
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	2.1			
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	0.069	0.90	0.5	<0.02	<0.015		0.56	1.34	<10 ppm
LNS 151	0.062	0.85	0.3	<0.02	<0.015		0.93	2.15	<10 ppm
LA-100	0.06	1.60	0.7	<0.02	<0.015	1.8	0.42	0.08	

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)			
					-20°C	-40°C	-50°C	-60°C
L-61	AW	415	515	31		135	100	
L-50M (LNS 133U)	AW	480	580	29			90	70
	SR	430	550	31		105		65
LNS 160	AW	470	550	26		115		
	SR	410	510	27		160		120
LNS 162	AW	500	580	25		100		55
	SR	440	550	25		160		120
LNS 164	AW	650	750	21		65		30
	SR	610	700	23		65		30
LNS 165	AW	530	620	26		70		40
	SR	495	595	27				70
LNS 150	SR	420	580	26	100			
LNS 151	SR	530	645	23				
LA-100	AW	680	760	25		50		

888: rev. EN 26

\* AW : As welded - SR : Stress relieved

888

## MATERIALS TO BE WELDED

Steel grades/Code	Type	Multirun													
		L-61	L-50M (LNS 133U)			L-70	LNS 164		LNS 165	LNS 150	LNS 151	LNS 160		LNS 162	LA 100
		AW -50°C	AW -60°C	SR-60°C	AW	AW-40°C	AW-40°C	SR-60°C	SR-50°C	SR-50°C	AW	SR	AW	SR	AW-40°C
<b>Ship plates</b>															
	A to E	✓	✓	✓											
	AH(32),DH(36), EH(36)	✓	✓	✓			✓		✓			✓	✓	✓	✓
<b>General structural steel</b>															
EN 10025 part 2	S185, S235, S275	✓	✓	✓											
	S355	✓	✓	✓		✓		✓	✓			✓	✓	✓	✓
<b>Cast steel</b>															
EN 10213-2	GP240R	✓	✓	✓											
<b>Pipe materials</b>															
EN 10208-2	L210, L240, L290	✓	✓	✓											
	L360	✓	✓	✓		✓		✓	✓			✓	✓	✓	✓
	L415		✓			✓		✓	✓						
	L445, L480					✓		✓	✓						
EN 10216-1/10217-1	P235, P275	✓	✓	✓											
	P355	✓	✓	✓		✓		✓	✓			✓	✓	✓	✓
<b>Boiler &amp; pressure vessel steel</b>															
EN 10028-1	P235GH, P265GH, 295GH	✓	✓	✓											
EN 10028-2	16 Mo 3					✓									
(High temperature steel)	13CrMo 4-5								✓	✓					
	10CrMo 9-10								✓	✓					
EN 10028-4/10222-3	11MnNi3, 13MnNi6-3							✓	✓			✓	✓	✓	✓
(Low temperature steel)															
<b>Fine grained steels</b>															
EN 10025 part 3/part 4	S275	✓	✓	✓											
	S355	✓	✓	✓		✓		✓	✓			✓	✓	✓	✓
	S420		✓			✓		✓	✓				✓	✓	
	S460					✓		✓	✓						
<b>High yield strength steels</b>															
EN 10025 part 6	S460, S500					✓		✓	✓			✓	✓	✓	✓

## FLUX CHARACTERISTICS

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

## SUGGESTIONS FOR USE

Boiler and pressure vessels  
Off-shore applications  
Wind towers  
Structural fabrications

## PACKAGING AND AVAILABLE SIZES

Unit	Net weight (kg)
Sahara ReadyBag™ (SRB)	25