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CLASSIFICATION

Flux		Flux/wire	
ISO 14174		**AWS A5.17 / A5.23**	**ISO 14171-A : MR**
S A FB 1 55 AC H5	**P240 / L-61 (LNS129)**	F7A6-EM12K	S 42 4 FB S2Si
	P240 / L-50M (LNS133U)	F7A8/P8-EH12K	S 46 6 FB S3Si
	P240 / LNS 160	F7A10/P10-ENi1-Ni1	S 46 6 FB S2Ni1*
	P240 / LNS 162	F7A10/P10-ENi2-Ni2	S 46 6 FB S2Ni2*
	P240 / LNS 165 (LA-85)	F8A8/P8-ENi5-Ni5	S 50 6 FB Sz
	P240 / LNS 150 (LA-92)	F8P2-EB2-B2R	
	P240 / LNS 151 (LA-93)	F9P0-EB3-B3R	
	P240 / LNS 168	F10A5-EM2-M2	S 69 4 FB S3NiCr2.5Mo

GENERAL DESCRIPTION

Highly basic fluoride agglomerated flux
Good impact values suitable for offshore constructions
Consistently good CTOD values with CMn and Ni-alloyed wires
Low hydrogen content
Suitable for single/multi wire welding

APPROVALS

Wire grade	BV	ABS	LRS	DNV	CRS	TÜV
L-50M (LNS 133U)	A5YM	5YM	5YM	5YM	5YM	✔
LNS 162						✔
LNS 160						✔
LNS 164						✔
LNS 165		5Y46M	5Y46M	5Y46M		
LNS 168			4Y69			

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

Wire grade	C	Mn	Si	P	S	Mo	Ni	Cr
L-61	0.08	1.0	0.35	< 0.010	< 0.010			
L-50M (LNS 133U)	0.08	1.6	0.35	< 0.020	< 0.015			
LNS 160	0.08	1.0	0.25	< 0.020	< 0.015		1.0	
LNS 162	0.08	1.01.3	0.25	< 0.020	< 0.015		2.2	
LNS 165	0.08	1.2	0.35	< 0.020	< 0.015	0.15	0.9	
LNS 150	0.08	0.7	0.3	< 0.015	< 0.010	0.5		1.1
LNS 151	0.10	1.5	0.3	< 0.015	< 0.010	1.0		2.5
LNS 168	0.08		0.4	< 0.015	< 0.015	0.4	2.4	0.3

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) -20°C	-40°C	-50°C	-60°C
L-61	AW	440	530	30	115	75		
L-50M (LNS 133U)	AW	460	560	28				40
	SR	420	540	28				40
LNS 160	AW	470	550	28				80
	SR	430	490	32				100
LNS 162	AW	480	560	26				100
	SR	460	530	30				140
LNS 165	AW	520	600	25				60
	SR	510	580	24				60
LNS 150	SR	520	610	24				100
LNS 151	SR	550	640	24				50
LNS 168	AW	720	800	20			55	

AW : As welded - SR : Stress relieved

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EXAMPLES OF MATERIALS TO BE WELDED

Code	Type / Steel grades	Multi-run					
		L-50M (LNS 133U)	LNS 160	LNS 162	LNS 165	LNS 150	LNS 151
Ship plates							
	A to E	✔	✔	✔	✔		
	AH32 to EH40	✔	✔	✔	✔		
General structural steels							
EN 10025 part 6 (A 36-204)	500 A & AL				✔		
EN 10025 part 3/part 4	S275 to S460 all qualities	✔	✔	✔	✔		
EN 10149 (A36-231)	S315 & S355 MC & NC	✔	✔	✔	✔		
	S315 to S500 MC & NC				✔		
EN 10025 part 2	S185 to E360 all qualities	✔	✔	✔	✔		
Boiler & pressure vessel steels							
EN 10028 (A 36-205)	P235 to P460 all qualities	✔	✔	✔	✔		
EN 10207 (A36-220)	P235 to P275 all qualities	✔	✔	✔	✔		
A36-601 & NF A36-605	A37 to A52 all qualities	✔	✔	✔	✔		
EN 10028-2	13CrMo 4-5					✔	✔
(Elevated temperature steel)	10CrMo 9-10					✔	✔
Steel for dangerous material transportation							
A 36-215	P265 to P460 all qualities	✔	✔	✔	✔		
Low temperature steels							
A 36-215	P285 to P420 all qualities	✔	✔	✔	✔		

FLUX CHARACTERISTICS

Current type	DC / AC
Basicity (Boniszewski)	3.0
Density (kg/dm³)	1.1
Grain size (ISO 14174)	2 -20

SUGGESTIONS FOR USE

Boiler and pressure vessels
Off-shore applications
Nuclear components
Low temperature applications
Highly restraint constructions

PACKAGING AND AVAILABLE SIZES

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