

## CLASSIFICATION

Flux	Flux/wire		
<b>ISO 14174</b> S A AB 1 66 AC H5		<b>AWS A5.17 / A5.23</b>	<b>ISO 14171-A : MR</b>
	<b>961 / L-61</b>	F 7 A 2 EM12K	S 42 2 AB S2Si
	<b>961 / L50M (LNS133 U)</b>	F 7 A 2 EH12K	S 46 2 AB S3Si
	<b>961 / LNS 140A</b>	F 7 A2 EA2	S 46 2 AB S2Mo
	<b>961 / LNS 135</b>	F 6 A2 EM12	S 35 2 AB S2
	<b>961 / L60</b>	F 6 A2 EL12	S 35 2 AB S1

## GENERAL DESCRIPTION

**961 is dedicated to the steel structure manufacturing and more specifically on fillet weld with high current and multiple arcs.**

**Wetting as well as his good resistance to the surface conditions makes it very effective on the general pupose steel structure workshop.**

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

Wire grade	C	Mn	Si	P	S	Mo
L61	0.044	1.2	0.41	0.019	0.008	0,02
L50M	0.048	1.7	0.58	0.019	0.005	0,009
LNS 135	0.052	1.3	0.38	0.02	0.004	0.008
LNS 140A	0.045	1.3	0.42	0.02	0.007	0.42
L60	0.031	1	0.032	0.02	0.006	0.008

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Impact ISO-V(J)
				-20°C
L61	MR	436	517	52
L50M	MR	474	553	73
LNS 135	MR	405	487	53
LNS 140A	MR	503	574	62
L60	MR	389	472	114

\* MR:Multirun

961: rev. C - EN01-26/01/16

## 961

## EXAMPLES OF MATERIALS TO BE WELDED

Code	Type / Steel grades	Multirun		Two-run	
		L61	L50M (LNS 133U)	L61	L50M (LNS 133U)
<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		✓		✓
API 5LX	X42, X46	✓	✓	✓	✓
	X52	✓	✓	✓	✓
	X56, X60		✓		✓
EN 10216-1/10217-1	P235, P275	✓	✓	✓	✓
	P355	✓	✓	✓	✓
<b>Boiler &amp; pressure vessel steel</b>					
EN 10028-1	P235GH, P265GH, P295GH	✓	✓	✓	✓
	P355GH	✓	✓	✓	✓
<b>Fine grained steels</b>					
EN 10025 part 3/4	S275	✓	✓	✓	✓
	S355	✓	✓	✓	✓
	S420		✓		✓

## FLUX CHARACTERISTICS

Current type	AC
Basicity (Boniszewski)	0.9
Solidification speed	medium
Density (kg/dm <sup>3</sup> )	-
Grain size (ISO 14174)	-

## SUGGESTIONS FOR USE

Wire	Characteristics
L61	General purpose
L50M(LNS 133U)	For dirty plates

**Applications**

Butt welds (single pass and multi-run)  
Fillet welds

## PACKAGING AND AVAILABLE SIZES

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