AS 461

TOP FEATURES

- Moderate silicon and manganese pick-up flux
- Compatible with a wide range of applications
- Suitable for one side welding as well

CLASSIFICATION

Flux	EN ISO 14174: S A AB 1 67 AC H5

Flux/wire	AWS 5.17	AWS 5.23	EN 14171-A
AS 26	F6A2/F6P2-EL12		S 35 2 AB S1
AS 35	F7A2-EM12K		S 42 3 AB S2
AS 40A		F8A3/F8P2-EA2-A2	S 46 2 AB S2Mo
AS 67		F8A4-ENi6-Ni6	S 50 4 AB S3Ni1Mo0,2
AS 37LN	F7A6/F7P6-EH12K		S 42 4 AB S3Si

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

Wire grade	C	Mn	Si	Mo	Ni
AS 26	0.05	1.0	0.4		
AS 35	0.05	1.5	0.6		
AS 40A	0.07	1.5	0.6	0.5	
AS 37LN	0.07	1.7	0.7		
AS 67	0.09	1.5	0.3	0.2	0.95

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)			
					-20°C	-30°C	-40°C	-50°C
AS 26	AW	≥355	440-550	≥24	≥ 40	≥ 27		
AS 26	PWHT 620°C/1h	≥330	420-550	≥22	≥ 60	≥ 27		
AS 35	AW	≥420	510-640	≥24	≥ 100	≥ 60	≥ 27	
AS 35	PWHT 620°C/1h	≥400	490-650	≥22	≥ 100	≥ 60	≥ 47	
AS 37LN	AW	≥440	530-650	≥22	≥ 90		≥ 70	≥ 27
AS 37LN	PWHT 620°C/1h	≥420	560-690	≥20	≥ 90		≥ 60	≥ 27
AS40A	AW	≥500	560-680	≥22	≥ 100	≥ 27		
AS40A	PWHT 620°C/1h	≥480	560-690	≥20	≥ 90	≥ 27		
AS 67	AW	≥ 500	590-660	≥ 22			≥ 50	

*AW = As welded; PWHT = Post weld heat treatment

FLUX CHARACTERISTICS

Current type	AC, DC+
Basicity (Boniszewski)	1.3
Redrying	300-350°C x 2h

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
BAG	25.0	W000280307

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.