AS 461Si

TOP FEATURES

- High silicon pick-up flux
- Smooth bead surface
- Suitable for one side welding as well

CLASSIFICATION

Flux	EN ISO 14174: S A AB 1 87 AC H5

Flux/wire	AWS A5.17	AWS A5.23
AS 26	F6A2/F6P2-EL12	
AS 35	F7A4/F7P4-EM12K	
AS 37LN	F7A6/F7P6-EH12K	
AS 40A		F8A2/F8P2-EA2 A2

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

Wire grade	C	Mn	Si	Mo
AS 26	0.05	1.0	0.4	-
AS 35	0.06	1.5	0.7	-
AS 37LN	0.07	1.7	0.7	-
AS 40A	0.05	1.6	0.7	0.5

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		
	620°Cx1h	≥330	420-550	≥22	≥60	≥27		
AS 35	AW	≥420	510-640	≥22	≥100	≥50	≥27	
	620°Cx1h	≥400	490-650	≥22	≥110	≥60	≥40	
AS 37LN	AW	≥440	530-650	≥22	≥90		≥50	≥27
	620°Cx1h	≥420	510-650	≥22	≥90		≥50	≥27
AS 40A	AW	≥490	570-680	≥20	≥50	≥27		
	620°Cx1h	≥480	560-690	≥20	≥50	≥27		

* AW = As welded

FLUX CHARACTERISTICS

Current type	AC, DC+
Basicity (Boniszewski)	1.3
Grain size (EN ISO 14174)	2-16
Redrying	300-350°Cx2h

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
BAG	25.0	W000280309

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.