960

TOP FEATURES

- Versatile flux
- High current carrying capacity
- For both single -run and multi-run techniques with moderate weld metal properties requirements
- Also available in coarse grain version

CLASSIFICATION

Flux	EN ISO 14174: S A AB 1 66 AC H5

Flux/wire	EN ISO 14171-A: MR	EN ISO 14171-A: TR	AWS A5.17 / A5.23
960 / L-61	S 38 2 AB S2Si	S 3T 2 AB S2Si	F7A2-EM12K
960 / L-50M	S 38 2 AB S3Si	S 3T 2 AB S3Si	F7A2-EH12K
960 / LNS 163	S 42 4 AB S2Ni1Cu		F7A4-EG-G

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

Wire grade	C	Mn	Si	P	S	Cu	Ni
L-61	0.07	1.3	0.4	<0.03	<0.025		
L-50M (LNS 133U)	0.07	1.6	0.6	<0.03	<0.025		
960 / LNS 163	0.06	1.4	0.35	<0.03	<0.025	0.4	0.6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-20°C	-40°C
L-61	AW	420	510	28	50	
L-50M (LNS 133U)	AW	440	530	28	70	
LNS 163	AW	460	540	27		55

* AW = As welded

FLUX CHARACTERISTICS

Current type	DC/AC
Basicity (Boniszewski)	1.0
Solidification speed	High
Density (kg/dm³)	1.4
Grain size (ISO 14174)	2-20

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
BIG BAG	1000.0	FX960-1T
DRUM	250.0	111835
PE BAG	25.0	111996, FX960-25
SRB BAG	25.0	FX960-25SRB

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.