

708GB

CLASSIFICATION

Flux	Flux/wire		
ISO 14174		AWS A5.23	ISO 14171-A
S A AR 1 99 AC H10	708GB / L-60	F7A0 - EL12	S 42 0 AR S1
	708GB / L-61	F7A0 - EM12K	S 42 0 AR S2Si

GENERAL DESCRIPTION

Agglomerated flux for submerged arc welding, with Mn and Si additions
 Excellent weldability, slag removal, resistance to porosity and cracks, and very good appearance of weld bead.
 It is a good choice for square edge welding joints, fillet welds and lap welds.
 Recommended for limited amount of passes.

CHEMICAL COMPOSITION (W%), ALL WELD METAL

Wire grade	C	Mn	Si	P	S
L-60	0.08	1.4	0.75	0.023	0.02
L-61	0.09	1.6	0.90	0.023	0.02

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
					-18°C
L-60	MR	470	570	33	30
L-61	MR	570	645	30	50

APPLICATION

It is typically used for welding gas bottles, truck wheels, structural shapes, joining plates, pieces of small diameter.

EXAMPLES OF MATERIALS TO BE WELDED

Code	Type / Steel grades	Limited passes
		L-61
Gas cylinders		
EN 10120	P245NB	✓
	P265NB	✓
	P310NB	✓
	P355NB	✓

FLUX CHARACTERISTICS

Current type	DC (+/-)/AC
Basicity (Boniszewski)	0.65
Density (kg/dm ³)	1.3
Grain size (ISO 14174)	2 - 20

PACKAGING AND AVAILABLE SIZES

Unit	Net weight (kg)
Bag	25

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