

8500

CLASSIFICATION

Flux	Flux/wire			
ISO 14174		AWS A5.17 / A5.23	ISO 14171-A : MR	ISO 14171-A : TR
S A FB 1 54 AC H5	8500 / L-61	F7A6/F6P8-EM12K	S 38 4 FB S2Si	S 4T 0 FB S2Si
	8500 / L-50M (LNS 133U)	F7A6/F7P8-EH12K	S 42 6 FB S3Si	S 4T 2 FB S3Si
	8500 / LNS 140A	F8A6-EA2-A2	S 46 4 FB S2Mo	
	8500 / LNS 160	F7A8/P8-ENi1-Ni1	S 42 5 FB S2Ni1*	
	8500 / LNS 162	F7A8/P8-ENi2-Ni2	S 42 6 FB S2Ni2*	
	8500 / LNS 165 (LA85)	F8A8/F7P8-ENi5-Ni5	S 50 6 FB SZ	
	8500 / LNS T55		S 50 5 FB TZ	

* Nearest classification

GENERAL DESCRIPTION

Basic flux designed for carbon and low alloy steels

Excellent welding characteristics over a wide range of welding procedures

Superior mechanical properties

Impact properties are consistent throughout the weld joint, including the cap location

Excellent CTOD values

APPROVALS

Wire grade	BV	ABS	LRS	DNV	GL	RMRS
L-61					3YM/2YT	
L-50M (LNS 133U)	A3YT/A5YM	3YT/5YM	5Y40M/3Y40T	5Y40M/3Y40T		
LNS 140A (L-70)		3YM			3Y40M/4Y40T	3YM/4YT

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

Wire grade	C	Mn	Si	P	S	Mo	Ni
L-61	0.08	1.0	0.2	<0.02	<0.015		
L-50M (LNS 133U)	0.07	1.4	0.3	<0.02	<0.015		
LNS 140A (L-70)	0.08	0.9	0.2	0.03	<0.025	0.4	
LNS 160	0.07	1.0	0.1	0.02	0.015		1.0
LNS 162	0.08	1.0	0.1	0.02	0.015		2.0
LNS 165 (LA 85)	0.07	1.3	0.2	0.02	0.015	0.2	0.9
LNS T55	0.08	1.7	0.7	<0.015	<0.015		

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)		
					-20°C	-40°C	-60°C
L-61	MR	430	510	28	150	100	50
L-50M (LNS 133U)	MR	440	540	28		110	
	SR	>420	>500	30		150	
	MR	440	540	28		55	
LNS 140A (L-70)	MR	440	540	28		150	
	AW	430	510	30		150	50
LNS 160	SR	400	510	30		150	50
	AW	470	560			150	50
	SR	450	530			150	50
LNS 162	AW	530	600	25		120	50
	SR	480	580	30		120	50
LNS 165 (LA 85)	AW	530	620		120	80	
	SR	500	570			70	

* MR : Multirun - TR : Two-run - AW : As welded - SR : Stress relieved

8500: rev. C-EN24-01/02/16

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.

Fumes: Material Safety Data Sheets (MSDS) are available on our website.

8500

EXAMPLES OF MATERIALS TO BE WELDED

Code	Type / Steel grades	Multirun														
		L-61		L-50M (LNS 133U)			LNS 140A (L-70)		LNS 160		LNS 162		LNS 165		LNS T55	
		AW	AW	SR	AW	SR	AW	SR	AW	SR	AW	SR	AW	SR		
Ship plates																
	A to E	✓	✓	✓										✓	✓	
	AH(32),DH(36), EH(36)	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
General structural steels																
EN 10025 part 2	S185, S235, S275	✓	✓	✓										✓	✓	
	S355	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
Cast steels																
EN 10213-2	GP240R	✓	✓	✓										✓	✓	
Pipe materials																
EN 10208-2	L210, L240, L290	✓	✓	✓										✓	✓	
	L360	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	L415		✓		✓	✓						✓	✓	✓	✓	
	L445, L480												✓	✓		
API 5LX	X42, X46	✓	✓	✓												
	X52	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	X56, X60		✓		✓	✓						✓	✓	✓	✓	
	X65, X70											✓	✓			
EN 10216-1/10217-1	P235, P275	✓	✓	✓										✓	✓	
	P355	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
Boiler & pressure vessel steels																
EN 10028-1	P235GH, P265GH, P295GH	✓	✓	✓	✓	✓										
Fine grained steels																
EN 10025 part 3/4	S275	✓	✓	✓										✓	✓	
	S355	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
	S420		✓		✓	✓						✓	✓	✓	✓	
	S460												✓	✓		

FLUX CHARACTERISTICS

Current type	DC/AC
Basicity (Boniszewski)	2.8
Solidification speed	Medium
Density (kg/dm ³)	1.3
Grain size (ISO 14174)	2 - 20

SUGGESTIONS FOR USE

Suitable for deep groove	Single and multi-wire systems
Low temperatures requirements	Off-shore and on-shore applications
Highly restrained constructions	Nuclear components

PACKAGING AND AVAILABLE SIZES

Unit Net weight (kg)

Bag	25
Sahara ReadyBag™ (SRB)	25
Metal drum	250