

P223

CLASSIFICATION

Flux	Flux/wire		
ISO 14174		AWS A5.17 / A5.23	ISO 14171-A : TR
S A AB 1 67 AC H5	P223 / L-61	F7A4-EM12K	S 4T 2 AB S2Si
	P223 / L-50M [LNS 133U]	F7A5-EH12K	S 4T 2 AB S3Si
	P223 / LNS 140A	F8A4-EA2-A2	S 4T 4 AB S2Mo
	P223 / LNS 133TB	F8TA4-G-EG	

GENERAL DESCRIPTION

Aluminate basic agglomerated flux

Good impact values in two-run and multi-run technique

Low hydrogen content

Very suitable for longitudinal and spiral pipe welding

Usable up to 3 wire systems

Fine grain version available for the thinnest wall and fastest welding speed

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

Wire grade	C	Mn	Si	P	S	Mo	Ni
L-61	0.08	1.4	0.2	<0.02	<0.015		
L-50M [LNS 133U]	0.07	1.7	0.3	<0.02	<0.015		
LNS 140A [L-70]	0.08	1.4	0.2	0.03	<0.025	0.4	
LNS 160	0.07	1.3	0.25	0.02	0.015		1.0
LNS 162	0.08	1.3	0.25	0.02	0.015		2.0
LNS 165 [LA-85]	0.07	1.5	0.3	0.02	0.015	0.2	0.9
LNS T55	0.08	1.7	0.7	<0.015	<0.015		

Remark: the chemical composition from butt welds in pipe depends on the chemical composition of base material.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength [N/mm ²]	Tensile strength [N/mm ²]	Impact ISO-V(J)	
				-20°C	-40°C
L-61	TR	450	550	60	
L-50M [LNS 133U]	TR	470	570	80	
LNS 140A [L-70]	TR	500	600		50
LNS 133TB	TR	510	610		60

* TR : Two-run

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EXAMPLES OF MATERIALS TO BE WELDED

Code	Type / Steel grades	Two-run	
		LNS 140A (L-70)	LNS 133TB
General structural steels			
EN 10025 part 6	500A	✓	✓
EN 10025 part 3/part 4	S275 to 460 N, NL	✓	✓
EN 10149	S315 to S500MC & NC	✓	✓
EN 10025 part 2	S185, S235, S275, S355	✓	✓
Pipe material			
API 5LX	X 42 to X70	✓	✓
Boiler & pressure vessel steels			
EN 10028-1	P235 to P460 all qualities	✓	✓
EN 10207	P235 to P275 S & SL	✓	✓
A36-601 & NF A36-605	A37 to A52 CP, AP & F	✓	✓
EN 10222	P285 & P420 all qualities	✓	✓
Offshore plates			
A36-212	PF 24 to PF 36 all qualities	✓	✓

FLUX CHARACTERISTICS

Current type	DC / AC
Basicity (Boniszewski)	1.6
Solidification speed	High
Density (kg/dm ³)	1.2
Grain size (ISO 14174)	2 -20

SUGGESTIONS FOR USE

Single/ multi wire welding
 Longitudinal and spiral pipe welding.

PACKAGING AND AVAILABLE SIZES

Unit	Net weight (kg)
Bag	25
Sahara ReadyBag™ (SRB)	25
Big Bag	500
Big Bag	600
Big Bag	100