Lincolnweld® 860

Key Features

- Industry standard for submerged arc welding applications
- Excellent operating characteristics in a variety of general welding applications
- Capable of producing weld deposits with impact toughness exceeding 27J @ -40°C with Lincolnweld® L-61

Typical Applications

- Pipe and double ending applications
- General purpose structural and multiple pass welds
- Storage tanks

Conformances

AS/NZS ISO 14174: SA AB 1 56 AC H5

Product Information

Basicity Index: 1.1

Density: 1.4 g/cm^3

Recommended Wires

Mild Steel:

Lincolnweld® L-50, L-56, L-60, L-61, LA-71, L-S3

Low Alloy:

Lincolnweld® L-70, LA-85

Packaging

Package Type	Weight Kg	Part Number
Steel Drum	25	FX860-25
Steel Drum	250	111828

Typical Flux Composition

	%SiO_2	%MnO	%MgO	%CaF_2	%Na_2O	%Al_2O_3	%TiO_2	%CaO	% Metal Alloys
Lincolnweld® 860	19	11	17	12	2	32	2	2	3 max

Typical Test Results

Flux / Wire Combination	Weld Condition	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ °C		AWS Classification A5.17/A5.23
L-50	As Welded	430	520	30	84	-29	F2A2-EM13K-H8
L-56	As Welded	470	590	28	61	-29	F7A2-EH11K
L-60	As Welded	370	450	34	138	-29	F6A2-EL12-H8
L-61	As Welded	410	500	31	58	-40	F7A4-EM12K-H8
L-61	Stress Relieved	340	440	37	222	-46	F6P5-EM12K-H8
L-S3	As Welded	500	590	28	52	-29	F7A2-EH12K
LA-71	As Welded	450	540	30	110	-29	F7A2-EM14K-H8
LA-71	Stress Relieved	400	520	32	119	-29	F7P2-EM14K-H8
LA-85	As Welded	520	600	26	38	-40	E8A4-ENi5-Ni5-H8