

SUBMERGED ARC FLUX – ACTIVE

## Lincolnweld® 761

### Key Features

- Manganese alloying and carbon reducing flux designed to provide superior crack resistance
- Slow freezing slag for a wide, flat weld
- Excellent resistance to cracking in single pass applications
- Available in moisture proof Sahara Ready Bag (SRB) and Steel Drums

### Typical Applications

- Single pass welding of mild steel
- Large fillets with constant current power sources
- Suitable for spiral pipe mills

### Conformances

AS/NZS ISO 14174: SA CS/MS 1 88 AC H5

### Product Information

Basicity Index: 0.8  
Density: 1.2 g/cm<sup>3</sup>

### Recommended Wires

#### Mild Steel:

Lincolnweld® L-50, L-60, L-61

#### Low Alloy:

Lincolnweld® L-70

### Packaging

Package Type	Weight Kg	Part Number
Plastic Bag	25	FX761-25
SRB	25	FX761-25-C-SRB
Steel Drum	250	111842

### Typical Flux Composition

	%SiO <sub>2</sub>	%MnO	%MgO	%CaF <sub>2</sub>	%Na <sub>2</sub> O	%Al <sub>2</sub> O <sub>3</sub>	%TiO <sub>2</sub>	%FeO	% Metal Alloys
Lincolnweld® 761	45	19	22	5	2	2	2	1	6 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	480	590	29	45	-29	F7A2-EM13K-H8
L-60	As Welded	440	530	29	64	-29	F7A2-EL12
L-61	As Welded	480	590	28	54	-29	F7A2-EM12K-H8
L-70	As Welded	550	640	24	58	-18	F9A0-EA1-G