

SUBMERGED ARC FLUX – ACTIVE

## Lincolnweld® 781

### Key Features

- Features fast follow characteristics that allow for uniform welds at high speeds without undercut or voids
- Recommended for high speed, limited pass welding on clean plate and sheet steel
- Good wetting action

### Typical Applications

- Single pass welding of mild steel
- Roundabouts with minimal spillage
- Horizontal position welding
- Hot water tanks

### Conformances

AS/NZS ISO 14174: SA ZS 187 AC H5

### Product Information

Basicity Index: 0.8  
Density: 1.5g/cm<sup>3</sup>

### Recommended Wires

#### Mild Steel:

Lincolnweld® L-50, L-60, L-61

#### Low Alloy Steel:

Lincolnweld® L-70

### Packaging

Package Type	Weight Kg	Part Number
Plastic Bag	25	FX781-25

### 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>	% CaO	% ZrO <sub>2</sub>	% Metal Alloys
Lincolnweld® 781	21	17	14	5	2	4	12	1	21	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	530	610	29	38	-18	F7A0-EM13K
L-60	As Welded	460	550	29	42	-18	F7A0-EL12
L-61	As Welded	530	610	28	31	-18	F7A0-EM12K
L-70	As Welded	590	660	25	35	-18	F9A0-EA1-G