



# LSF38 x LSW-EM12K

LINKWELD ALLOYS INC.

AWS A5.17 F7A2-EM12K  
JIS Z3183 S502-H

### Characteristics:

LSF-38 is an active flux. It is designed for butt or fillet welding on sheet metal with nice bead appearance, porosity resistance and good slag removal. It is recommended for single pass welding steel plate under 25 mm thick.

### Applications:

Typical applications include pressure vessels, H beam, pipe-mill application, shipbuilding and general steel structure.

### Notes on Usage:

1. Dry the flux at 350°C for 60 minutes before use.
2. Not recommended to welding more than two passes.

### Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.09	1.33	0.6	0.015	0.010

### Typical mechanical properties of weld metal

YP N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL%	IV -30°C J
415	525	31	46

### Sizes available, Package:

Wire: Diameter (mm)	2.4	3.2	4.0
Wire: Weight per roll (kg)	25	25	25
Flux: Weight per bag(kg)	25	25	25